S.V. 246, ~~247~~ C.V. MAY 07 1981 D.V. ✓

CG 04 CODE KO-786-D PKG PROCESSES APPROVED BY

EST'D WGT 862 LBS MAY -0·81-Z1311 ( ) KO-786-D (P) FWP 01/16/81

STANDARD HRS. 10.5 TIME M 9 ( ) ( )

( ) ( )

COMTYP JOBNAME: 04KO786DMP

CG	CODE	PQ	LOT	LBS
01	YC010B	98	37757	300
01	YC010B	98	39772	1400
~~01~~	~~YC010B~~	~~98~~	~~34775~~	~~862~~
01	YC010B	93	D1095	2600

Impact Valve Replaced

TOTAL EST'D WGT ~~4962~~ 5162 REQ. NO. (10718) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2	WEIGH IN DRUM AND POUR IN	270	32-D	270
	3	DUMP IN AND STIR 5 MIN LOT 86	~~92~~X50	YC10B	~~4400~~ 4300
		RECORD: START 10:30am 37757	300		
1		FIN 12:30pm 39772	1400		
		D1095	2600		
	4	ADJUST TO 75° (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208			
	6	WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208			
	7	RECORD: V-208 VOL. 41 " & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 15" (771 G) WATER INTO V-246, START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1:30pm TOTAL MINUTES 150			
2		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	11	WHEN V-208 MT, RUN IN 5"(240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384	12	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	14	WEIGH INTO V-384 & PUMP TO V-349	2400	32-D	2400
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.029 G/ML (1.078-1.081)			
SV	~~18~~	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	~~19~~	RECORD: PH 10.5 & ADJ TO 10.4-10.8 USING N-7-D			
4		DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	____	7-D	____
		SIPHON N-7-D INTO SV & RECORD: PH ____			
	20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 185 °F			
		& RECORD: 198 °F			

EQUIP		PAGE 2 CG 04 KO-786-D EST WGT 4962# V-246	USE LBS	N-CODE	USE LBS
	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M 14, 10.9 #/GAL 32.5 GAL		27-D	355
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.018 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
SV		AT 190-194*F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 3:30 AM 7:30 A 240			
		V-349 2 AM 6:35 A 285			
		TIME V-343 V-349 SV NORMAL			
		3:30 INCHES 54 INCHES 22 PH PH			
SAMPLE AFTER N-32		AT 20 MIN 3:50 (47) 45+ (20) — 9.2 (9.3-10.0)			
		40 MIN 4:10 (43) 45+ (17) + 9.2 (9.3-10.0)			
		1 HR 4:30 (38) 40 (15) + 9.2 (9.3-10.0)			
		2 HR 5:30 (24) 36 (7) 8 9.2 (9.3-10.0)			
		3 HR 6:30 (10) 7 (0) — 9.1 (9.3-10.0)			
		FINISH 7:15 (0) — 8.5 (7.5-8.5)			
		NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP PUMPS & SEE SUPV. IF FINAL PH IS ABOVE 8.5, ADJ TO 7.5-8.5 & RECORD: ____PH			
		ASSUME 77%		27-D	
385	30	RUN 40" (308 G) WATER INTO V-385 & HEAT TO			
7		135-140*F			
	31	DUMP IN & STIR TO DISSOLVE	300	15-A	300
302	32	ADD 42" (514 G) WATER TO V-302			
8	33	ADD & STIR 2 MIN	150	7-D	75
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	36	TURN OFF STEAM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.7 (3.3-3.7) & IF NECESSARY ADJ			
		(DOWN ONLY) TO 3.3-3.7 & RECORD: PH ___		15-A	
		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140 *F IN DRUM , USE 30 GAL WATER TO 50# N-15-A. STIR SV 5 MIN AFTER EACH ADDITION			
	39	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	40	RECORD: PH 4.1 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH ___	ASSUME 77%	27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER	ASSUME 50%	7-D	
	41	SIPHON N-7-D INTO SV			
		STOP AGITATOR			

START	FINISH	OPERATOR
3:00 PM	11:00 PM	400-403
4:00 P	7:00 AM	235-244
4:00 A.M	8:00 A.M	381-323

DUP050096650