

246, (247)

C.V.

D.V.

PL 04 CODE K0-789-D PKG.

JAN 15 33827

WGT 509 1132 LBS.

S.S. 10.8

TIME

11P M

01 YC-16-B 93 4 Lot 33581 1650#

01 YC-16-B 93 4 Lot 33608 450#

01 YC-16-B 93 4 Lot _____ #

Total Weight 2609 5332# (Req 0549)

NON-BLEEDING

PROCESSES		APPROVED BY	
() K0-789-D	(I)	EWK 09-21-76	
()	()	DCG 09-21-76	
()	()	MTW 10-02-76	
()	()	FWP 02-05-79	
TYPED BY			
emw020579			

		NAME	USE LBS.	N CODE	ACCT. LBS.
211	1	Run 60" (990 G) water into V-211			
&	2	Weigh in drum & pour in	265 530	32-D	530-265
208	3	Dump in & stir 5 min	Lot 42 85 x 50	YC-16-B	4200
1		Record: Start 1.00	33581 1650		2100
		Fin 2.00	33608 450		
	4	Adj to 70" (1200 G) 2800-3200			
	5	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	6	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7	Record: V-208 Vol 45" & adj to 54" (1890 G)			
	8	Inspect Homog strainer & clean if necessary			
208	9	Run 10" (514 G) water into V-247 & start agitator & install temperature chart			
&	10	Pump V-208 thru Homog at 4800-5200 psi into SV-247			
SV	2	Record: Time Start 9:00 AM Total Min 130			
		NOTE: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	11	When V-208 MTY, run in 5" (240 G) water & pump thru Homog at 4800-5200 psi. Rinse in using Hot Water			
349	12	While Homog, run 6" (284 G) water into V-349			
&	13	Run ±1000# water into V-384 & heat to 110-120°F	1272		1272
384	14	Weigh into V-384 & pump to V-349	2930	32-D	2930
3	15	Run ±1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 30" (1400 G) & stir 15 min or longer (2.2)(10416)			
	17	Record: Ope 1.04 (10.0 ± 0.2) (1.040-1.044)			
SV	18	When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19	Record: pH 10.8 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	12	7-D	6
		Siphon N-7-D into SV & Record: pH 11.2			
	20	Heat to 190-194°F in 55-65 min & Record: HT 19V of			
		& Rec 19V of			
		NOTE: Strike must be started immediately on completion of heating			
343	21	While heating SV, run 70" (1920 G) water into V-343			
&	22	Meter in from V-386 M 4, 9.55 #/Gal 20.6 Gal		27-D	440
386	23	Stir 15 min or longer			197
5	24	Record: Ope 1.008 (2.5 ± 0.1) (1.008-1.009)			

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COMPONENT	PAGE 2	CG 04	CODE K0-789-D (I)	EST. WGT.	5332 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete, Record: pH 10.0 (9.6-10.2)						
	26	Set V-343 acid pump at 80 setting (± 255 minutes) 65						
	27	Set V-349 silicate pump at 20 setting (± 210 minutes) 53						
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike						
	29	Record: Start Fin Min						
		V-343	2:20 P.M.	2:45 P.M.	2:55			
		V-349	2:20 P.M.	2:50 P.M.	2:10			
		Record:	Time	V-343 in	V-349 in	SV pH	Normal pH	
		at 20 min	2:40 P.M.	(86) 49 49	(28) 20 21	9.7	9.3-10.0	
		40 min	3:00 P.M.	(88) 45 45	(28) 18 18	9.7	9.3-10.0	
		1 hr	3:20 P.M.	(56) 41 41	(28) 16 16+	9.5	9.3-10.0	
		2 1/2 hrs	4:35 P.M.	(28) 25 32	(28) 8 8	9.6	9.3-10.0	
		3 1/2 hrs	5:50 P.M.	(28) 9 15	(0) 0	9.7	9.3-10.0	
		Finish	6:35 P.M.	(0) 5		8.3	7.5-8.5	
		NOTE: If pH drops below 9.3 in 1st hr, stop pumps & see Supervisor. If final pH is above 8.5, adj to 7.5-8.5 & Record: pH Assume 77%						
357	30	Run 33" (238 G) water into V-357 & heat to 135-140°F						
7	31	Dump in & stir to dissolve				265 530	15-A	530
302	32	Add 42" (514 G) water to V-302						
8	33	Add & stir 2 min				Assume 50% 164 530	7-D	165
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump at zero setting						
	35	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	36	Stir 30 min at 190-194°F then turn off steam						
		Record: Start 7:30 P.M.						
	37	Run in V-357 from S 31 & stir 5 min						
	38	Record: pH 3.2 (3.4-3.8) & if necessary, adj (DOWN ONLY) to 3.4-3.8 & Record: pH					15-A	
		NOTE: Dissolve extra N-15-A in water at 135-140°F in drum, use ± 30 G water to 50# N-15-A. Stir SV 5 min after each addition						
	39	Run in N-7-D from S 33 in 10-12 min & stir 5 min						
	40	Record: pH 4.7 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.25				Assume 77%	27-D	
		(Dilute 10 parts water to 1 part N-7-D)				Assume 50% 30	7-D	15
		Siphon N-7-D into SV						
	41	Pour in & stir 15 min				12-25	978-A	1225
	42	Stop agitator						
		START	FIN	OPTR				
		8:30 A.M.	3:00 P.M.	381-86				
		3:00 P.M.	9:50 P.M.	126-201				

