

S.V. 246 1247 345 C.V.

D.V.

MAY 29 1980

CG 04 CODE KO-909-D PKG

PROCESSES

APPROVED BY

EST'D WGT 1596 LBS

() KO-909-D (C)

FWP 5/19/80

STANDARD HRS.

TIME 11.8 M

TYPED BY FWP 5/19/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	34372	400#
01	YC016B	93	34652	1500#
01	YC016B	93	35438	1500#

MAY 28 1980

TOTAL EST'D WGT 5296

REQ. NO. (

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
208	2 WEIGH IN DRUM AND POUR IN	480	32-D	480
	3 DUMP IN AND STIR 5 MINS. LOT	74X50	YC16B	3700
1	RECORD: START 8:45 AM 34372	400#		
	FIN 10:12 AM 34652	1500#		
	ADJUST TO 75" (1275 G)	1500#		
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 49" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-247. START HOMOG AGITATOR & INSTALL TEMP CHART			
2	10 PUMP V-208 THRU HOMOG 4000-5200 PSI INTO SV. RECORD: TIME START 7:00 AM TOTAL MINUTES			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	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			
384	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	14 WEIGH INTO V-384 & PUMP TO V-349	2500	32-D	2500
3	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.091 G/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, PUMP SV TO 20" (3084 G)			
4	19 RECORD: PH 10.3 & ADJ TO 11.1-11.3 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH 11.2	26	7-D	13
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

OK
HP
Homog #2
Homog #4
Homog #3

HOMO #2
NEEDS
& IMPACT VALVE
START - Down
AT 5:00 AM

Note Volume

N34679

EQUIP

PAGE 2 CG 04 KO-909-D EST WGT 5296#

USE

N-

USE

LBS

CODE

LBS

V-247

343	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343			
6	22	METER IN FROM V-386	M	35, 11.06 GAL, 33.7 GAL	27-D 373
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.024G/ML (1.018-1.020)			

25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1		
26	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)		
27	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)		
28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE		

29	RECORD:	START	FINISH	MINUTES
	V-343	2:35/10	7:00P	285
	V-349		6:05P	210
	TIME	V-343	V-349	SV
	2:35	INCHES	INCHES	PH
	AT 20 MIN	2:55 (46) 46	(17) 17	9.7 (9.3-10.0)
	40 MIN	3:15 (41) 41	(15) 16	9.7 (9.3-10.0)
	1 HR	3:35 (37) 40	(13) 14	9.7 (9.3-10.0)
	2 HRS	4:35 (23) 27	(6) 9	9.7 (9.3-10.0)
	3 HRS	5:35 (10) 10	(0) 4	9.7 (9.3-10.0)
	FINISH	6:20 0)		7.6 (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

30	SIFT IN	ASSUME 77%	27-D	50
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356	31	RUN 20" (216 G) WATER INTO V-356 & HEAT TO 135-140°F		
7	32	DUMP IN & STIR TO DISSOLVE FOR S-61	477	15-A 477

302	33	ADD 38" (465 G) WATER TO V-302		
B	34	ADD & STIR FOR 2 MIN FOR S 64	ASSUME 50%	296 7-D 148

135	DURING STRIKE PUMP INTO PT	482	149-A 482
PT	136	PUMP IN	54 155-A 54
9	137	PUMP IN	54 160-A 54
138	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42		

139	DURING STRIKE RUN 15" (268 G) WATER INTO V-356		
140	TURN ON STEAM		
356	141	ADJ TO 21" (366 G) AT 81-82°C	
10	142	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE	
143	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN		
144	SHUT OFF PUMP		
145	STIR 30 MIN AT 81-82°C FOR S 55		
146	DO NOT SHUT OFF AGITATOR		

SV 147 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
11 148 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
149 STIR 60 MIN AT 190-194°F 7:20 AM
150 HEAT TO 198-200°F IN 5-10 MIN
151 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP
152 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET
153 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER
154 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER
155 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
156 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
157 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER
158 TURN OFF HOMOG & STEARATE PUMP
159 STIR 5 MIN AT 198-200°F
160 SHUT OFF STEAM
161 RUN IN V-356 FROM S-32 & STIR 5 MIN
162 RECORD: PH 3.7 (3.4-3.8)
163 IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY)
& RECORD: PH
164 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
165 RECORD: PH 5.5 (6.2-6.4) & IF NECESSARY, ADJ
TO PH 6.2-6.4 & RECORD: PH 6.7 ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
SIPHON N-7-D INTO SV
166 DO NOT STOP AGITATOR

27-D
7-D

9

300

7-D

150

5-27-80

7:00 AM

3: PM

235-320

3 PM

11 PM

282-381

10 A

2 PM

126-120

7:00 A

3:00 PM

235-144

11 PM

11 PM

120-126

Note → STEP 10: - Homog #2 N.G. Cleaned #2 N.G.,
Cleaned #3

