CG 04 CODE KO-786-D PKG

PROCESS
( ) KO-786-D (P)

APPROVED BY
FWP 03/25/82

JUN 16 1982
(DATE)

F2H82
(LOT)

5084*
(EST. WGT)

COMTYP JOB NAME: 04KO786DMP
TYPED BY
TIME: 3:00 P.M. STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC-10	93	A2K39	2000					
	13	YE698D	98	14367	2000					
	01	YC-10	93	H1018	300					

REQ. NO. (10833) NON-BLEEDING

EQUIP MENT			NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
			BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208	1		RUN 60"(990 G) WATER IN V-211 & ADD & SET AGITATOR ON HIGH SPEED ASSUME 50%	30	7-D	15
	2		WEIGH IN DRUM AND POUR IN	270	32-D	270
	3		PUMP IN AND STIR 5 MIN	86X50	YC10B	4300
			RECORD: START 3:15 PM LOT A2K39	2000		
1			FIN 5:00 PM 14367	2000		
			H1018	300		
	4		ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	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._____" & 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 1240A TOTAL MINUTES 140			
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: 1.080 G/ML (1.078-1.081)			
SV	18		WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19		RECORD: PH 11.0 & 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 192*F & RECORD: 192*F			

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EQUIP MENT			USE LBS	N- CODE	ACCT LBS
	21	WHILE HEATING SV, RUN 51* (1400 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M 18, 1081 #/GAL, 328 GAL		27-D	355
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.017 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1			
	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			
6	29	RECORD: START FINISH MINUTES			
		V-343 4:20A			
		V-349 ____ 7:30AM 180			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 4:40A (47) 47 (20) 20 10.0 (9.3-10.0)			
		40 MIN 5:00A (43) 43 (17) 17 10.0 (9.3-10.0)			
		1 HR 5:20A (38) 38 (15) 15 10.0 (9.3-10.0)			
		2 HR 6:20A (24) 24 (7) 61 10.0 (9.3-10.0)			
		3 HR 7:20A (10) 10 (0) 0 10.0 (9.3-10.0)			
		FINISH 8:05A (0) 0 7.3 (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	ADD 67* (514 G) WATER TO V-385			
D 7	31	ADD & STIR 2 MIN D ✓	150	7-D	75
SV	32	WHEN V-349 MT; RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
8	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	34	TURN OFF STEAM			
	35	RUN IN ALUM USING BADGER METER	600	115-A	300
	36	FLUSH ALUM LINE WITH WATER.			
	37	RECORD: PH 3.7 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH ✓			
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%		115-A	
	38	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	39	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	
		SIPHON N-7-D INTO SV			
	40	STOP AGITATOR			

START	FINISH	OPERATOR
11:00P	7:00A	257-114
1:00AM	8:30AM	381-337

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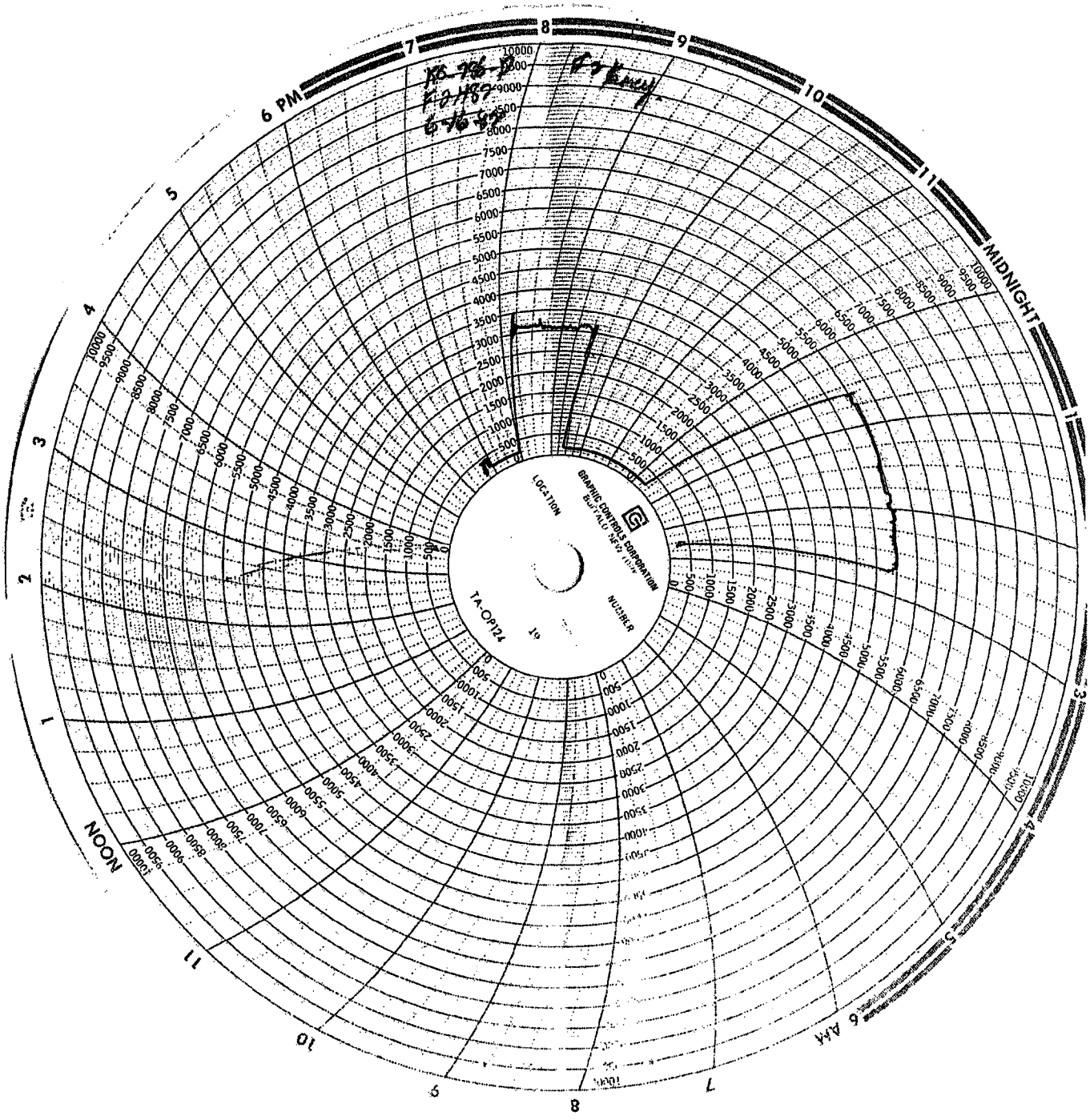

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