

CG 04 CODE KO-786-D PKG

PROCESSES

APPROVED BY

OCT-15 80 37459
EST'D WGT 862 LBS

() KO-786-D (P) FWP 9/18/80

STANDARD HRS. 10.5 TIME 7A M

TYPED BY: FWP 9/18/80

CG	CODE	PQ	LOT	LBS
01	YC010B	93	37304	3350
01	YC010B	93	36209	750
01	YC010B	93		

Homolog #2 - 1st Pass

TOTAL EST'D WGT 4962

REQ. NO. ()

NON-BLEEDING

QUIP	NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
11	1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
08	2 WEIGH IN DRUM AND POUR IN 3 DUMP IN AND STIR 5 MIN	270	32-D	270
1	RECORD: START 1038 AM FIN 12.00 AM	B2X50 67 15	YC10B	4100
	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. " & ADJUST TO 50" (1840G) 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
08	9 RUN 15" (771 G) WATER INTO V-211, START & AGITATOR & INSTALL TEMP CHART V 10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START 330P TOTAL MINUTES 120 2 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208 4 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
49	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349 & 13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F B4 14 WEIGH INTO V-384 & PUMP TO V-349 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: 1.081 G/ML (1.078-1.081)	2400	32-D	2400
V	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G) 19 RECORD: PH 10.8 & 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% SYPHON N-7-D INTO SV & RECORD: PH 20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F & RECORD: 192°F		7-D	

EQUIP PAGE 2 CG 04 KU-786-D EST WGT 4962# USE N USE
LBS CODE LBS

V.247

343 21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
& 22 V-343
386 23 METER IN FROM V-386 M 893 #/GAL 39.8 GAL 27-D 355
5 24 STIR 15 MIN OR LONGER
RECORD: DENSITY 1.020 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 9.8
26 SET V-343 ACID PUMP AT 72 SETTING (225 MIN)
27 SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)
SV 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
AT 190-194°F DURING STRIKE
29 RECORD: START FINISH MINUTES
V-343 7:45P 11:40PM 2:35
V-349 10:45P 18:0
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 8:05P (47) (20) 9.6 (9.3-10.0)
40 MIN 8:25P (43) (17) 9.6 (9.3-10.0)
1 HR 8:45P (38) (15) 9.7 (9.3-10.0)
2 HR 9:45P (24) (7) 9.7 (9.3-10.0)
3 HR 10:45P (10) (0) 9.7 (9.3-10.0)
FINISH 11:00P (0) 8.2 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

185 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

102 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 &
35 SET PUMP AT ZERO SETTING
9 36 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
37 TURN OFF PUMP MOTOR
38 TURN OFF STEAM
39 RUN IN V-385 FROM S 31 & STIR 5 MIN
40 RECORD: PH 3.3 (3.3-3.7) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.3-3.7 & RECORD: PH
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
41 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN
42 RECORD: PH 4.2 (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
43 STOP AGITATOR

START FINISH OPERATOR
3:00P 11:00P 126-259
11:00P 12:45AM 235-244

