

CG 04
JUN 14 1982CODE KU-909-D PRG
F2K14APPROVED BY
() KO-909-D (C) FWP 03/25/82

DATE

LOT NUMBER

STD. HRS.

TIME 3:27 AM

JOB NAME: 04K0909DMC

CG	CODE	PR	LOT	LBS
01	YC-16-B	93	22K36	2000
01	YC-16-B	93	22K63	1600
01	YC-16-B	98	39103	150

EST. WT. 5243* LBS.

REQ. NO. (10844)

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF. 1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED 2 WEIGH IN DRUM AND POUR IN 3 DUMP IN AND STIR 5 MINS. RECORD: START 3:15 PM LOT 22K36 FIN 4:30 PM 22K63 39103	480	32-D	480
1	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208 RECORD: V-208 VOL. 4.7" & ADJUST TO 54" (1890G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY	2000 1600 150	YC16B	3750
208 & SV	9 RUN 10" (514 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 5:30 PM TOTAL MINUTES 120 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 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: 1.092 G/ML (1.091-1.094)	2500	32-D	2500
SV & 4	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G) 19 RECORD: PH 10.1 & ADJ TO 11.1-11.3 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% 20 SIPHON N-7-D INTO SV & RECORD: PH 11.2 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 197°F & RECORD: 197°F NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.	60	7-D	30

V-246

121 WHILE HEATING SV, RUN 49" (1348 G) WATER INTO
343 V-343
& 122 METER IN FROM V-386 M 18 10.81 +/- GAL 34.5 GAL
385 123 STIR 15 MIN OR LONGER 27-D 373
5 124 RECORD: DENSITY 1.022 G/ML (1.018-1.020)

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
126 SET V-343 ACID PUMP AT 69 SETTING (225 MIN)
127 SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)
128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE

6 129 RECORD: START FINISH MINUTES
V-343 10:35 A.M. 2:30 P.M. 235
V-349 1:40 P.M. 185
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 10:55 A 46) (17) 9.7 (9.3-10.0)
40 MIN 11:15 A 41) (15) 9.7 (9.3-10.0)
1 HR 11:35 A 37) 37 (13) 13 9.7 (9.3-10.0)
2 HRS 12:35 P 23) 23 (6) 6 9.6 (9.3-10.0)
3 HRS 1:35 P 10) 10 (0) 0 9.6 (9.3-10.0)
FINISH 2:30 P 0) 0 7.7 (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%

130 SIFT IN 50 27-D 128-A 50

385 131 ADD 60" (465 G) WATER TO V-385
7 132 ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50% 296 7-D 148

133 DURING STRIKE CHECK LEVEL IN V-387.
387 134 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37
8 135 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING
THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE
136 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW
STEARATE MAKE-UP PROCEDURE.

137 RUN IN 27" (268 GAL). DO NOT MAKE UP THIS
SOLUTION MORE THAN 30 MINUTES IN ADVANCE.
DELAY BETWEEN END OF STEP 43 HEAT-UP AND
START OF STEP 53 HOMOGENIZATION SHOULD BE
LESS THAN 30 MINUTES.

388 138 TURN ON STEAM & AGITATOR
9 139 ADJUST TO 37" (366 GAL) AT 178-182°F
140 SET BADGER METER FOR 590#
141 PUMP IN FROM V-387 THRU UNDERSURFACE 482 169-A 482
DISTRIBUTORS AS FAST AS POSSIBLE 54 155-A 54
54 160-A 54
142 SHUT OFF PUMP
143 STIR 30 MIN AT 178-182°F FOR S 53
144 DO NOT SHUT OFF AGITATOR

SV 145 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING

10 146 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR

STIR 60 MIN AT 190-194°F - NOTE - STATED 2:30 P.M.

SV 148	HEAT TO 198-200°F IN 5-10 MIN			
10 149	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE			
CONT	PUMP			
150	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP			
	INLET			
151	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER			
	THRU HOMOG AT 2900-3100 PSI TO SEWER			
152	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE			
	TO SV & CLOSE VALVE TO SEWER			
153	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,			
	TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100			
	PSI. MAINTAIN SV AT 198-200°F.			
154	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE			
	AT STEARATE PUMP ASAP			
155	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT			
	WATER FROM HOT WATER MIXER			
156	TURN OFF HOMOG & STEARATE PUMP			
157	STIR 5 MIN AT 198-200°F			
158	SHUT OFF STEAM			
159	RUN IN ALUM USING BADGER METER	950	115-D	475
160	FLUSH ALUM LINE WITH WATER			
161	RECORD: PH <u>3.0</u> (3.4-3.8)			
162	IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY)			
	& RECORD: PH ____ . NOTE: USE LIQUID ALUM,			
	N-115-D. ADD TO SV VIA BADGER METER. STIR			
	5 MIN. AFTER EACH ADDITION. ASSUME 50%		115-D	
163	RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
164	RECORD: PH <u>4.1</u> (6.2-6.4) & IF NECESSARY, ADJ			
	TO PH 6.2-6.4 & RECORD: PH <u>6.2</u> ASSUME 78%		27-D	
	(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	80	7-D	80
	SIPHON N-7-D INTO SV			
165	DO NOT STOP AGITATOR			

START	FINISH	OPER
5: A.M.	7: A.M.	54-114
7:00 A.M.	3:00 P.M.	381-282
3:00 P.M.	5:40 P.M.	37-



