

CG 04 CODE KO-909-D PKG
 NOV-12-80 37829
 EST'D WGT 1596 LBS
 STANDARD HRS. TIME 11A M

PROCESSES APPROVED BY
 () KO-909-D (C) FWP 11/3/80
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 () ()
 TYPED BY FWP 11/3/80

CG CODE PQ LOT LBS
 01 YC016B 93 37336 2200
 01 YC016B 93 37370 1700
 01 YC016B 93

PUNCHED & CHECKED

CLEAN UP
 AS YOU GO ALONG

TOTAL EST'D WGT 5296 NOV 23 1980
 REQ. NO. () NON-BLEEDING

EQUIP	NAME	"KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1	RUN 40" (1990 G) WATER IN V-211. SET AGITATOR ON & HIGH SPEED			
208	2	WEIGH IN DRUM AND POUR IN	480	983-D	480
	3	DUMP IN AND STIR 5 MINS. LOT 37336 RECORD: START 3:45 PM. 37370	2200	YC16B	3700
		FIN 5:30 PM. 37370	1700		3900
	4	ADJUST TO 75" (1275 G)	3900		
	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 56 " & ADJUST TO 54" (1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9	RUN 10" (514 G) WATER INTO V-208. START			
	10	AGITATOR & INSTALL TEMP CHART			
SV	11	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	12	RECORD: TIME START 9:30 TOTAL MINUTES 135			
	13	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	14	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349	15	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	16	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	17	WEIGH INTO V-384 & PUMP TO V-349	2500	983-D	2500
	18	RUN 1000# WATER INTO V-384 & PUMP TO V-349	2000		2000
3	19	ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	20	RECORD DENSITY: 1.075 G/ML (1.091-1.094) 1.072-1.079			
SV	21	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	22	RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D			
4	23	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%			
	24	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	25	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190°F			
	26	& RECORD: 190°F			
	27	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-247

343	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343			
&	22	METER IN FROM V-386	M 67.9156#	339 AL	27-D
386	23	STIR 15 MIN OR LONGER			310
5	24	RECORD: DENSITY 1.016 G/ML (1.018-1.020)			

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
	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 1:10 5:15A 24.5			
		V-349 1:40 3:10A 18.0			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 1:30 (46) (17) 9.8 (9.3-10.0)			
		40 MIN 1:50 (41) (15) 9.8 (9.3-10.0)			
		1 HR 2:10 (37) (13) 9.8 (9.3-10.0)			
		2 HRS 2:10 (23) (6) 9.8 (9.3-10.0)			
		3 HRS 4:10 (10) (0) 9.7 (9.3-10.0)			
		FINISH 4:55 (0) 7.0 (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
	30	SIFT IN			50 120 11 50

385	31	RUN 40" (308 G) WATER INTO V-385 & 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

PT	35	DURING STRIKE PUMP INTO PT	482	169-A	482
9	36	PUMP IN	54	155-A	54
	37	PUMP IN	54	160-A	54
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			

356	39	DURING STRIKE RUN 15" (268 G) WATER INTO V-356			
10	40	TURN ON STEAM			
	41	ADJ TO 21" (366 G) AT 81-82°C			
	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE			
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN			
	44	SHUT OFF PUMP			
	45	STIR 30 MIN AT 81-82°C FOR S 55			
	46	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 30 MIN AT 190-194°F *5:15 A*
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-385 FROM S-32 & STIR 5 MIN
162 RECORD: PH *3.4* (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 *3.5* (6.2-6.4) & IF NECESSARY, ADJ
TO PH 6.2-6.4 & RECORD: PH *6.3* ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
SIPHON N-7-D INTO SV
166 DO NOT STOP AGITATOR

27-D

13 201-D 13

1100P
7:00P
1100P
700A

700A
3:00P
700A
9.AM

120-207
322-241
126-120
144-244

