

S.V. 246 (247) C.V. D.V.
 CG 04 CODE KD-786-D PKG PROCESSES APPROVED BY
 DEC 11 '80 38248 ~~0400C 00 11 80~~ () KD-786-D (P) FWP 11/20/80
 EST'D WGT 862 LBS () ()
 () ()
 STANDARD HRS. 10.5 TIME M () ()
 JOB NAME: 04KD786DMP

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36475	1750
01	YC010B	93	36216	2260
01	YC010B	93	36212	150

(2M)

OK
 H

TOTAL EST'D WGT 4962 REQ. NO. () NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
211	RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50%	30	7-D	15
&	& SET AGITATOR ON HIGH SPEED			
208	WEIGH IN DRUM AND POUR IN	280	983-D	280
	DUMP IN AND STIR 5 MIN LOT	82X50	YC10B	4100
1	RECORD: START 10.5 PM			
	FIN 2.25 PM			
	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. 29 & ADJUST TO 50" (1840G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 15" (771 G) WATER INTO V-208, START			
&	AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 8.50 TOTAL MINUTES 1.20			
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	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
&	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	WEIGH INTO V-384 & PUMP TO V-349	2450	983-D	2450
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
2	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	RECORD DENSITY: 1.029 G/ML (1.078-1.081)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			
	RECORD: PH 10.7 & 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			
120	HEAT TO 190-194°F IN 55-65 MIN & REC: HT			
	& RECORD: *F			

N34562

343 21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
 & 22 V-343
 386 23 METER IN FROM V-386 M 26, 969 #/GAL, 36.6 GAL
 5 24 STIR 15 MIN OR LONGER
 24 RECORD: DENSITY 1.0186/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 9.7
 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
 29 RECORD: START FINISH MINUTES
 V-343 5:50 P.M. 7:20 P.M. 225
 V-349 5:50 P.M. 8:50 P.M. 195
 TIME V-343 V-349 SV NORMAL
 INCHES INCHES PH PH
 AT 20 MIN 5:50 (47) 48 (20) 20 26 (9.3-10.0)
 40 MIN 6:10 (43) 44 (17) 12 26 (9.3-10.0)
 1 HR 6:20 (38) 25 (15) 15 26 (9.3-10.0)
 2 HR 7:20 (24) 25 (7) 25 26 (9.3-10.0)
 3 HR 8:20 (10) 11 (0) 0 26 (9.3-10.0)
 FINISH 8:50 (0) 0 8.0 (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

385 20 RUN 40" (308 G) WATER INTO V-385 & HEAT TO
 7 135-140°F
 31 DUMP IN & STIR TO DISSOLVE 300 15-A 300

302 30 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 &
 SET PUMP AT ZERO SETTING
 9 35 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
 36 TURN OFF STEAM
 37 RUN IN V-385 FROM S 31 & STIR 5 MIN
 38 RECORD: PH 3.2 (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
 39 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN
 40 RECORD: PH 4.15 (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
 41 STOP AGITATOR

START FINISH OPERATOR

3:00 P.M. 11:00 P.M. 320-235
 3:00 P.M. 10:10 P.M. 77

20M57