CG 04 CODE KO-786-D PKG 5084* PROCESS ( ) KO-786-D (F) APPROVED BY: FWP 09/08/82

10/13/82 K2K06 (EST WGT) COMTYP JOBNAME: 04KO786DMP

(DATE) (LOT) TIME: 7:00 A.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	C2K79	3950	100.00	79	50	3950	3950
	01	YC-10	93	H1278	50	100.00	1	50	50	50
	01	YE721D	98	D2H89	300	100.00	6	50	300	300
	01	YC-10	93							

SUBSTANDARD BLEND-BACK FOR S-40: CODE ~~LOT~~ ~~PQ~~

REQ. NO.(10991) NON-BLEEDING

EQUIP MENT		NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D (HYDROCHLORIC ACID) LINE, IF ANY IS BLANKED OFF".			
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD (CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	270	32-D	270
	3	DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	80X50	YC10B	4000
		RECORD: START 4:15pm LOT	6X50	YE721D	300
1		FIN 4:50pm C2K79 79x50	3950		
		H1278 1x50	50		
		D2H89 6x50	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			
	6	HOMOG AT 1800-2200 PSI INTO V-208			
	7	WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208			
	8	RECORD: V-208 VOL. 48" & ADJUST TO 50"(1840G)			
		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.			
2		RECORD: TIME START 10:00am TOTAL MINUTES 180			
		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: 1.078 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 9.5 & ADJ TO 10.4-10.8 USING N-7-D			
4		DILUTED TO SG (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	30	7-D	15
		SIPHON N-7-D INTO SV & RECORD: PH 10.7			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT ____*F & RECORD: ____*F			

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LOT= _____ _ COMTYP JOB NAME = 04K0786DMP PAGE 02 DATE PRINTED: 9/14/82

EQUIPMENT		PAGE 2 CG 04 K0-786-D V-246	USE LBS	N-CODE	ACCT LBS
	21	WHILE HEATING SV, RUN 51* (1400 G) WATER INTO			
343		V-343			
&	25	METER IN (SULFURIC ACID 60%) FROM V-386		27-D	355
386		M25 1.146#/GAL, 319 GAL			
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.018 KG/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
	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-343 220 8:40AM 360			
		V-349 2AM 5:40AM 200			

	TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
STRAINER CHECKED	AT 20 MIN	2:40 (47)	(20)	9.6	(9.3-10.0)
	40 MIN	3:00 (43) 50	(17) 17	9.7	(9.3-10.0)
MOVED METER ON N-217 TO 100 TO HOLD PH	1 HR	3:20 (38) 49	(15) 15	10.0	(9.3-10.0)
	2 HR	4:20 (24) 46	(7) 8	10.0	(9.3-10.0)
	3 HR	5:20 (10) 28	(0) 2	10.0	(9.3-10.0)
	FINISH	6:05 (0) 12		8.1	(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			
7	31	ADD & STIR 2 MIN	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 LIQUID ALUM USING BADGER METER ← USE 480#	600	115-D	300
	36	FLUSH ALUM LINE WITH WATER.			
	37	RECORD: PH 3.3 (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-D	_____
	38	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	39	RECORD: PH 3.5 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.1 ASSUME 77%	_____	27-D	_____
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	18	7-D	9
	40	SIPHON N-7-D INTO SV			
		WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN SUBSTANDARD TO BE BLENDED BACK.			
		RECORD: CODE ___V___, LOT ___V___, ___V___#			
	41	STOP AGITATOR			

START	FINISH	OPERATOR
7:00 PM	3:00 PM	322-320
10:00	11:00 PM	54-301
11:00 PM	7:00 AM	438-409

7:00 AM 9:20 AM 322-320

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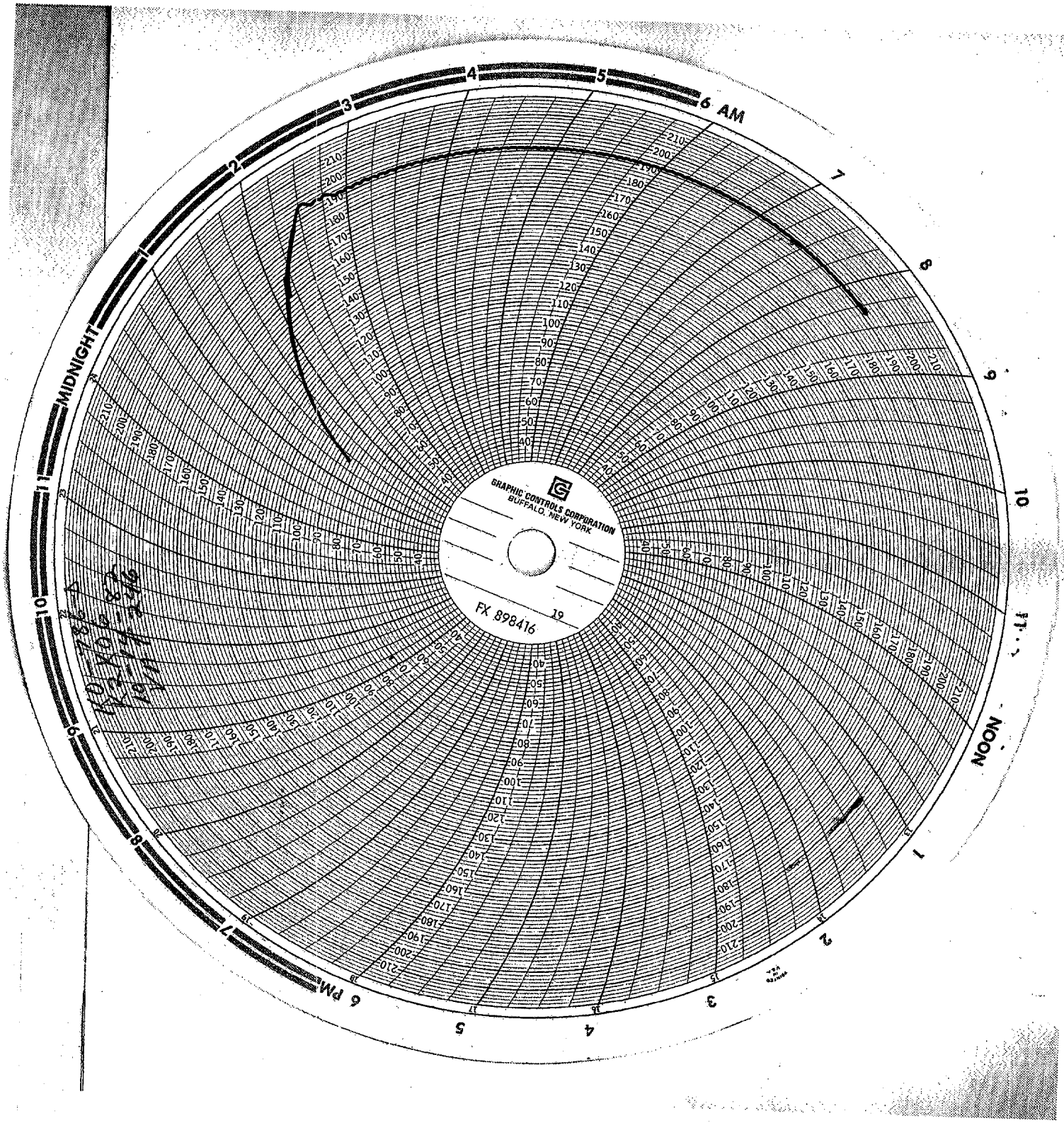

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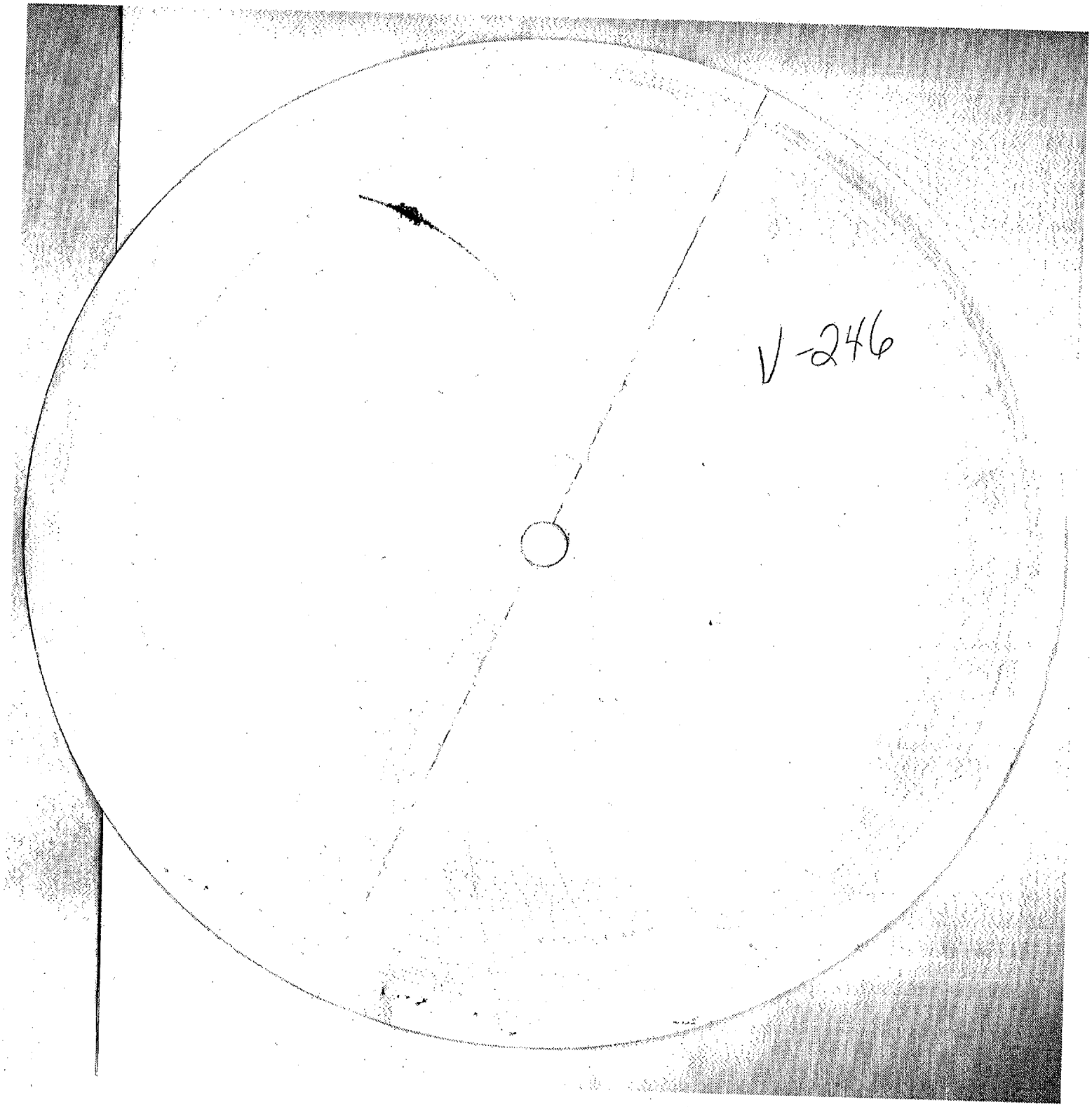

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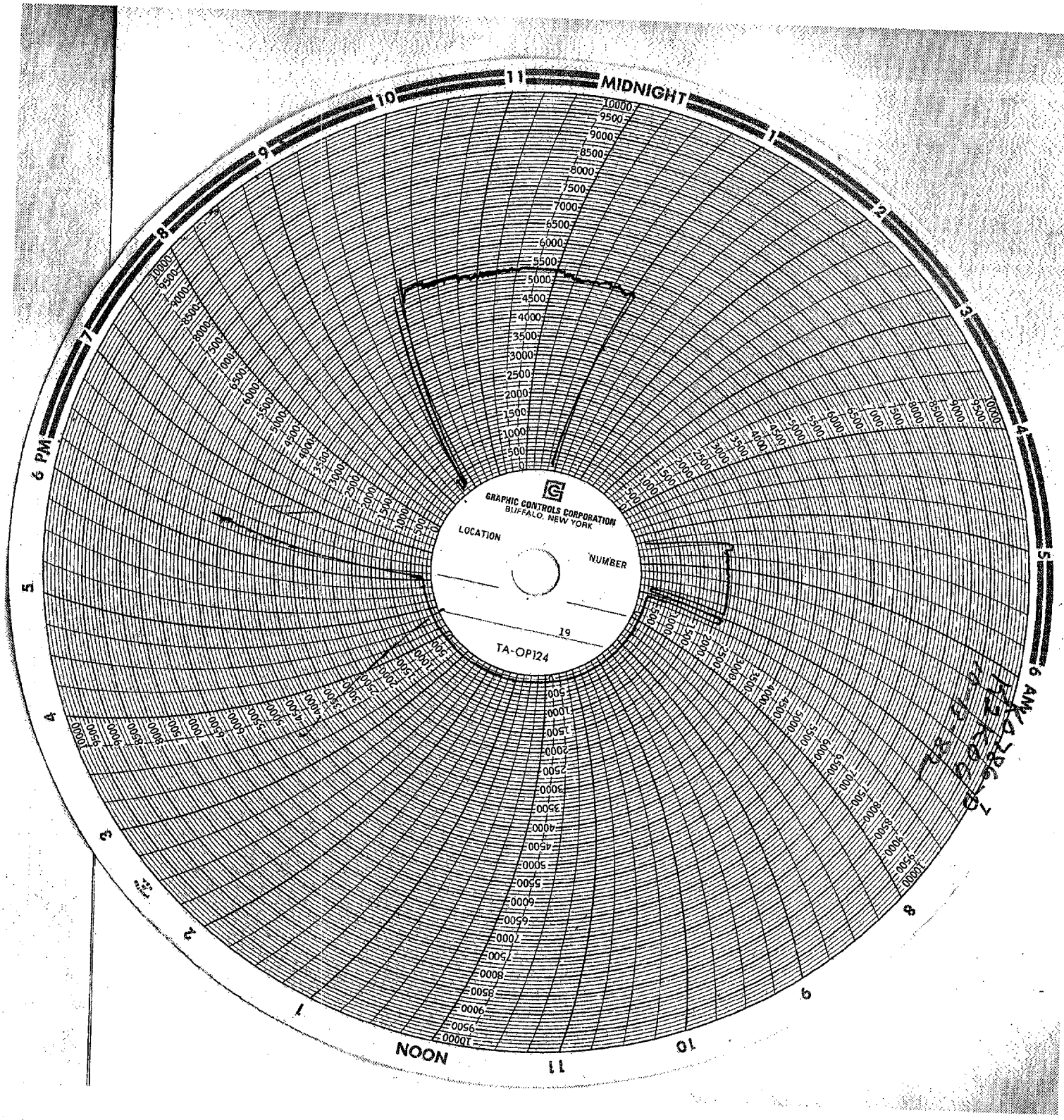

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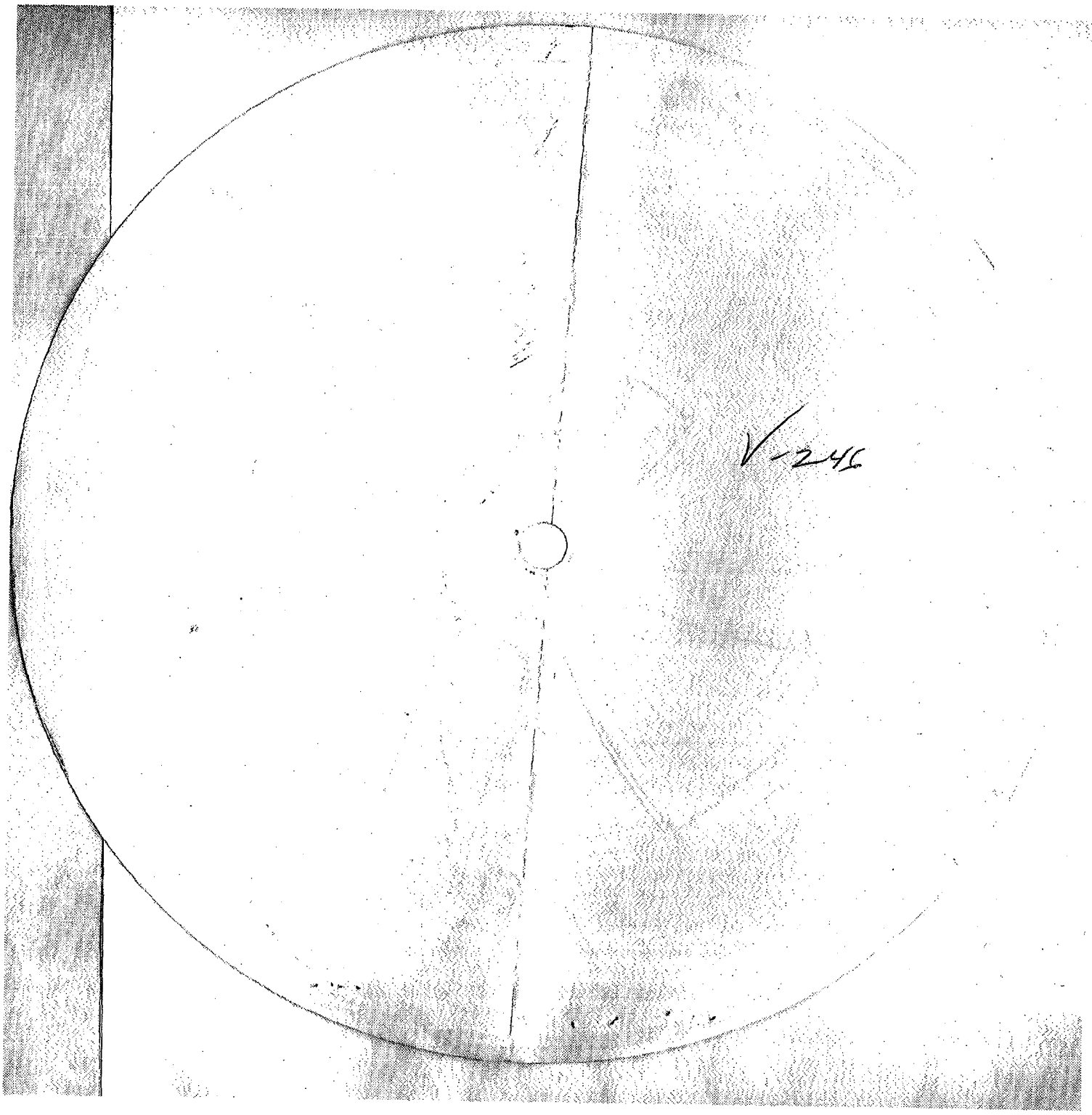

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