

CG 04 CODE KO-786-D PKG PROCESSES APPROVED BY
 EST'D WGT 862 LBS 36252 June 24 () KO-786-D (P) FWP 5/22/80
 STANDARD HRS. 10.5 TIME 11:AM OK
 TYPED BY: FWP 5/22/80

CG CODE PQ LOT LBS
 01 YC010B 93 35782 1200
 01 YC010B 93 35780 2900
 01 YC010B 93

PUNCHED & CHECKED

JUN 30 1980

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

EQUIP	NAME	USE LBS	NCODE	ACCT LBS
211 & 208	NAME: "KROLOR" ORANGE R RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN RECORD: START FIN ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208 RECORD: V-208 VOL. 42" & ADJUST TO 50" (1840G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY	30 270 82X50 1200 2900	7-D 32-D YC10B	15 270 4100
208 & SV 2	RUN 15" (771 G) WATER INTO V-208 START AGITATOR & INSTALL TEMP CHART PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START 2:10 PM TOTAL MINUTES 300 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F WEIGH INTO V-384 & PUMP TO V-349 RUN 1000# WATER INTO V-384 & PUMP TO V-349 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN RECORD DENSITY: 1.081 G/ML (1.078-1.081)	2400	32-D	2400
SV 4	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G) RECORD: PH 10.8 & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH HEAT TO 190-194°F IN 55-65 MIN. & REC: HT 19V *F & RECORD: 19V *F		7-D	

V-247

LBS CODE

343	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
386	22	METER IN FROM V-386	M	39, 10.94 GAL, 32.8	27-D 355
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.020 G/ML ()			

SV	25	WHEN S' 20 HEATING COMPLETE, RECORD: PH 10.0			
	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 AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH	9:30	MINUTES	
		V-343 4:55 AM	8:15	2:75	
		V-349		2:00	

	TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
AT 20 MIN	5:55 A	(47) 48	(20) 20	9.6	(9.3-10.0)
40 MIN	5:55 A	(43) 43	(17) 17	9.6	(9.3-10.0)
1 HR	5:55 A	(38) 38	(15) 15	9.6	(9.3-10.0)
2 HR	6:55 A	(24) 24	(7) 7	9.6	(9.3-10.0)
3 HR	7:55 A	(10) 10	(0) 0	9.6	(9.3-10.0)
FINISH	8:40 A	(0) 0	(0) 0	6.9	(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	RUN 31" (228 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	31	DUMP IN & STIR TO DISSOLVE	300	15-A	300

302	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 & 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 3.3 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH			15-A
		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 4.0 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH			27-D
		DILUTE N-7-D 10 TO 1 WITH WATER			7-D
		SIPHON N-7-D INTO SV			
	41	STOP AGITATOR			

START

FINISH

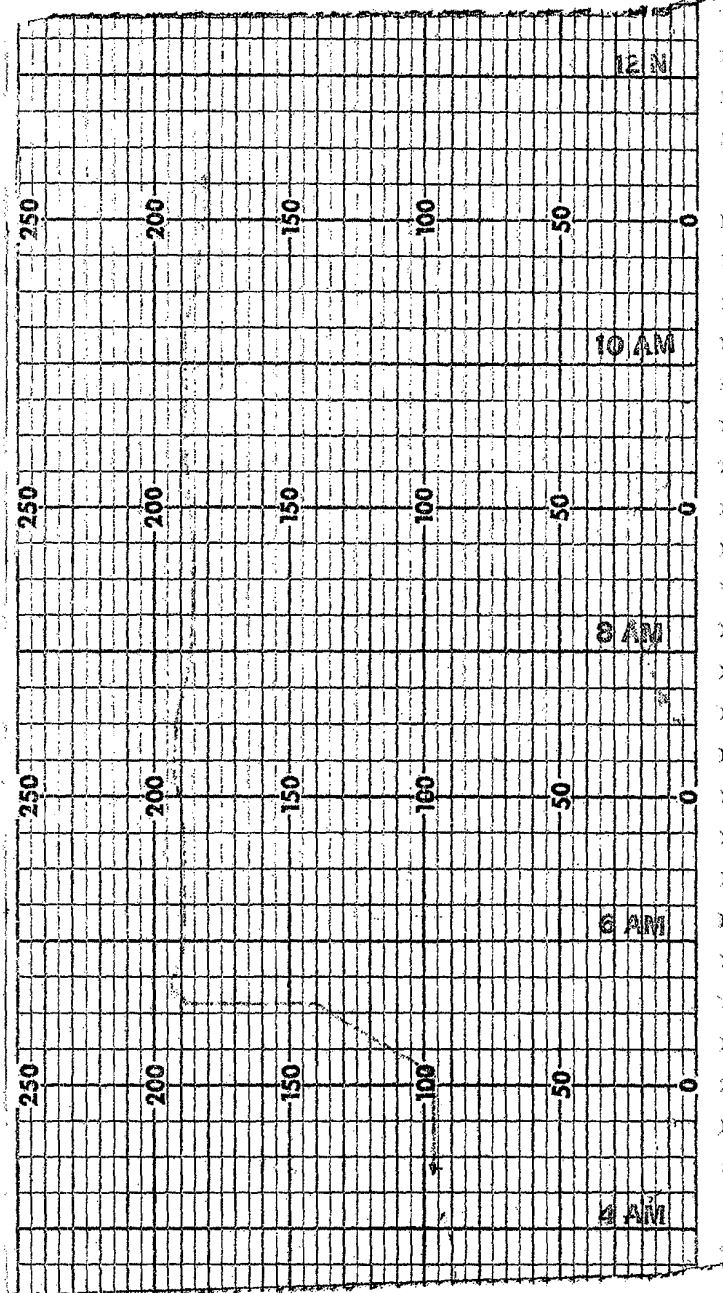
OPERATOR

7 AM
3:00 PM
11:00 PM3 PM
7:00 AM120
320-322
201-381

7 AM

10:55

120



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