

CG 04

CODE KO-786-D

PKG

PROCESS

APPROVED BY:

OCT 28 1982

L2H36

5084*

() KO-786-D (P)

FWP 10/04/82

(DATE)

(LOT)

(EST WGT)

COMTYP JOBNAME: 04KO786DMP

TIME: __:00 __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-16-8	94	<u>51314</u>	<u>200</u>	100.00	<u>4</u>	<u>50</u>	<u>200</u>	<u>200</u>
	01	YC-10	93	<u>62494</u>	<u>1550</u>	100.00	<u>31</u>	<u>50</u>	<u>1550</u>	<u>1550</u>
	01	YC-10	93	<u>52305</u>	<u>2550</u>	100.00	<u>51</u>	<u>50</u>	<u>2550</u>	<u>2550</u>
	01	YC-10	93			100.00				

SUBSTANDARD BLEND-BACK FOR S-40: CODE _____, LOT _____, PQ _____, # _____
REQ. NO. 11014 NON-BLEEDING

EQUIP MENT	NAME	USE LBS	N CODE	ACCT LBS
	"KROLOR" ORANGE R			
211	BEFORE USING SV, MAKE SURE THAT N-28-D (HYDRO-CHLORIC ACID) LINE, IF ANY IS BLANKED OFF.			
&	RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% (CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
208	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	270	32-D	270
	DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	8X50	YC10B	400
1	RECORD. START <u>7:15 AM</u> LOT _____	4X50	YC16B	200
	FIN <u>11 AM</u>			
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 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. _____ & ADJUST TO 50" (1840G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 45" (771 G) WATER INTO V- <u>246</u> , START			
&	AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START <u>8:30 AM</u> TOTAL MINUTES <u>240</u>			
	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			
12	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	2400	32-D	2400
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	RECORD DENSITY: <u>1.080</u> G/ML (1.078-1.081)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			
	RECORD: PH <u>10.5</u> & 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 _____			
20	HEAT TO 190-194°F IN 55-65 MIN & RECORD: <u>190</u> °F			
	& RECORD. <u>190</u> °F			

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EQUIP PAGE 2 CG 04 KO-786-D V- 246 USE N- ACCT
MENT LBS CODE LBS

21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
343 V-343
& 22 METER IN (SULFURIC ACID 60%) FROM V-386 27-D 355
386 123 11.014 G/GAL, 32.2 G/GAL
5 123 STIR 15 MIN OR LONGER
124 RECORD: DENSITY 1.019 G/ML (1.018-1.020)

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
SV 6 AT 190-194°F DURING STRIKE
29 RECORD: START FINISH MINUTES
V-343 2:10 PM 6:25 230
V-349 5:20 PM 280
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 2:30 (47) 48 (20) 20 9.8 (9.3-10.0)
40 MIN 2:50 (43) 44 (17) 17 9.8 (9.3-10.0)
1 HR 3:10 (38) 15 9.8 (9.3-10.0)
2 HR 4:10 (24) 7 9.8 (9.3-10.0)
3 HR 6:10 (10) 0 7.4 (9.3-10.0)
FINISH 6:50 (0) 2.2 (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 &
33 SET PUMP AT ZERO SETTING
8 33 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
34 TURN OFF PUMP MOTOR
35 TURN OFF STEAM
35 RUN IN LIQUID ALUM USING BADGER METER 600 115-D 300
36 FLUSH ALUM LINE WITH WATER. 480
37 RECORD: PH 3.6 (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 4.2 (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
40 WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN
SUBSTANDARD TO BE BLENDED BACK.
RECORD: CODE LOT #
41 STOP AGITATOR
START FINISH OPERATOR
2:30 P 3:01 P 126
11:00 PM 1:00 AM 370
8:30 A 3:00 P 126
3 PM 6:45 282



