S.V. ~~246~~ 247 C.V. JUL 8 0 1980 B.V.

CG 04 CODE KO-786-D PKG JUL-2 36374
EST'D WGT 862 LBS
STANDARD HRS. 10.5 TIME 11 AM

PROCESSES
( ) KO-786-D (P)
( ) ( )
( ) ( )
( ) ( )
TYPED BY: FWP 5/22/80

APPROVED BY
FWP 5/22/80

CG	CODE	PQ	LOT	LBS
01	YC010B	93	35779	1550
01	YC010B	93	36139	1550
01	YC010B	93	~~35770~~	1000
YC-10		93	35781	1600

JUL 8

PUNCHED & CHECKED
JUL - 8 '980

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

EQUIP		NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACC LBS
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD & SET AGITATOR ON HIGH SPEED ASSUME 50%	30	7-D	15
	2	WEIGH IN DRUM AND POUR IN	270	32-D	27(
	3	DUMP IN AND STIR 5 MIN LOT	82X50	YC10B	410(
		RECORD: START 230 AM 36139	1600		
1		FIN 630 AM 35779	1500		
		35781	1000		
	4	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. 39 " & ADJUST TO 39"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 15" (771 G) WATER INTO V-247, START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 250 PM TOTAL MINUTES 150			
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 & 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	240(
	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: 1.079 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.6 & 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 [illegible] PH ____			
	20	HEAT TO 170-194*F IN [illegible] MIN & RECORD: ____*F			

N34528

DUP050104310

V-247

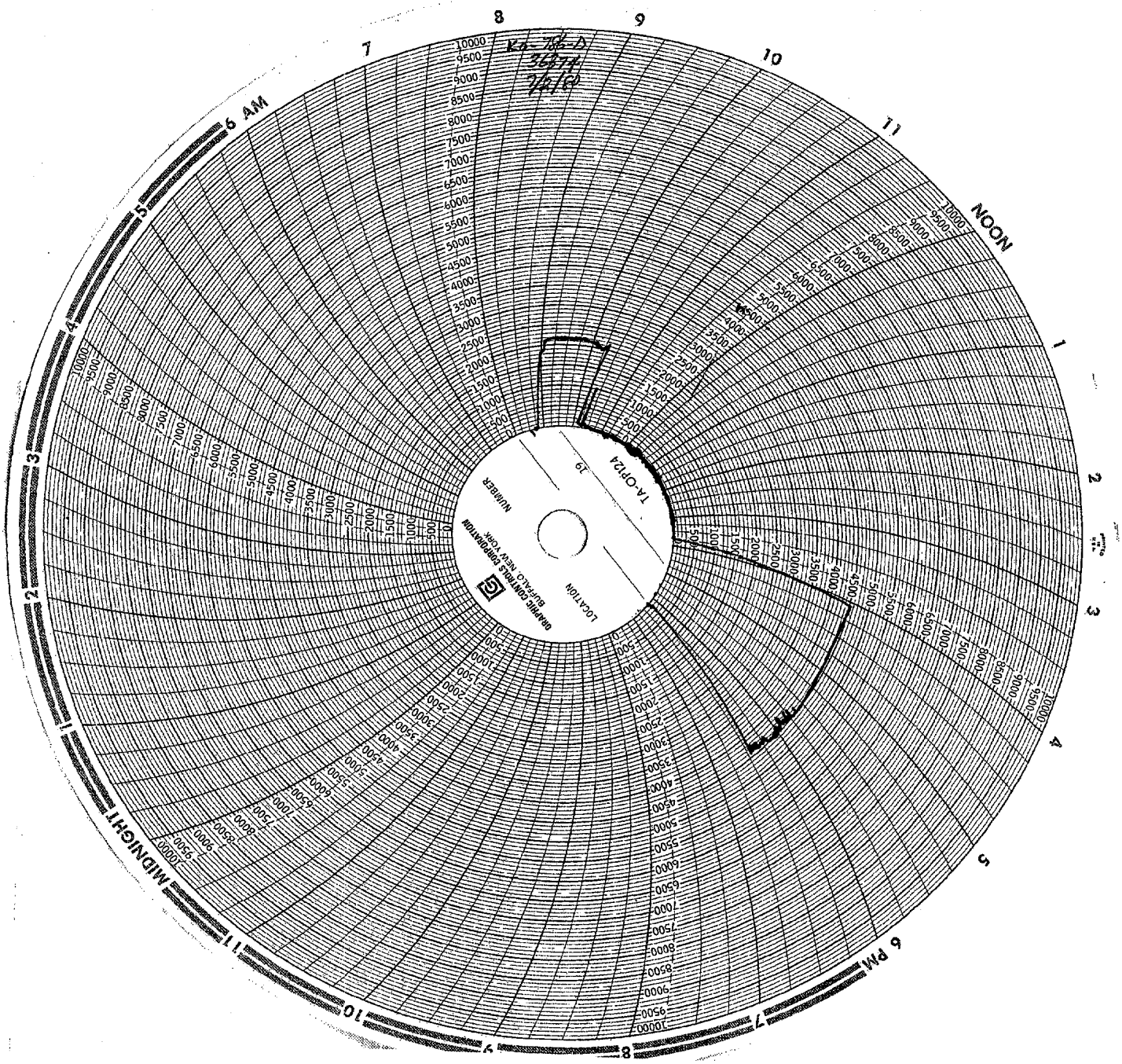
			LBS	CODE	LBS
	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M 40 10.46 #/GAL, 33.9 GAL		27-D	355
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.020 #/ML. ( )			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.5			
	26	SET V-343 ACID PUMP AT 72 SETTING (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 STROKE			
	29	RECORD: START FINISH MINUTES			
		V-343 7:00P 11:00P 240			
		V-349 7:00P 10:15P 195			

	TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
AT 20 MIN	7:20P	(47) -	(20) -	9.4	(9.3-10.0)
40 MIN	7:40P	(43) ✓	(17)	9.4	(9.3-10.0)
1 HR	8:00P	(38) +	(15)	9.4	(9.3-10.0)
2 HR	9:00P	(24) 27	(7)	9.6	(9.3-10.0)
3 HR	10:00P	(10)	(.0)	9.7	(9.3-10.0)
FINISH	10:45P	(0)		6.75	(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" (238 G) WATER INTO V-385 & HEAT TO			
7		135-140*F			
	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 3.25 (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 3.85 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.05 ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	12	7-D	6
	41	SIPHON N-7-D INTO SV			
	42	STOP AGITATOR			

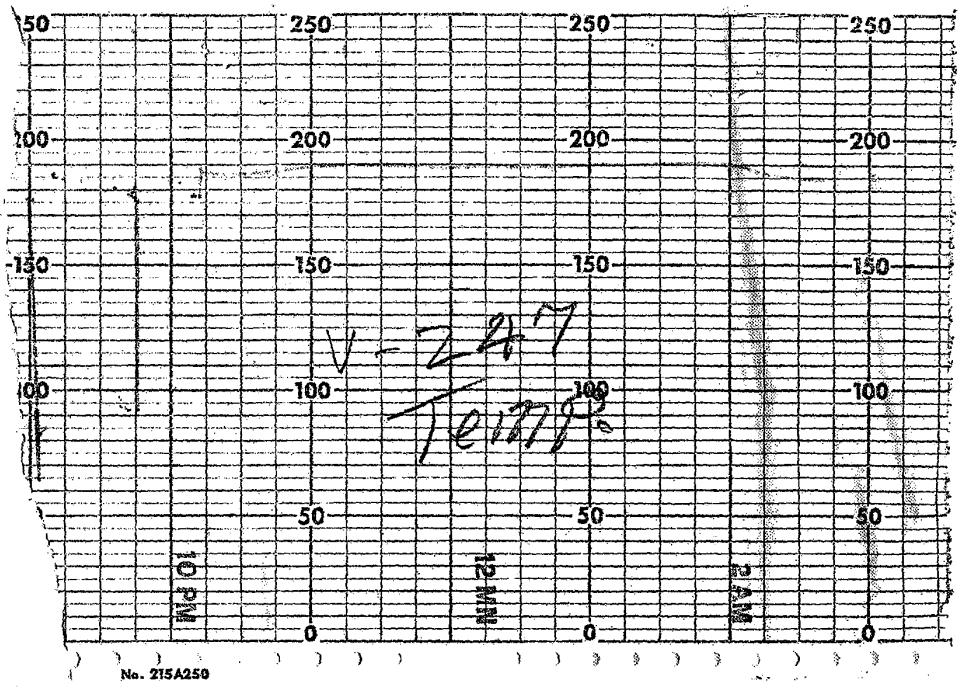
START	FINISH	OPERATOR
3:00P	11:00P	239-201
11:00P	11:55PM	235

DUP050104311



DUP050104312


V-247



DUP050104314