

CG 04 CODE KO-906-D PKG.

PUNCHED & CHECKED

PROCESSES

APPROVED BY

EST. WGT. 1377 LBS.

STD. HRS. TIME 11A M

01 YC-10-B 93 4 35487 1850#
 01 YC-10-B 93 4 35488 1850#
 01 YC-10-B 93 4

(C) KO-906-D (C) FWK 1/24/78
 () DCG 1/26/78
 () MW 1/26/78

TYPED BY
ri 3/2/78

MAY 12 1980

CLEAN UP
 AS YOU GO ALONG

TOTAL WEIGHT 5077# (Req.)

Homog #2

NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
211 & 208	1 KROLO® ORANGE R			
1	2 Run 31" (505 G) water in V-211 and add. Assume 50%	26	7-D	13
	3 Weigh in drum and pour in	245	32-D	245
	3 Dump in and stir 5 min	74 x 50	YC-10-B	3700
	Record: Start 12:40	35487	1850	
	Finish 1:30 A.M.	35488	1850	
	4 Adjust to 64" (1082 G)			
	5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-208 Vol 40 " & adjust to 45" (1662 G)			
	8 Inspect Homog strainer and clean if necessary			
208 & SV	9 Run 15" (793 G) water into V-247 & start agitator			
2	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
	11 Record: Time Start 2:00 P.M. Total Min 125			
	Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	12 When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384	13 While Homog, run 5" (237 G) water into V-349			
3	14 Run 1000#water into V-384 and heat to 110-120°F			
	15 Weigh into V-384 and pump to V-349	2165	32-D	2165
	16 Run 1000#water into V-384 and pump to V-349			
	17 Adjust V-349 to 20" (946 G) and stir 15 min or longer			
	18 Record: "Be" 1.081 (10.9 ± 0.2) (1.078-1.081)			
SV	19 When S12 Homog complete, adi to 59" (3033 G) in SV			
4	20 Record: pH 10.8 & adi to 10.4-10.8 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D). Assume 50%		7-D	
	Siphon N-7-D into SV, stir 5 min & record: pH			
	21 Heat to 190-194°F in 55-65 min & Record: HT 186 Rec 1930F			
	Note: Strike must be started immediately on completion of heating			
343 & 386	22 While heating SV, run 46" (1265 G) water into V-343			
5	23 Meter in from V-386 M 33 1050#/Gal. 30.5 Gal		27-D	320
	24 Stir 15 min or longer			
	25 Record: "Be" 1.018 (2.9 ± 0.1) (1.018-1.019)			

V-247

EQUIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE	N	ACCT.
	2	04	K0-906-D (C)	5077		LBS.	CODE	LBS.
SV	26	When S20 heating complete, Record: pH 9.9 (9.6-10.2)						
6	27	Set V-343 acid pump at 65 setting (+225 min)						
	28	Set V-349 Silicate pump at 57 setting (+180 min)						
	29	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike						
	30	Record: Start Finish Minutes						
		V-343 6:00 / 10:05 245						
		V-349 6:00 PM 9:10 PM 190						
		Record:	Time	V-343	V-349	SV pH	Normal pH	
			6:00	Inches	Inches			
		at 20 min	6:20	(43) 44+	(18)	9.7	9.3-10.0	
		40 min	6:40	(39) 40+	(16)	9.7	9.3-10.0	
		1 hr	7:00	(35) 36+	(13)	9.7	9.3-10.0	
		2 hrs	8:00	(22) 24	(7)	9.75	9.3-10.0	
		3 hrs	9:00	(10) 13+	(0) 1	9.85	9.3-10.0	
		Finish	10:05	(0)		7.1	7.5-8.5	
		Note: (1) If pH not as specified notify supervisor & note in Log (2) If final pH is above 8.5, adj to 7.5-8.5 and						
		Record: pH Assume 78%						
	31	Sift in 1 bag					27-D	
						50	128-A	50
							65	
356	32	Run 19" (137 G) water into V-356 & heat to 135-140°F						
7	33	Dump in & stir to dissolve for S61						
						270	15-A	270
302	34	Run 24" (294 G) water into V-302						
8	35	Add & stir 2 min for S64						
						Assume 50%	136	7-D 68
PT	36	During strike pump into PT						
9	37	Pump in						
	38	Pump in						
	39	Stir 10 min with lightning mixer for S43						
							464	169-A 464
							52	155-A 52
							52	160-A 52
356	40	During strike, run 22" (268 G) water into V-356						
10	41	Turn on steam						
	42	Adj to 20" (366 G) at 178-182°F 81-82°C						
	43	Pump PT. mixture from S39 thru undersurface						
		Distributor AFAP						
	44	Rinse PT with hot water from hot water mixer & pump in						
	45	Shutoff pump 81-82°C						
	46	Stir 30 min at 178-182°F for S55						
	47	Do not shutoff agitator						
SV	48	When V-349 MTY, rinse in with minimum water then set pump to zero setting						
11	49	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	50	Heat to 198-200°F in 5-10 min						
	51	Close water line & discharge valves at stearate pump						
	52	Open V-356 Discharge valves to stearate pump inlet						
	53	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer						
	54	While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & close valve to sewer						
	55	Immediately open stearate pump Discharge valve, Turn on pump & Homog V-356 to SV at 2900-3100 psi Maintain SV at 198-200°F						
	56	While Homog V-356 to SV, shutoff water valve at Stearate pump ASAP						

[illegible]

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