

CG 04 CODE KO-789-D PKG

PROCESSES

APPROVED BY

EST'D WGT JUL 14 80 LBS 36530

OK () KO PUNCHED & CHECKED

STANDARD HRS. 10.8 TIME 7A M

TYPED BY: FWP 5/22/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	36120	2000#
01	YC016B	93	36365	2000#
01	YC016B	93	36036	2000#
01	YC016B	98	72335	40#

Homog #2
V-247 M'T '10:15/PM

TOTAL EST'D WGT 5232 5270 REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
	RECORD: START 215 LOT YC-16-36120	1x40	YC16B	40
	FIN 8:45 YC-16-12335			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 42" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	1 RUN 10" (514 G) WATER INTO V-247 START			
	2 AGITATOR & INSTALL TEMP CHART			
SV	3 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 10:20 TOTAL MINUTES 120			
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	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	14 WEIGH INTO V-384 & PUMP TO V-349	2545	32-D	2545
	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: 1.086 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 10.5 & ADJ TO 11.1-11.3 USING N-7-D			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	225	7-D	12
	SIPHON N-7-D INTO SV & RECORD: PH 11.3			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34608

343 21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO
 & 22 METER IN FROM V-386 M 42, 1967 #/GAL 35.8 GAL
 386 23 STIR 15 MIN OR LONGER
 5 24 RECORD: DENSITY 1.019 G/ML (1.018-1.020)

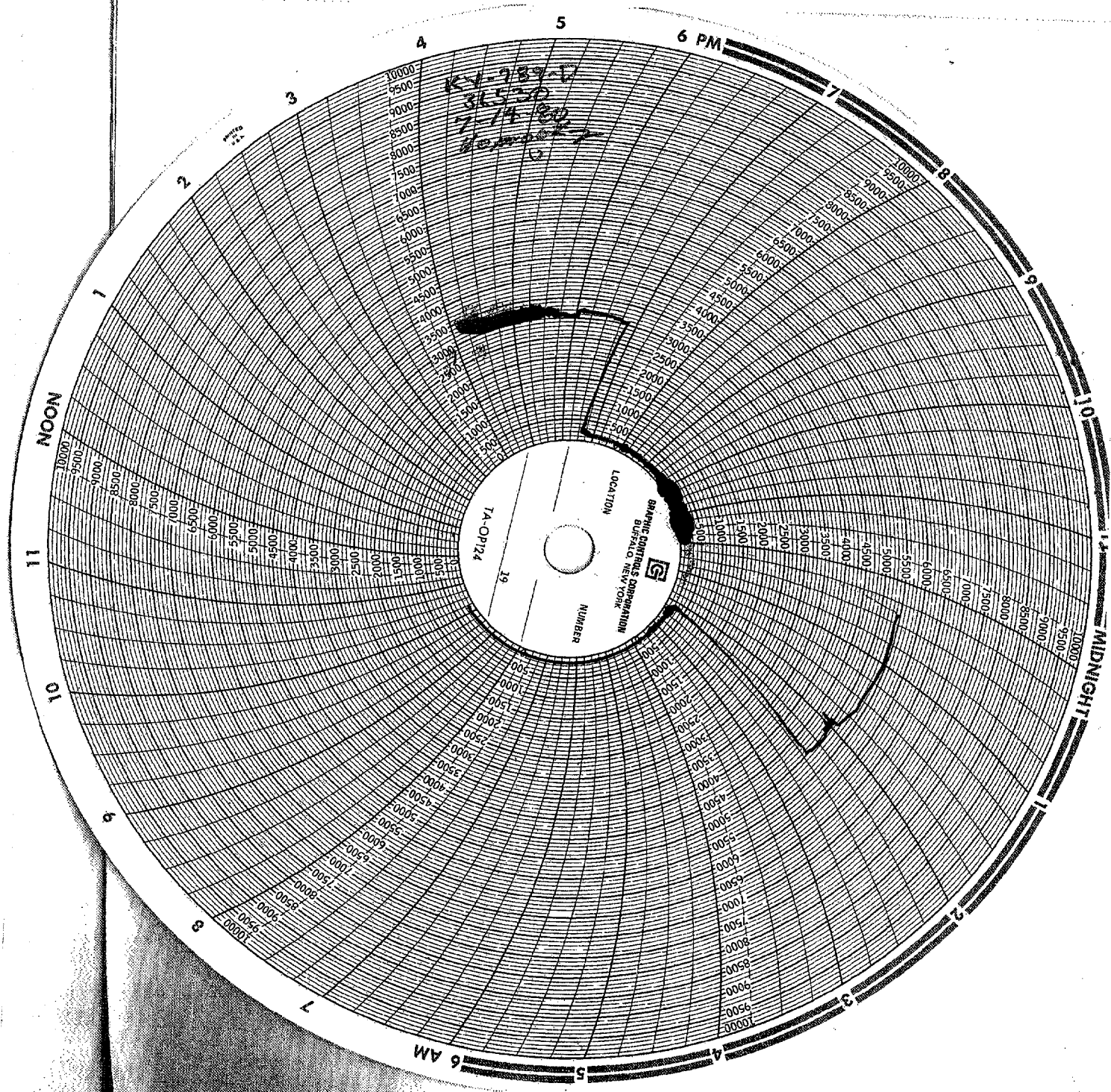
25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2
 26 SET V-343 ACID PUMP AT 65 SETTING (255 MIN)
 27 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)
 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 SV AT 190-194°F DURING STRIKE
 29 RECORD: START FINISH MINUTES
 V-343 1:50 PM 6:30 AM 280
 V-349 1:50 PM 5:25 AM 215
 TIME V-343 V-349 SV NORMAL
 INCHES INCHES PH PH
 AT 20 MIN 2:10 PM (49) (20) 10.0 (9.3-10.0)
 40 MIN 2:30 PM (45) (18) 10.2 (9.3-10.0)
 1 HR 2:50 PM (41) (16) 10.0 (9.3-10.0)
 2 1/4 HR 3:10 PM (25) (8) 10.0 (9.3-10.0)
 3 1/2 HR 3:30 PM (9) 12 (0) 10.0 (9.3-10.0)
 FINISH 3:45 PM (0) 7.9 (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%

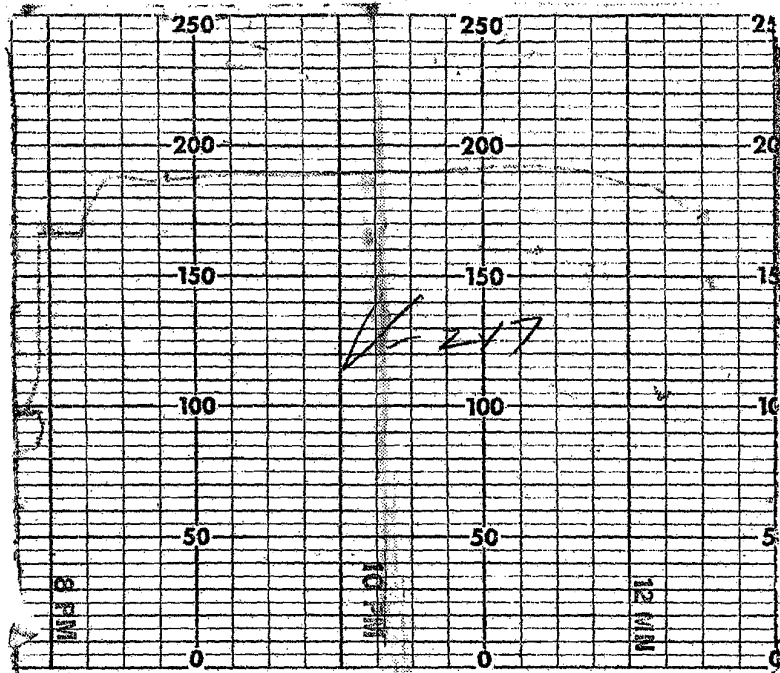
385 130 RUN 31" (238 G) WATER INTO V-385 & HEAT TO
 7 135-140°F
 131 DUMP IN & STIR TO DISSOLVE 530 15-A 530

302 132 ADD 42" (514 G) WATER TO V-302
 8 133 ADD & STIR 2 MIN 330 7-D 165

SV 134 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 9 135 SET PUMP AT ZERO SETTING
 136 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
 137 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
 RECORD: START 6:30 A.M.
 138 RUN IN V-385 FROM S 31 & STIR 5 MIN
 RECORD: PH 3.4 (3.4-3.8) & IF NECESSARY ADJ
 (DOWN ONLY) TO 3.4-3.8 & RECORD: PH
 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
 139 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5
 MIN
 140 RECORD: PH 6.4 (6.2-6.4) & IF NECESSARY ADJ TO
 PH 6.2-6.4. 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
 141 POUR IN STIR 15 MIN 50 978-A 50
 142 STOP AGITATOR

START FINISH OPERATOR
 3:00 P 11:00 P 235-37
 11:00 PM 7:00 AM 201-381
 7:00 A 8:45 A 259





No. 215A250

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