

CG 04 CODE KD-789-D PKG PROCESSES APPROVED BY  
 EST'D WGT 1032 LBS MAY -0.81- 21531 ( ) KD-789-D (I) FWP 01/16/81  
 STANDARD HRS. 10.8 TIME \_\_\_\_\_ M ( ) ( ) ( ) ( )  
 JOB NAME: 04K0789-DMI

CG CODE PQ LOT LBS  
 01 YC016B 93 E1234 400  
 01 YC016B 93 E1229 1150  
 01 YC016B 93 E1223 2650  
 YC-116 72335 80 (2-bags)  
 (PK)

TOTAL EST'D WGT 5232 5312 REQ. NO. (10251) NON-BLEEDING

| EQUIP     | NAME : "KROLOR" ORANGE Y                                           | USE<br>LBS  | NCODE  | ACCT<br>LBS |
|-----------|--------------------------------------------------------------------|-------------|--------|-------------|
| 211 & 208 | 1 ✓ RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.    |             |        |             |
|           | 2 ✓ WEIGH IN DRUM AND POUR IN                                      | 530         | 32-D   | 530         |
|           | 3 ✓ DUMP IN AND STIR 5 MIN                                         | 84X50       | YC16B  | 4200        |
| 1         | RECORD: START <u>12:11</u> <u>E1234</u>                            | <u>400</u>  |        |             |
|           | FIN <u>1:11 P.M.</u> <u>E1229</u>                                  | <u>1150</u> |        |             |
|           |                                                                    | <u>2650</u> |        |             |
|           | 4 ✓ ADJUST TO 75" (1275 G)                                         | 2x40        | YC-116 | 80          |
|           | 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. <u>40</u> " & ADJUST TO 54" (1890G)           |             |        |             |
|           | 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY                      |             |        |             |
| 208 & SV  | 9 ✓ RUN 10" (514 G) WATER INTO V-208. START                        |             |        |             |
|           | AGITATOR & INSTALL TEMP CHART                                      |             |        |             |
|           | 10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.                 |             |        |             |
|           | RECORD: TIME START <u>1:51</u> TOTAL MINUTES <u>160</u>            |             |        |             |
| 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                              | 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: <u>1.082</u> G/ML (1.082-1.086)               |             |        |             |
| SV        | 18 ✓ WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)              |             |        |             |
|           | 19 ✓ RECORD: PH <u>10.7</u> & ADJ TO 11.1-11.3 USING N-7-D         |             |        |             |
| 4         | AT 5% (10 PARTS WATER TO 1 PART N-7-D)                             |             |        |             |
|           | ASSUME 50%                                                         | <u>30</u>   | 7-D    | <u>15</u>   |
|           | SIPHON N-7-D INTO SV & RECORD: PH <u>11.3</u>                      |             |        |             |
|           | 20 ✓ HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____ °F             |             |        |             |
|           | & RECORD: <u>190</u> °F                                            |             |        |             |
|           | NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING. |             |        |             |

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✓ 21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO  
343 V-343  
& 422 METER IN FROM V-386 M.16, 11.44 L/GAL, 35.0 GAL  
386 423 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 2:45 4:50 P 2:25  
V-349 4:00 P 2:25  
TIME V-343 V-349 SV NORMAL  
INCHES INCHES PH PH  
AT 20 MIN 12.35 (49) 4.9 (20) 9.9 (9.3-10.0)  
40 MIN 12.55 (45) 4.9 (18) 9.9 (9.3-10.0)  
1 HR 14.5 (41) 4.9 (16) 9.9 (9.3-10.0)  
2 1/4 HR 2:30 (25) 4.9 (8) 9.9 (9.3-10.0)  
3 1/2 HR 3:45 (9) 4.9 (0) 9.9 (9.3-10.0)  
FINISH 4:50 (0) 4.9 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 40" (308 G) WATER INTO V-385 & HEAT TO  
7 135-140°F  
34 DUMP IN & STIR TO DISSOLVE 530 15-A 530

302 32 ADD 42" (514 G) WATER TO V-302  
B 33 ADD & STIR 2 MIN 330 7-D 165

SV 434 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &  
SET PUMP AT ZERO SETTING  
9 435 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &  
TURN OFF PUMP MOTOR  
436 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM  
RECORD: START 4:50 P  
437 RUN IN V-385 FROM S 31 & STIR 5 MIN  
438 RECORD: PH 3.25 (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 500  
N-15-A. STIR SV 5 MIN AFTER EACH ADDITION  
439 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5  
MIN  
440 RECORD: PH 6.2 (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  
441 POUR IN STIR 15 MIN ✓ 50 978-A 50  
442 STOP AGITATOR

N-15 Pumped  
28 MIN

START FINISH OPERATOR  
3:00 P 4:50 P 235-244  
7:00 A 3:00 P 120-301  
8:00 P 6:25 P 235-244