CG 04 CODE KO-789-D-3 NOV 80 FOG 37690

EST'D WGT 1032 LBS 11-AM

STANDARD HRS. 10.8 TIME ____ M

PROCESSES
( ) KO-789-D (I)
( ) ( )
( ) ( )
( ) ( )
TYPED BY: FWP 9/18/80

APPROVED BY
FWP 9/18/80

OK

CG	CODE	PQ	LOT	LBS
01	YC016B	93	36366	2000
01	YC016B	93	36361	2000
01	YC016B	93	36409	200

RUNCHED & CHECKED
NOV - 7 1980

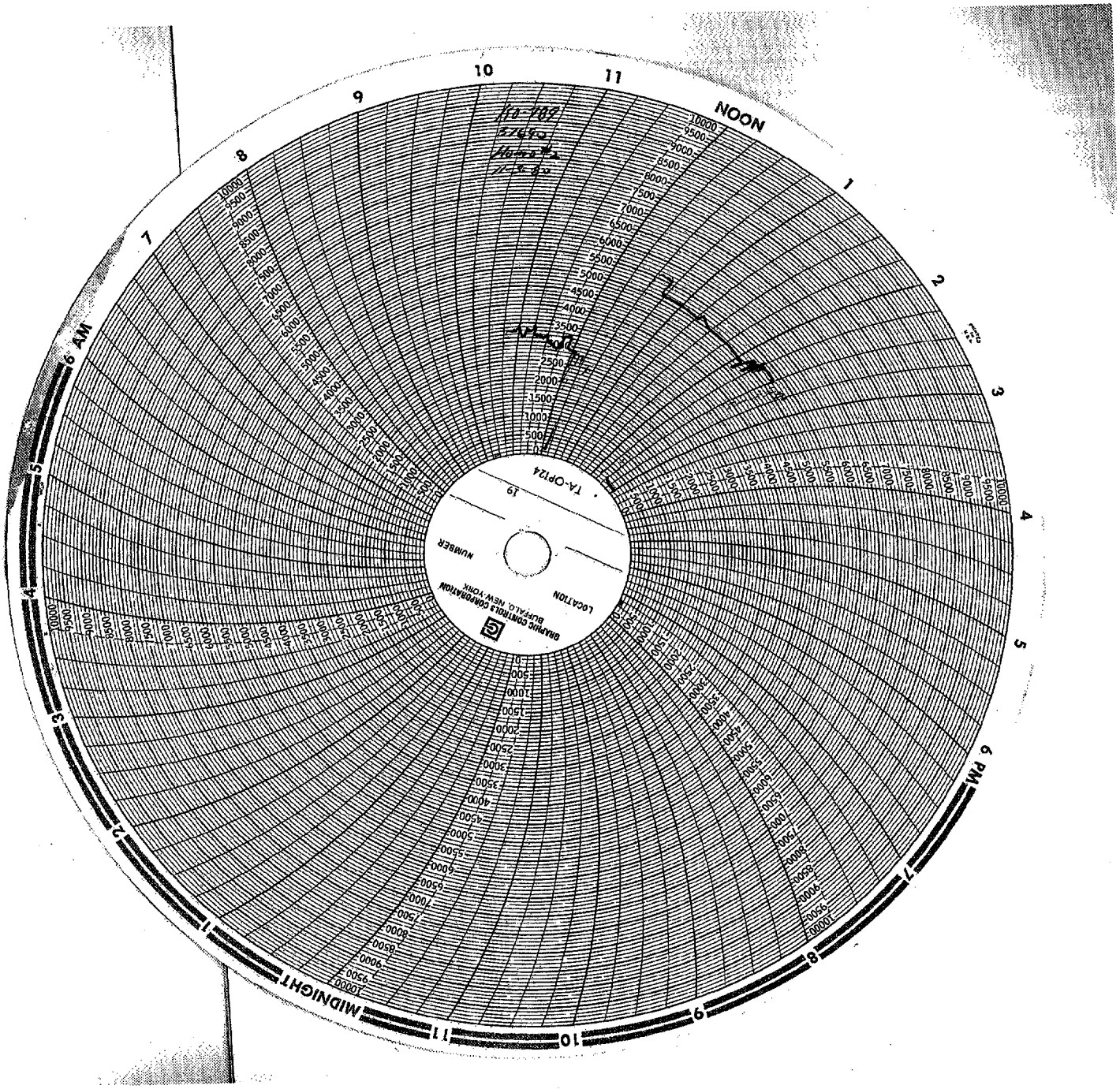
TOTAL EST'D WGT 5232 REQ. NO.( ) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60"(990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.		983	
	2	WEIGH IN DRUM AND POUR IN	530	32-D	530
	3	DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
		RECORD: START 7:30 LOT 36366	2000		
1		FIN 10:30 LOT 36361	2000		
		LOT 36409	200		
	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 & SV 2	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 12:10 TOTAL MINUTES 130			
		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	11	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
		WHEN V-208 MT, RUN IN 5"(240 G) WATER & PUMP			
		THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384 3	12	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120*F		983	
	14	WEIGH INTO V-384 & PUMP TO V-349	2545	32-D	2545
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.084 G/ML (1.082-1.086)			
SV 4	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.8 & ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
		ASSUME 50%	4	721 N-7-D	4
		SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT 192 *F & RECORD: 192 *F		2M	
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

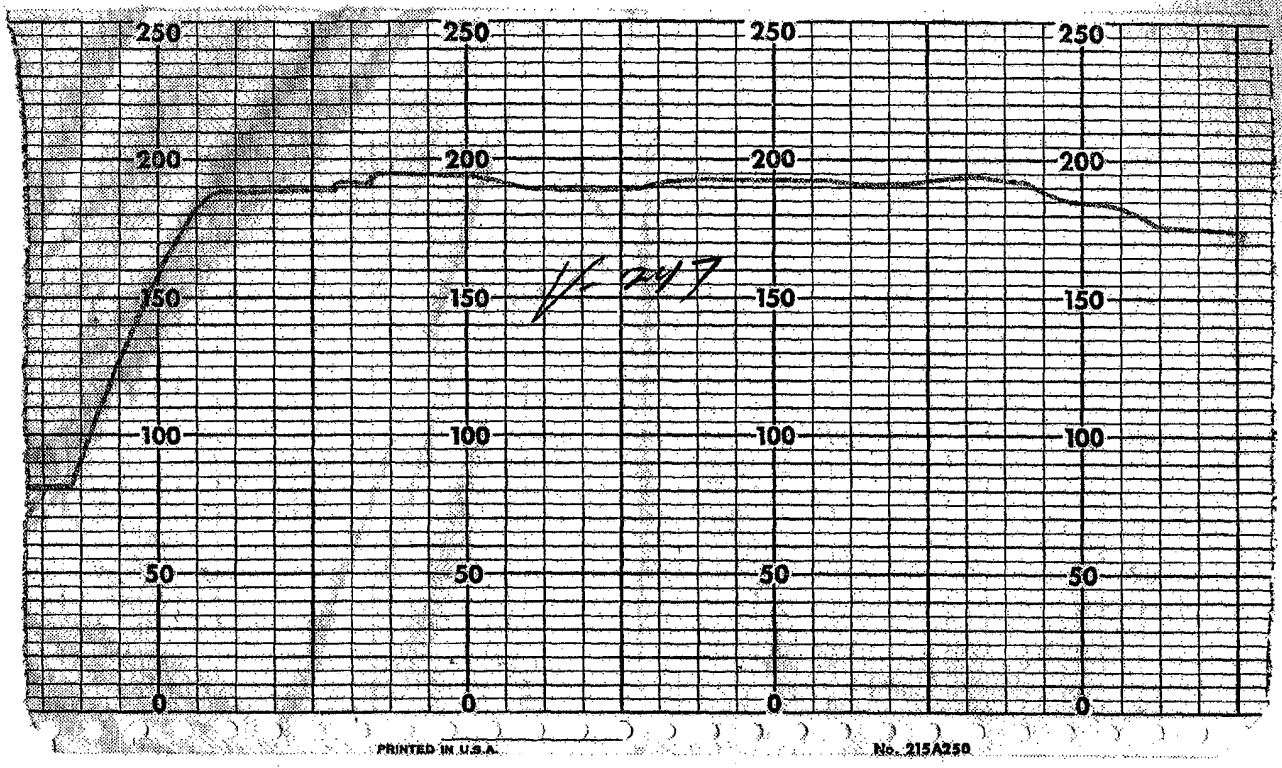
EQUIP		PAGE 2 CG 04 KO-789-D EST WGT 5232# V-247	USE LBS	N-CODE	USE LBS
	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M 66, 9.053 #/GAL, 43.1 GAL		27-D	390
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.020 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
	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 8:45 Am 1:15 Pm 255			
		V-349 8:45 Am 12:30 Pm 210			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 9:05 Am (49) 49 (20) 20 9.6 (9.3-10.0)			
		40 MIN 9:25 Am (45) 45 (18) 18 9.6 (9.3-10.0)			
		1 HR 9:45 Am (41) 41 (16) 16 9.6 (9.3-10.0)			
		2 1/4 HR 11:0 Am (25) 25 (8) 8 9.5 (9.3-10.0)			
		3 1/2 HR 12:30 Pm 9) 9 (0) 0 9.5 (9.3-10.0)			
		FINISH 1:15 Pm (0) 0 7.0 (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			
	31	DUMP IN & STIR TO DISSOLVE	530	15-A	530
302	32	ADD 42" (514 G) WATER TO V-302			
8	33	ADD & STIR 2 MIN	330	7-D	165
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	STIR 30 MIN AT 190-194*F, THEN TURN OFF STEAM			
		RECORD: START ____			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.5 (3.4-3.8) & IF NECESSARY ADJ			
		(DOWN ONLY) TO 3.4-3.8 & 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 10-12 MIN & STIR 5 MIN			
	40	RECORD: PH 5.7 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.4 ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	20	727-D	20
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN	✓ 50	978-A	50
	42	STOP AGITATOR			

START	FINISH	OPERATOR
11:00 PM	7:00 PM	237-244
300 P	345 P	209

DUP050104816



DUP050104817



DUP050104818