

NOV 10 1982

L2J56

5179*

PROCESSES APPROVED BY: () KD-789-D (I) FWP 11/04/82
COMTYP JOB NAME: 04KD789DMI

(DATE) (LOT) (EST WGT)
WAREHOUSE REQUEST NO. 11028

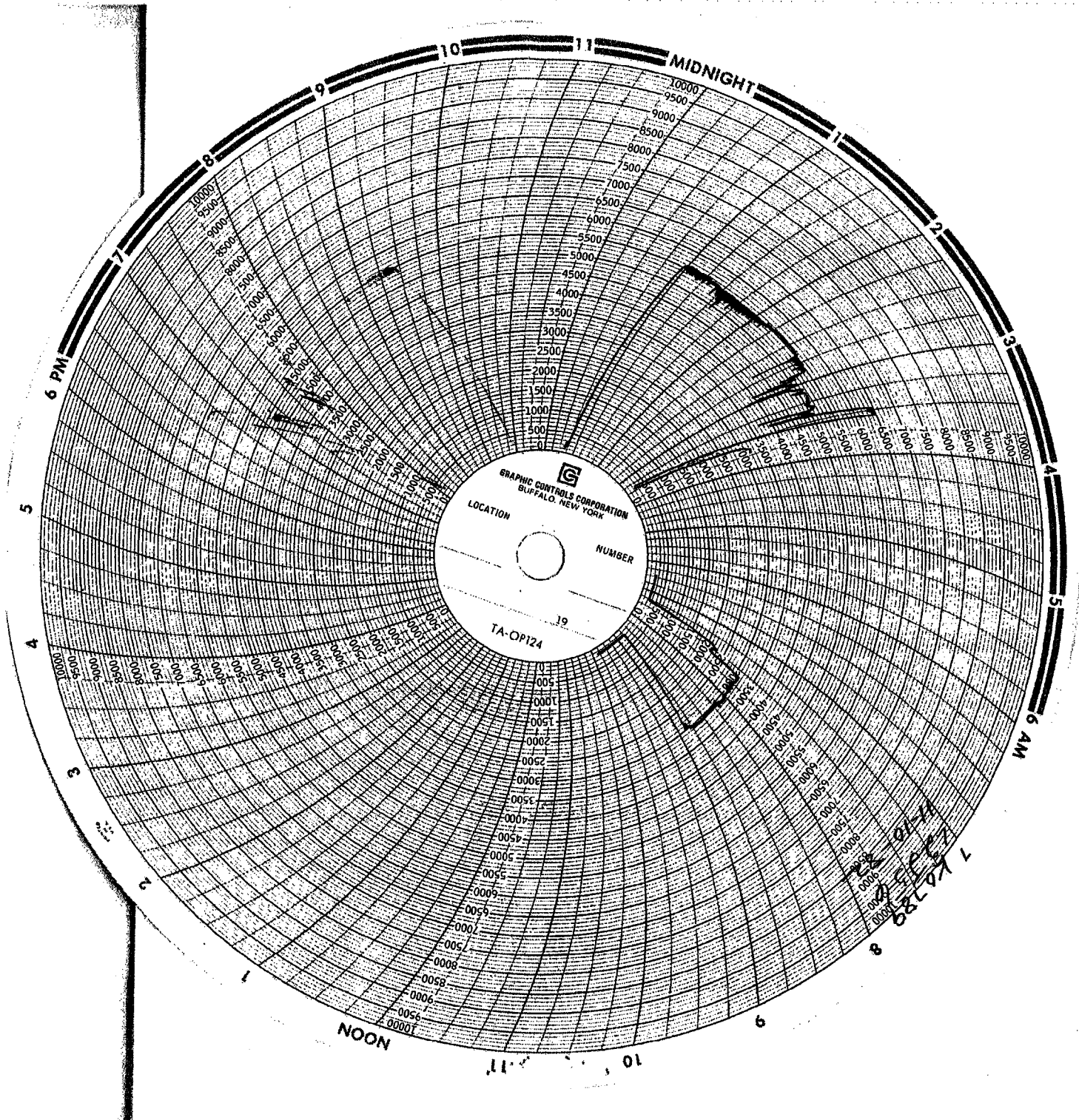
LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC016B	93	<u>D2140</u>	<u>2000</u>	100.00	<u>40</u>	50	<u>2000</u>	<u>2000</u>
	01	YC016B	93	<u>K2H23</u>	<u>2200</u>	100.00	<u>44</u>	50	<u>2200</u>	<u>2200</u>
	01	YC016B	93			100.00		50		
	01	YC016B	93			100.00		50		
	01	YC016B	93			100.00		50		

EQUIP	NAME : 'KROLOR' ORANGE Y	NON-BLEEDING	USE LBS	N-CODE	ACCT LBS
211 & 208	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF. 1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED. 2 WEIGH IN DRUM AND POUR IN (SODIUM SILICATE) 3 DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE) RECORD: START <u>2:30 Am</u> <u>D2K40</u> FIN <u>2:40 Am</u> <u>K2H23</u>		530	32-D	530
1	4 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. RECORD PH: <u>10.7</u> (9.0-10.5) 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>4.2</u> " & ADJUST TO 54" (1890G) 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY		84X50	YC16B	4200
208 & SV	9 RUN 10" (514 G) WATER INTO V- <u>246</u> START AGITATOR & INSTALL TEMP CHART 10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>10:10 A</u> TOTAL MINUTES <u>150</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 15 RUN 1000# WATER INTO V-384 & PUMP TO V-349 3 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN 17 RECORD DENSITY: <u>1.086</u> G/ML (1.082-1.086)		2545	32-D	2545
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G) 19 RECORD: PH <u>10.8</u> & ADJ TO 11.1-11.3 USING N-7-D (CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% 4 SIPHON N-7-D INTO SV & RECORD: PH <u>11.2</u> 20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>190</u> *F & RECORD: <u>190</u> *F. STRIKE MUST START IMMEDIATELY			7-D	

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EQUIP	MENT	PAGE 2	CG 04	KO-789-D	USE	N-	ACCT
					LBS	CODE	LBS
343	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO					
&	22	V-343					
386	22	METER IN (SULFURIC ACID 60%) FROM V-386				27-D	390
5	23	M 28.12014 = /GAL 35.4 GAL					
	23	STIR 15 MIN OR LONGER					
	24	RECORD: DENSITY 1.020 G/ML (1.018-1.020)					
		NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE.					
		BE SURE HOSE IS NOT IN UNDERSURFACE STRIKE LINE					
SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2					
6	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					
		AT 190-194°F DURING STRIKE					
	29	RECORD: START FINISH MINUTES					
		V-343 5:35A 230					
		V-349 205					
		TIME V-343 V-349 SV NORMAL					
		INCHES INCHES PH PH					
		AT 20 MIN 5:55 (49) 49 (20) 20 10.0 (9.3-10.0)					
		40 MIN 6:15 (45) 45 (18) 18 10.0 (9.3-10.0)					
		1 HR 6:35 (41) 41 (16) 16 9.8 (9.3-10.0)					
		2 1/4 HR 7:50 (25) 24 (8) 8 9.5 (9.3-10.0)					
		3 1/2 HR 8:05 (9) 8 (0) 0 9.3 (9.3-10.0)					
		FINISH 8:50 (0) 0 7.4 (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	ADD 67" (514 G) WATER TO V-385					
7	31	ADD & STIR 2 MIN			330	7-D	165
SV	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &					
8	33	SET PUMP AT ZERO SETTING					
	34	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &					
		TURN OFF PUMP MOTOR					
	34	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM					
		RECORD: START 8:20					
	35	RUN IN LIQUID ALUM USING BADGER METER	848		1060	115-D	530
	36	FLUSH ALM LINE WITH WATER					
	37	RECORD: PH 3.8 (3.4-3.8) & IF NECESSARY ADJ					
		(DOWN ONLY) TO 3.4-3.8 & RECORD: PH					
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA					
		BADGER METER. STIR 5 MIN AFTER EACH					
		ADDITION. ASSUME 50%				115-D	
	38	RUN IN N-7-D FROM S31 IN 10-12 MIN & STIR 5 MIN					
	39	RECORD: PH 6.2 (6.2-6.4) & IF NECESSARY ADJ TO					
		PH 6.2-6.4. RECORD: PH 6.2				27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER				7-D	2.5
		ASSUME 50%			50		
		SIPHON N-7-D INTO SV					
	40	POUR IN (PLASTOLEIN 9746A) & STIR 15 MIN			50	978-A	50
	41	STOP AGITATOR					
		START FINISH OPERATOR					
		2 PM 3 PM 438					
		1:00 PM 7:00 PM 122					
		7 AM 11:50 438					



m 8 15
T 9 16
W 10 17
Th 11
F 12