

CG 04 CODE KD-909-D PKG PROCESSES APPROVED BY
 JUN 3 1982 F2H78 () KD-909-D (C) FWP 03/25/82
 DATE LOT NUMBER
 STD. HRS. TIME 7 A.M. JOB NAME: 04K0909DMC

CG	CODE	PQ	LOT	LBS
01	YC-16-B	94	F1288	100
01	YC-16-B	93	B2H74	350
01	YC-16-B	93	C2J27	3000
01	YC-16-B	93	B2H78	300

EST. WT. 5243* LBS. REQ. NO. (10829) NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
	2 WEIGH IN DRUM AND POUR IN	480	32-D	480
	3 DUMP IN AND STIR 5 MINS. RECORD: START 13:05 LOT C2J27 3000	75X50	YC16B	3750
1	FIN 13:55 F1288 100			
	4 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.	350		
	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 OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 49" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-247, START AGITATOR & INSTALL TEMP CHART			
	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 10:30P TOTAL MINUTES 135			
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	2500	32-D	2500
	14 WEIGH INTO V-384 & PUMP TO V-349			
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
417	RECORD DENSITY: 1.092 G/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
4	19 RECORD: PH 9.6 & ADJ TO 11.1-11.3 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	60	7-D	30
	20 SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT *F			
	& RECORD: *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

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✓ 21 WHILE HEATING SV, RUN 49" (1348 G) WATER INTO
 343 V-343
 & ✓ 22 METER IN FROM V-386 M 17 10318 / GAL, 36.2 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 9.9
 ✓ 26 SET V-343 ACID PUMP AT 69 SETTING (225 MIN)
 ✓ 27 SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)
 ✓ 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 SV AT 190-194°F DURING STRIKE
 6 RECORD: START FINISH MINUTES
 V-343 210 6:10 AM 240
 V-349 5:10 AM 180
 TIME V-343 V-349 SV NORMAL
 INCHES INCHES PH PH
 AT 20 MIN 230 (46) (17) 9.1 (9.3-10.0)
 40 MIN 250 (41) (15) 9.6 (9.3-10.0)
 1 HR 310 (37) (13) 9.6 (9.3-10.0)
 2 HRS 410 (23) (6) 9.6 (9.3-10.0)
 3 HRS 510 (10) (0) 9.4 (9.3-10.0)
 FINISH 555 (0) 7.5 (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%

✓ 30 STEP IN 50 120 A 50

385 ✓ 31 ADD 60" (465 G) WATER TO V-385
 7 ✓ 32 ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50% 296 7-D 148

✓ 33 DURING STRIKE CHECK LEVEL IN V-387.
 387 ✓ 34 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37
 8 ✓ 35 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING
 THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE
 ✓ 36 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW
 STEARATE MAKE-UP PROCEDURE.

✓ 37 RUN IN 27" (268 GAL). DO NOT MAKE UP THIS
 SOLUTION MORE THAN 30 MINUTES IN ADVANCE.
 DELAY BETWEEN END OF STEP 43 HEAT-UP AND
 START OF STEP 53 HOMOGENIZATION SHOULD BE
 LESS THAN 30 MINUTES.
 388 ✓ 38 TURN ON STEAM & AGITATOR
 9 ✓ 39 ADJUST TO 37" (366 GAL) AT 178-182°F
 ✓ 40 SET BADGER METER FOR 590#
 ✓ 41 PUMP IN FROM V-387 THRU UNDERSURFACE
 DISTRIBUTORS AS FAST AS POSSIBLE 482 169-A 482
 54 155-A 54
 54 160-A 54
 ✓ 42 SHUT OFF PUMP
 ✓ 43 STIR 30 MIN AT 178-182°F FOR S 53
 ✓ 44 DO NOT SHUT OFF AGITATOR

SV ✓ 45 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 SET PUMP AT ZERO SETTING
 10 ✓ 46 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
 ✓ 47 STIR 60 MIN AT 190-194°F 7:10 AM

EQUIP* | PAGE 3 CG 04 KO-909-D
 MENT | COMTYP JOB NAME: 04KO909DMC

USE | N- | ACCT
 LBS | CODE | LBS

SV	10	CONT				
148	148		HEAT TO 198-200°F IN 5-10 MIN			
149	149		CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
150	150		OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
151	151		OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
152	152		WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
153	153		IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
154	154		WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
155	155		WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
156	156		TURN OFF HOMOG & STEARATE PUMP			
157	157		STIR 5 MIN AT 198-200°F			
158	158		SHUT OFF STEAM			
159	159		RUN IN ALUM USING BADGER METER	950	115-D	475
160	160		FLUSH ALUM LINE WITH WATER			
161	161		RECORD: PH <u>3.2</u> (3.4-3.8)			
162	162		IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH ____ . NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN. AFTER EACH ADDITION. ASSUME 50%		115-D	
163	163		RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
164	164		RECORD: PH <u>6.4</u> (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH ____ . ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%		27-D	
165	165		SIPHON N-7-D INTO SV		7-D	
166	166		DO NOT STOP AGITATOR			

830
7.00

1100 P
9.15 PM

126-301
342-320



