

CG 04 CODE KO-789-D PKG

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS

DEC -5 80 38165

() KO-789-D (I)

FWP 11/20/80

STANDARD HRS. 10.8 TIME _____ M

JOB NAME: 04KO789-DMI

CG	CODE	PQ	LOT	LBS
01	YC016B	93	36036	200
01	YC016B	93	37621	1350
01	YC016B	93	37620	1100
01	YC-16-B	93	37816	1550

Homog #2

**CLEAN UP
AS YOU GO ALONG**

TOTAL EST'D WGT 5232

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 3 DUMP IN AND STIR 5 MIN RECORD: START <u>8 AM</u> <u>36036</u> FIN <u>9:30 AM</u> <u>37621</u> <u>37620</u> <u>37816</u>	540 84X50 200 1350 1100 1550	983-D YC16B	540 4200
1	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. <u>42</u> " & ADJUST TO 54" (1890G) 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V- <u>211</u> , START & AGITATOR & INSTALL TEMP CHART SV <u>10</u> PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>1:30 A</u> TOTAL MINUTES <u>120</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	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 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>1.084</u> G/ML (1.082-1.086)	2600	983-D	2600
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 4 AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH <u>11.2</u> 20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____ °F & RECORD: _____ °F NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.		7-D	<u>25</u>

N34644

DUP050104744

V-247

343	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
&	22	METER IN FROM V-386 M22, 9.622 GAL 46.3 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 10.1			
	26	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)			
	27	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)			
SV	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 4:45 AM 9:30 27.5			
		V-349 8:40 23.5			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 5:05 (49) (20) 9.7 (9.3-10.0)			
		40 MIN 5:25 (45) (18) 9.7 (9.3-10.0)			
		1 HR 5:45 (41) (16) 9.4 (9.3-10.0)			
		2 1/4 HR 7:00 (25) (8) 9.4 (9.3-10.0)			
		3 1/2 HR 8:15 (9) (0) 9.4 (9.3-10.0)			
		FINISH 9:00 (0) 6.5 (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%	27-D		
385	30	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	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 9:25			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.6 (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 5.8 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.3	27-D		
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	6	7-D	3
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN	50	978-A	50
	42	STOP AGITATOR			
		START 9:30A FINISH 3:00P OPERATOR 37-235			
		11:00P 7:00 AM 11:45 AM 259 101			



