

JUN 4 1982

F2H80

APPROVED BY () KO-909-D (C) FWP 03/25/82

DATE

LOT NUMBER

STD. HRS.

TIME

7 A.M.

JOB NAME:

04KO909DMC

CG	CODE	PG	LOT	LBS
01	YC-16-B	94	34399	150✓
01	YC-16-B	93	02K64	2000✓
01	YC-16-B	93	02H52	1150✓
01	YC-16-B	93	02H78	450✓

EST. WT. 5243* LBS.

REQ. NO. (10831)

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
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. LOT 34399	75X50	YC16B	3750
1	RECORD: START 11:15 PM	150		
	FIN 12:30 PM	2000		
	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.	1150		
5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208	450		
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. 55" & ADJUST TO 54" (1890G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	1 RUN 10" (514 G) WATER INTO V-246, START			
	AGITATOR & INSTALL TEMP CHART			
SV	2 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 2:20 PM TOTAL MINUTES 150			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
close AIR	1 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			
384	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	14 WEIGH INTO V-384 & PUMP TO V-349	2500	32-D	2500
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.0922/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	19 RECORD: PH 10.5 & ADJ TO 11.1-11.3 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH 11.3			
20	HEAT TO 190-194°F IN 55-65 MIN & REC HT 190°F			
	& RECORD: 190°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

JUN 10 1982

V-46

343	121	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO			
&	122	V-343 METER IN FROM V-386 M 12 103/8 GAL 36.2 GAL		27-D	373
386	123	STIR 15 MIN OR LONGER			
5	124	RECORD: DENSITY 1.020 G/ML (1.018-1.020)			
	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 8.0			
	126	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)			
	127	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)			
SV	128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
6	129	AT 190-194°F DURING STRIKE			
		RECORD: START FINISH MINUTES			
		V-343 7:00 10:55 2:55			
		V-349 7:00 10:10 1:10			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 7:20 (46) 44 (17) 18 9.9 (9.3-10.0)			
		40 MIN 7:40 (41) 39 (15) 16 8.9 (9.3-10.0)			
		1 HR 7:55 (37) 36 (13) 14 8.5 (9.3-10.0)			
		2 HRS 8:00 (23) 23 (6) 7 8.5 (9.3-10.0)			
		3 HRS 8:00 (10) 10 (0) 1 8.5 (9.3-10.0)			
		FINISH 10:45 (0) 5.7 (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	
	130	DIFF IN	50	120 A	50
385	131	ADD 60" (465 G) WATER TO V-385			
7	132	ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50%	296	7-D	148
	133	DURING STRIKE CHECK LEVEL IN V-387.			
387	134	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37			
8	135	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING			
		THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	136	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW			
		STEARATE MAKE-UP PROCEDURE.			
	137	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	138	TURN ON STEAM & AGITATOR			
9	139	ADJUST TO 37" (366 GAL) AT 178-182°F			
	140	SET BADGER METER FOR 590#			
	141	PUMP IN FROM V-387 THRU UNDERSURFACE	482	169-A	482
		DISTRIBUTORS AS FAST AS POSSIBLE	54	155-A	54
			54	160-A	54
	142	SHUT OFF PUMP			
	143	STIR 30 MIN AT 178-182°F FOR S 53			
	144	DO NOT SHUT OFF AGITATOR			
SV	145	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &			
		SET PUMP AT ZERO SETTING			
60	146	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &			
		TURN OFF PUMP MOTOR			
	147	STIR 60 MIN AT 190-194°F 10:50 P			

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

USE | N- | ACCT
 LBS | CODE | LBS

SV	48	HEAT TO 198-200°F IN 5-10 MIN			
10	49	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
CONT	50	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
	51	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
	52	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
	53	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
	54	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
	55	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
	56	TURN OFF HOMOG & STEARATE PUMP			
	57	STIR 5 MIN AT 198-200°F			
	58	SHUT OFF STEAM			
	59	RUN IN ALUM USING BADGER METER	950	115-D	475
	60	FLUSH ALUM LINE WITH WATER			
	61	RECORD: PH <u>3.5</u> (3.4-3.8)			
	62	IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH <u>3.5</u> . NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN. AFTER EACH ADDITION. ASSUME 50%		115-D	
	63	RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
	64	RECORD: PH <u>6.3</u> (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH <u>6.3</u> ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	60	27-D 7-D	30
	65	SIPHON N-7-D INTO SV			
		DO NOT STOP AGITATOR			

7:00 AM
 300 P

3:00 PM

320-342
 126-301



