CG 04 CODE KO789D PKG
MAY 6 35612
EST'D WGT ~~1032~~ 1032 LBS
STANDARD HRS. 10.8 TIME 3H M

PROCESSES
( ) KO789D (I)
( ) ( )
( ) ( )
( ) ( )
TYPED BY: FWP 4/28/80

APPROVED BY
FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	34710	350#
01	YC016B	93	34835	1500#
01	YC016B	93	34656	2350#

PUNCHED & CHECKED
MAY - 8 198

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

HIP		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.			
	2	WEIGH IN DRUM AND POUR IN	530	32-D	530
	3	DUMP IN AND STIR 5 MINS. LOT	84X50	YC16B	4200
		RECORD: START 3.30 P			
1		FIN 5.30 P			
	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 OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7	RECORD:V-208 VOL. 45 " & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 10" (514 G) WATER INTO V-245 & START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1200A TOTAL MINUTES 100			
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	2545	32-D	2545
	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: 1.086 G/ML (1.082-1.086)			
SV	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.7 & 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%	10	7-D	5
		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.			

(JK)

N32375

PAGE 2 CG 04 KO-789-D EST WGT 5232# V-245

		USE LBS	N- CODE	
21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
22	METER IN FROM V-386 M 11.06 #/GAL, 35.3 GAL		27-D	390
23	STIR 15 MIN OR LONGER			
24	RECORD: DENSITY 1.018 GM/ML (1.018-1.020)			
25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2			
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 5:30A / 9:50A / 260			
	V-349 ---- / 9:10AM / 220			

	TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
AT 20 MIN	5:50A	(49)	(20)	9.9	(9.3-10.0)
40 MIN	6:10A	(45)	(18)	9.9	(9.3-10.0)
1 HR	6:30A	(41) 40	(16) 16	9.9	(9.3-10.0)
2 1/4 HR	7:45A	(25) +	(8) 9	9.9	(9.3-10.0)
3 1/2 HR	9:00A	(9) 10	(0) 1	9.95	(9.3-10.0)
FINISH	9:50A	(0)		9.3	(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: 8.3 PH			
	ASSUME 77%	60	27-D	40
30	RUN 33" (238 G) WATER INTO V-356 & HEAT TO 135-140*F			
31	DUMP IN & STIR TO DISSOLVE	530	15-A	530
32	ADD 42" (514 G) WATER TO V-302			
33	ADD & STIR 2 MIN	330	7-D	165
34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING.			
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 10:00AM			
37	RUN IN V-356 FROM S 31 & STIR 5 MIN			
38	RECORD: PH 3.65 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH ----			
	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 6.7 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4 & RECORD: PH 6.3			
	ASSUME 77%	12	27-D	----
	DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	----	7-D	----
	SIPHON N-7-D INTO SV			
41	POUR IN STIR 15 MIN	50	978-A	50
42	STOP AGITATOR			

	START	FINISH	OPERATOR
	11:00P	7:00A	259
	7:00A	11:30AM	235

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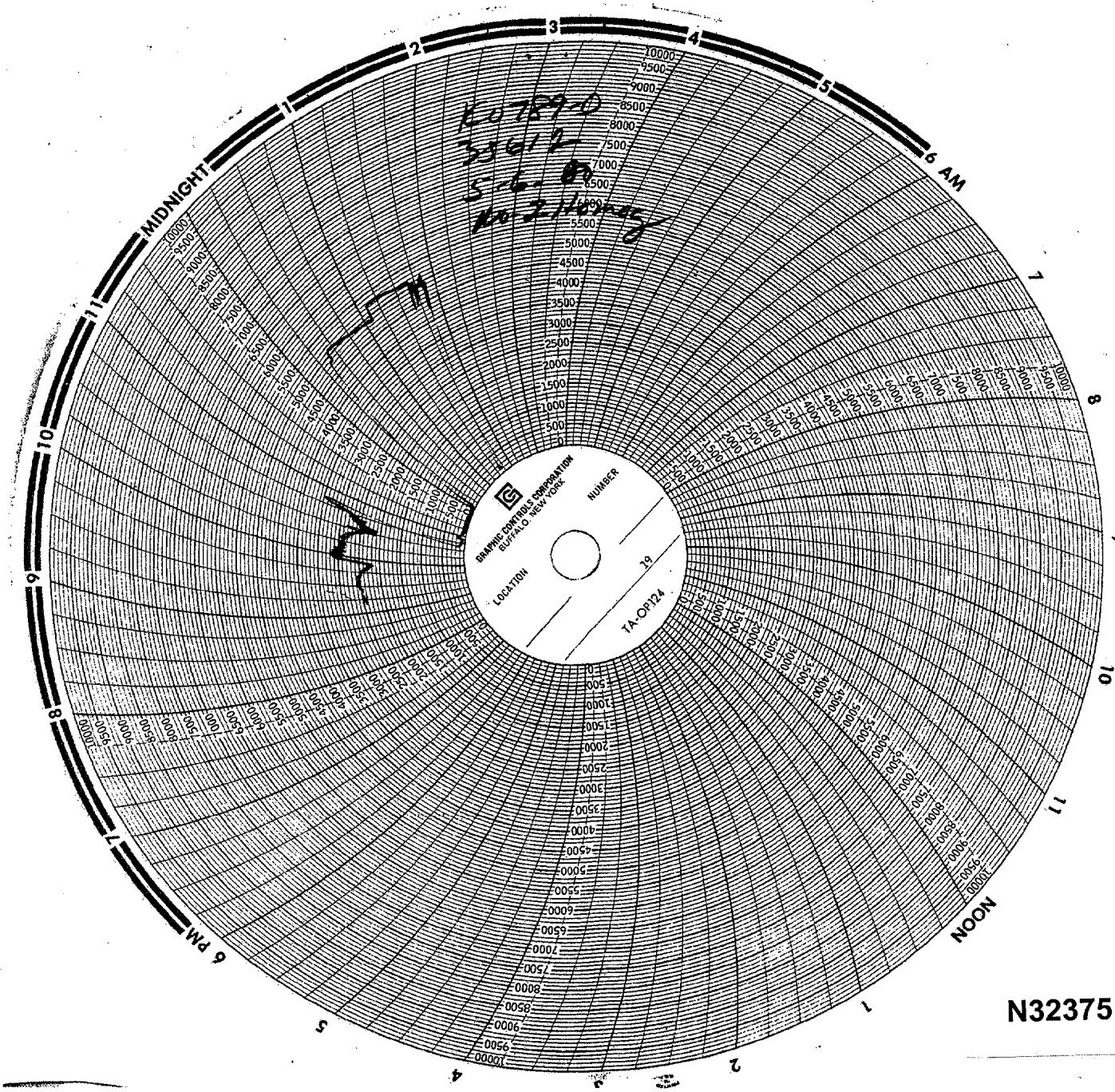

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V-245

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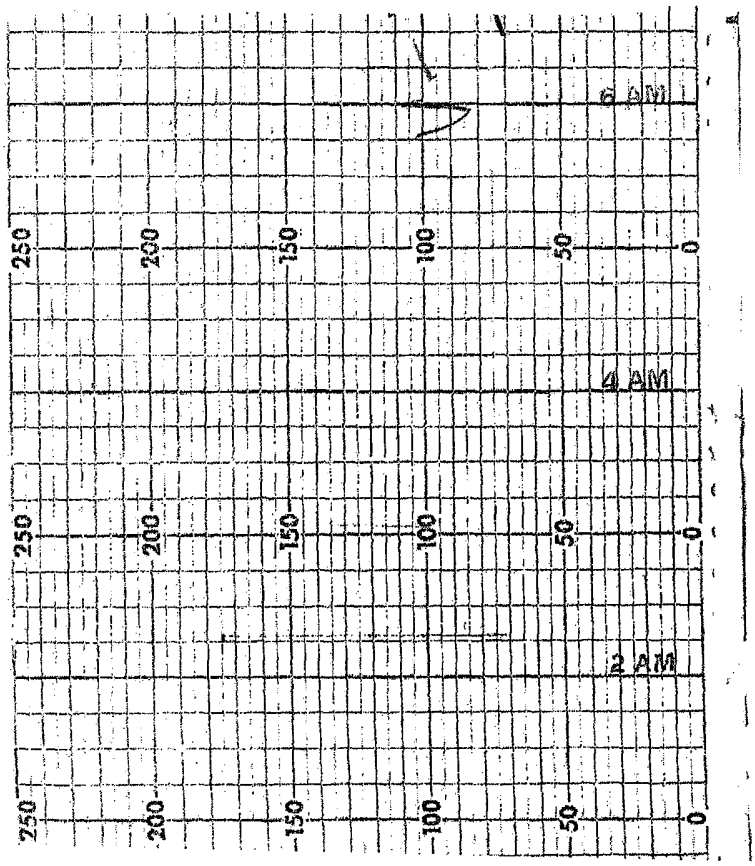

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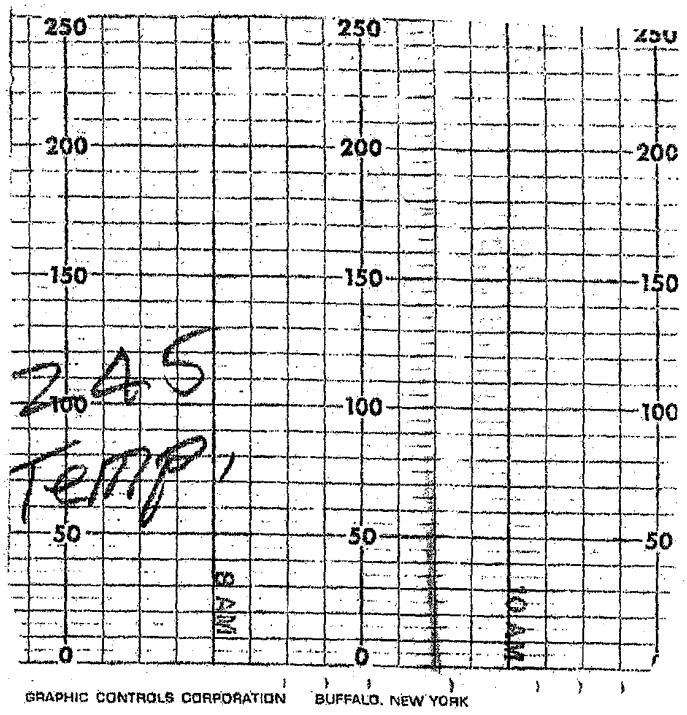

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