

EST'D WGT 1032 LBS DEC -4 80 38150

STANDARD HRS. 10.8 TIME 7 A M

( ) KD-789-D (1) FWP 11/20/80  
( ) ( )  
( ) ( )  
( ) ( )  
JOB NAME: 04KD789-DMI

| CG | CODE   | PQ | LOT   | LBS       |
|----|--------|----|-------|-----------|
| 01 | YC016B | 93 | 36036 | 260       |
| 01 | YC016B | 93 | 36350 | 50        |
| 01 | YC016B | 93 | 37667 | 2900 2050 |
| 01 | YC016B | 93 | 37710 | 1050 1900 |

**CLEAN UP  
AS YOU GO ALONG**

TOTAL EST'D WGT 5232

REQ. NO. ( )

NON-BLEEDING

| EQUIP | NAME : "KROLOR" ORANGE Y                                                                   | USE<br>LBS | NCODE | ACCT<br>LBS |
|-------|--------------------------------------------------------------------------------------------|------------|-------|-------------|
| 211   | RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.                                |            |       |             |
| 208   | WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN                                           | 540        | 983-D | 540         |
|       | RECORD: START 8:45 AM LOT 36036                                                            | 84X50      | YC16B | 4200        |
|       | FIN 9:35 AM LOT 36350                                                                      | 200        |       |             |
|       | ADJUST TO 75" (1275 G) LOT 37667                                                           | 50         |       |             |
|       | WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208               | 2050       |       |             |
|       | WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208       | 1900       |       |             |
|       | RECORD: V-208 VOL. 50" & ADJUST TO 54" (1890G)                                             |            |       |             |
|       | INSPECT HOMOG STRAINER & CLEAN IF NECESSARY                                                |            |       |             |
| 208   | RUN 10" (514 G) WATER INTO V-247. START AGITATOR & INSTALL TEMP CHART                      |            |       |             |
| SV    | PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 6:45 TOTAL MINUTES 120  |            |       |             |
| 2     | NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208 |            |       |             |
|       | WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV          |            |       |             |
| 349   | WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349                                               |            |       |             |
|       | RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F                                             |            |       |             |
| 384   | WEIGH INTO V-384 & PUMP TO V-349                                                           | 2600       | 983-D | 2600        |
|       | RUN 1000# WATER INTO V-384 & PUMP TO V-349                                                 |            |       |             |
| 3     | ADJ V-349 TO 22" (1040 G) & STIR 15 MIN                                                    |            |       |             |
|       | RECORD DENSITY: 1.0756/ML (1.082-1.086)                                                    |            |       |             |
| SV    | WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)                                           |            |       |             |
|       | RECORD: PH 10.8 & ADJ TO 11.1-11.3 USING N-7-D                                             |            |       |             |
| 4     | AT 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                                                     |            |       |             |
|       | HEAT TO 190-194°F IN 55-65 MIN & RECORD: _____°F                                           |            |       |             |
|       | & RECORD: _____°F                                                                          |            |       |             |
|       | NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.                         |            |       |             |

N34620

V-247

343 21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343  
 & 22 METER IN FROM V-386 M 22,967 GAL 403 GAL  
 386 23 STIR 15 MIN OR LONGER  
 5 24 RECORD: DENSITY 1.020 G/ML (1.018-1.020)

27-D 390

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0  
 26 SET V-343 ACID PUMP AT 45 SETTING (255 MIN)  
 27 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)  
 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV  
 SV AT 190-194°F DURING STRIKE

| RECORD:   | START         | FINISH        | MINUTES        |
|-----------|---------------|---------------|----------------|
| V-343     | 11:10 AM      | 3:35 PM       | 265            |
| V-349     | 11:11 AM      | 2:45 PM       | 215            |
| TIME      | V-343         | V-349         | SV NORMAL      |
|           | INCHES        | INCHES        | PH PH          |
| AT 20 MIN | 11:30 (49) 49 | (20) 20       | 9.8 (9.3-10.0) |
| 40 MIN    | 11:50 (45) 45 | (18) 18       | 9.8 (9.3-10.0) |
| 1 HR      | 12:10 (41) 42 | (16) 17       | 9.8 (9.3-10.0) |
| 2 1/4 HR  | 1:30 (25) 26  | (8) 10        | 9.5 (9.3-10.0) |
| 3 1/2 HR  | 2:40 (9) 10   | (0) —         | 9.5 (9.3-10.0) |
| FINISH    | 3:25 (0) 2    | 8.1 (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 3:35 PM

37 RUN IN V-385 FROM S 31 & STIR 5 MIN  
 38 RECORD: PH 3.2 (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

15-A

39 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN  
 40 RECORD: PH 4.7 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.2 ASSUME 77%  
 DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%  
 SIPHON N-7-D INTO SV  
 41 POUR IN STIR 15 MIN  
 42 STOP AGITATOR

36 27-D 18  
 50 978-A 50

START 8:45 PM  
 3 PM  
 11:10 AM  
 FINISH 3:00 PM  
 11 PM  
 6:10 PM  
 OPERATOR 370-235-197  
 282-342  
 54

