CG 04 CODE KO-786-D PKG

JUN 25 36307

EST'D WGT 862 LBS

STANDARD HRS. 10.5 TIME 7PM

PROCESSES
( ) KO-786-D (P)
( ) ( )
( ) ( )
( ) ( )

APPROVED BY
FWP 5/22/80

TYPED BY: FWP 5/22/80.

CG	CODE	PQ	LOT	LBS
1 01	YC010B	93	73241	50 ← will look yellow
38 01	YC010B	93	34410	1900
31 01	YC010B	93	34405	1550
13 01	YC690D	98	31698X	650
				4150#

83

OK
AP

PUNCHED & CHECKED

JUN 30 1980

TOTAL EST'D WGT ~~4962~~ 5012 REQ. NO.( ) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2	WEIGH IN DRUM AND POUR IN	270	32-D	270
	3	DUMP IN AND STIR 5 MIN LOT	3X50	YC10B	~~4100~~ 4150
		RECORD: START 4PM 34405 -	1550		
1		FIN 6PM 31698 -	650		
		73241	50		
		ADJUST TO 75" (1275 G) 34410	1900		
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208			
	6	WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208			
	7	RECORD: V-208 VOL. 44 " & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 15" (771 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 9:45/A TOTAL MINUTES 150			
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	2400	32-D	2400
	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: 1.079 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.6 & ADJ TO 10.4-10.8 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 ____			
	20	HEAT TO 190-194*F. IN 55-[illegible] MIN. & REC:HT 190 *F & RECORD: 190 *F			

N34525

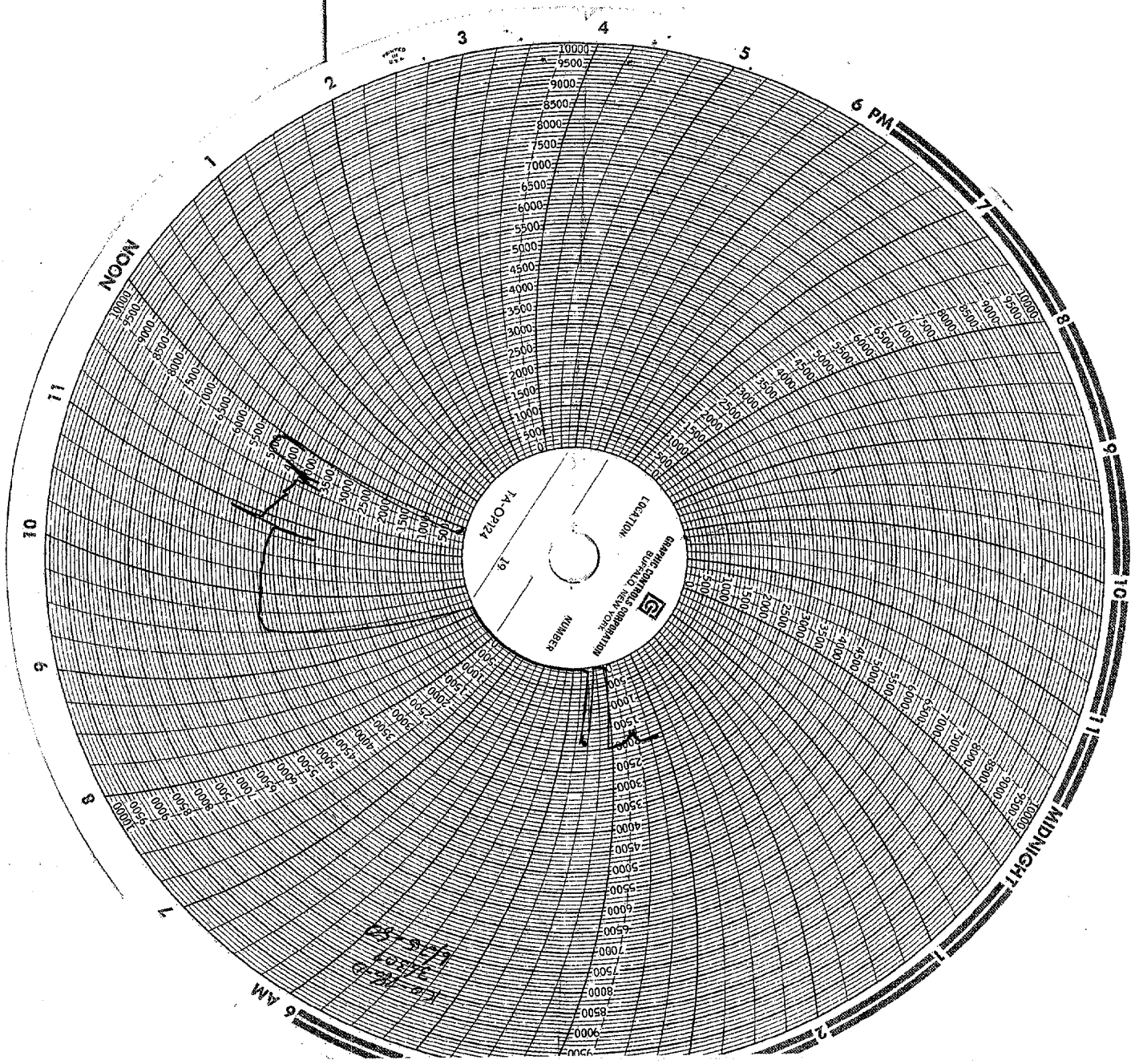
DUP050104296

V-245

			LBS	CODE	LBS
343 & 386 5	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
	22	METER IN FROM V-386 M 1046 #/GAL, 33.9 GAL		27-D	355
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.020 G/ML ( )			
SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.8			
	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194*F DURING STRIKE			
	29	RECORD: START / FINISH / MINUTES V-343 1:30P / 5:30P / 245 V-349 / 4:40P / 190 TIME / V-343 INCHES / V-349 INCHES / SV PH / NORMAL PH AT 20 MIN 1:50P (47) (20) 9.6 (9.3-10.0) 40 MIN 2:10P (43) (17) 9.6 (9.3-10.0) 1 HR 2:30P (38) + (15) + 9.7 (9.3-10.0) 2 HR 3:30P (24) 27- (7) + 9.75 (9.3-10.0) 3 HR 4:30P (10) 14 (0) 1 9.7 (9.3-10.0) FINISH 5:30P (0) 6.8 (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 7	30	RUN 31" (238 G) WATER INTO V-385 & HEAT TO 135-140*F			
	31	DUMP IN & STIR TO DISSOLVE	300	15-A	300
302 8	32	ADD 42" (514 G) WATER TO V-302			
	33	ADD & STIR 2 MIN	150	7-D	75
SV 9	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	TURN OFF STEAM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.25 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & 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 4-6 MIN & STIR 5 MIN			
	40	RECORD: PH 3.8 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.0 ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	16	7-D	8
		SIPHON N-7-D INTO SV			
	41	STOP AGITATOR			

START	FINISH	OPERATOR
11:Pm	7:Am	223
700A	300P	54-259
3:00P	6:20PM	335-323

DUP050104297



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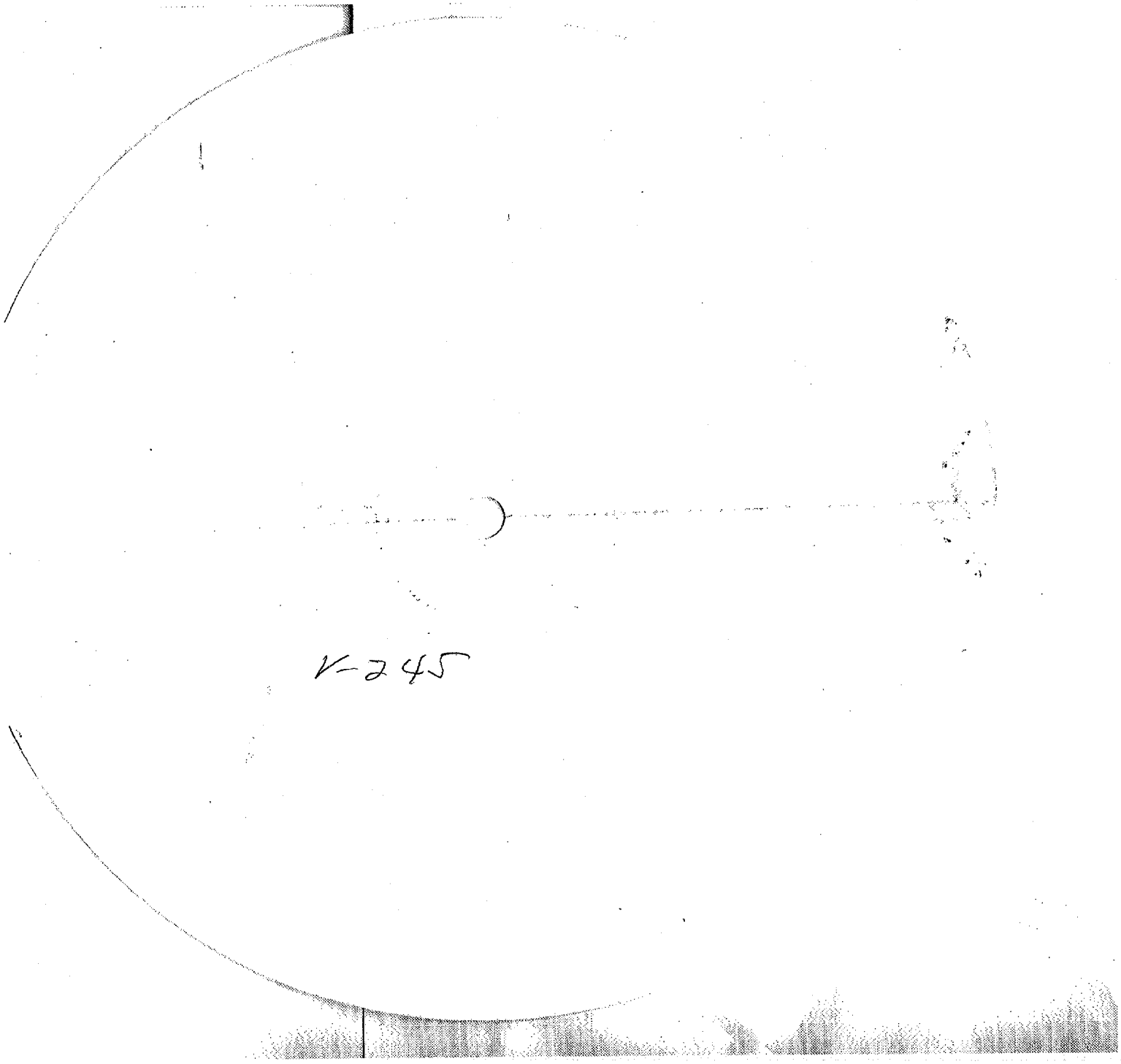
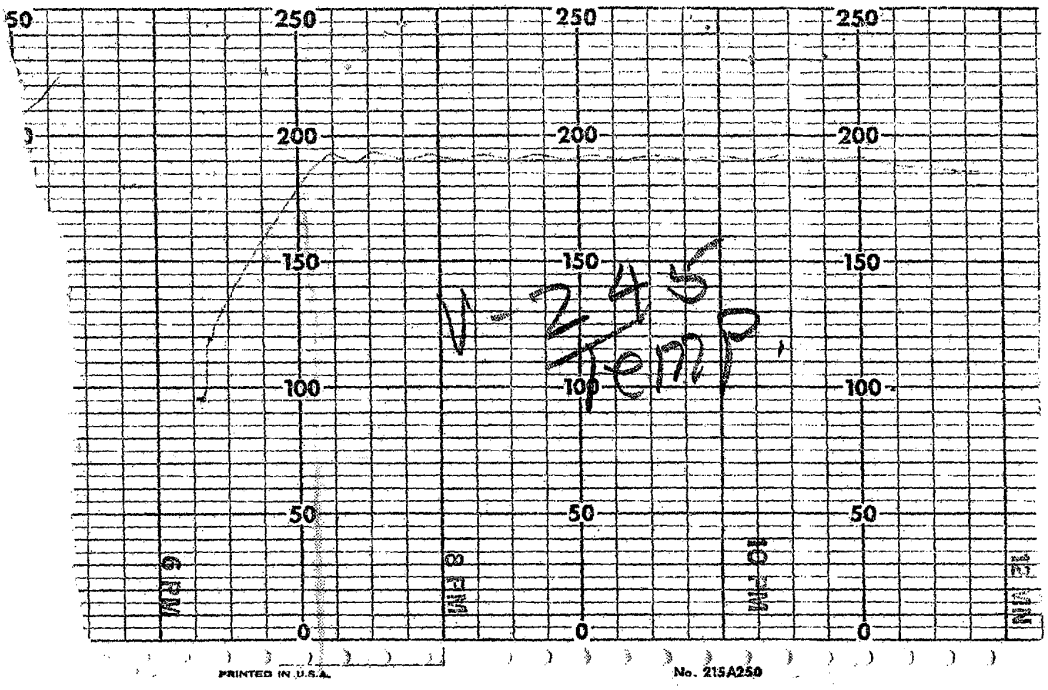

K-245



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