

CG 04 CODE KD-784-D PKG

JUL -7-80 36402

EST'D WGT 862 LBS

STANDARD HRS. 10.5 TIME

7A M

PROCESSES APPROVED BY
() PUNCHED & CHECKED ()
() ()
() ()

JUL 10 1980

TYPED BY: FWP 5/22/80

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36165	200
01	YC010B	93	36141	1700
01	YC010B	93	36142	2200

Jb

Homog #2

V-247 Mit

Rec 8-247 At 9:30 Pm

TOTAL EST'D WGT 4962

5162

REQ. NO. (

JUL 8, 1980

NON-BLEEDING

DUP	NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACT LBS
1	V 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 DUMP IN AND STIR 5 MIN	270	32-D	270
	RECORD: START 11-PM LOT 36142 FIN 130 AM 36141	2200 1700	YC10B	4100
	ADJUST TO 75" (1275 G)	200		
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. 42" & ADJUST TO 50" (1840G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
9	V RUN 15" (771 G) WATER INTO V-247 START AGITATOR & INSTALL TEMP CHART			
10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 9:30 PM TOTAL MINUTES 180			
11	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
12	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
13	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
14	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
15	WEIGH INTO V-384 & PUMP TO V-349	2400	32-D	2400
16	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
17	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
18	RECORD DENSITY: 1.081 G/ML (1.078-1.081)			
19	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			
20	RECORD: PH 10.6 & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH			
21	HEAT TO 190-194°F IN 55-65 MIN. & REC: HT			
	& RECORD: *F			

N34523

U-247

METER FROM V-386

41.10.85 32.7

27-D 355

IS 4IN OF LONGER

DND DENSITY 1.019 G/ML

WHEN 3 20 HEATING COMPLETE, RECORD PH 10.4
 SET V-343 ACID PUMP AT 72 SETTING (225 MIN)
 SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)
 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 AT 190-194°F DURING STRIKE

RECORD:	START	FINISH	MINUTES
V-343	2:05 AM	8:00 AM	235
V-349	2:05 AM	5:15 AM	190

TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
AT 20 MIN	2:25 (47) 48	(20) 21	10.2	(9.3-10.0)
40 MIN	2:45 (43) 44	(17) 18	10.0	(9.3-10.0)
1 HR	3:05 (38) 39	(15) 16	10.0	(9.3-10.0)
2 HR	4:05 (24) 25	(7) 8	10.0	(9.3-10.0)
3 HR	5:05 (10) 12	(0) 1	10.0	(9.3-10.0)
FINISH	6:00 (0) 1		8.0	(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

RUN 31" (238 G) WATER INTO V-385 & HEAT TO 135-140°F

PUMP IN & STIR TO DISSOLVE

300

15-A

300

ADD 42" (514 G) WATER TO V-302

ADD & STIR 2 MIN

150

7-D

75

WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING

WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR

36 TURN OFF STEAM & SIFT IN

200

128-A

200

RUN IN V-385 FROM S 31 & STIR 5 MIN

RECORD: PH 3.5 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & 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 4-6 MIN & STIR 5 MIN

40 RECORD: PH 5.5 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.2

ASSUME 77%

20

27-D

DILUTE N-7-D 10 TO 1 WITH WATER

ASSUME 50%

7-D

SIPHON N-7-D INTO SV

41 STOP AGITATOR

START

1:30A

FINISH

7:00A

OPERATOR

235-144-B23

7-7-80-7:00A

3:00P

235

8:00PM

11:00PM

201.381

7:00A

8:00A

235



