

CG 04 CODE K0789D

PKG

PROCESSES

APPROVED BY

JUN 13 36123

() K0789D

(I)

FWP 4/28/80

EST'D WGT - 1032 LBS

STANDARD MRS. 10.8

TIME 7 AM

TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	35918	3100
01	YC016B	93	29930	500
01	YC016B	93	34186	300
01	YC016B	93	35865	300
04	K0909D	92	22769	356

Homog # 2

for SV at S-29-A

TOTAL EST'D WGT 5232

REQ. NO. (JUN 13 1980

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACC LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MINS. LOT	84X50	YC16B	4200
	RECORD: START 23:20 H 35918	1000		
	FIN 12 M 34186	1300		
	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 40 " & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 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 11:45 AM TOTAL MINUTES 135			
	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	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	14 WEIGH INTO V-384 & PUMP TO V-349	2545	32-D	2545
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.084 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 10.5 & ADJ TO 11.1-11.3 USING N-7-D			
	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	20	7-D	10
	SIPHON N-7-D INTO SV & RECORD: PH 11.2			
20	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 184 °F			
	& RECORD: 191 °F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

EQUIP

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

USE

N-

USE

LBS

CODE

LBS

V-247

121 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO
 343 V-343
 & 122 METER IN FROM V-386 M38-10.86/GAL, 35.9
 386 123 STIR 15 MIN OR LONGER
 5 124 RECORD: DENSITY 10.19 GM/ML (1.018-1.020)

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2
 126 SET V-343 ACID PUMP AT 65 SETTING (255 MIN)
 127 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)
 128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 SV AT 190-194°F DURING STRIKE.

129 RECORD: START FINISH MINUTES
 V-343 6:15 AM 11:00 AM 22.5
 V-349 6:15 AM 10:00 AM 22.5
 TIME V-343 V-349 SV NORMAL
 INCHES INCHES PH PH
 AT 20 MIN 6:35 (49) (20) 10.0 (9.3-10.0)
 40 MIN 6:55 (45) (18) 10.0 (9.3-10.0)
 1 HR 7:15 (41) (16) 9.9 (9.3-10.0)
 2 1/4 HR 8:30 (25) (8) 9.9 (9.3-10.0)
 3 1/2 HR 9:45 (9) (0) 9.9 (9.3-10.0)
 FINISH 10:30 (0) 6.7 (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

200 Dump in one drum KO-909-D 32769 ASSUME 77% 27-D
 385 130 RUN 38" (238 G) WATER INTO V-343 & HEAT TO 135-140°F DC=530% V356 KO-909-D 356
 7 131 DUMP IN & STIR TO DISSOLVE 530 15-A 530

132 ADD 42" (514 G) WATER TO V-302
 8 133 ADD & STIR 2 MIN 330 7-D 160

134 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 SET PUMP AT ZERO SETTING.
 135 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR.
 136 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
 RECORD: START
 137 RUN IN V-385 FROM S 31 & STIR 5 MIN
 138 RECORD: PH 3.1 (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

139 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5
 MIN

140 RECORD: PH 6.2 (6.2-6.4) & IF NECESSARY ADJ TO
 PH 6.2-6.4 & RECORD: PH ASSUME 77% 27-D

DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 7-D

SIPHON N-7-D INTO SV

141 POUR IN STIR 15 MIN 50 978-A 50

142 STOP AGITATOR

START
 12:15 A

FINISH
 7:00 AM

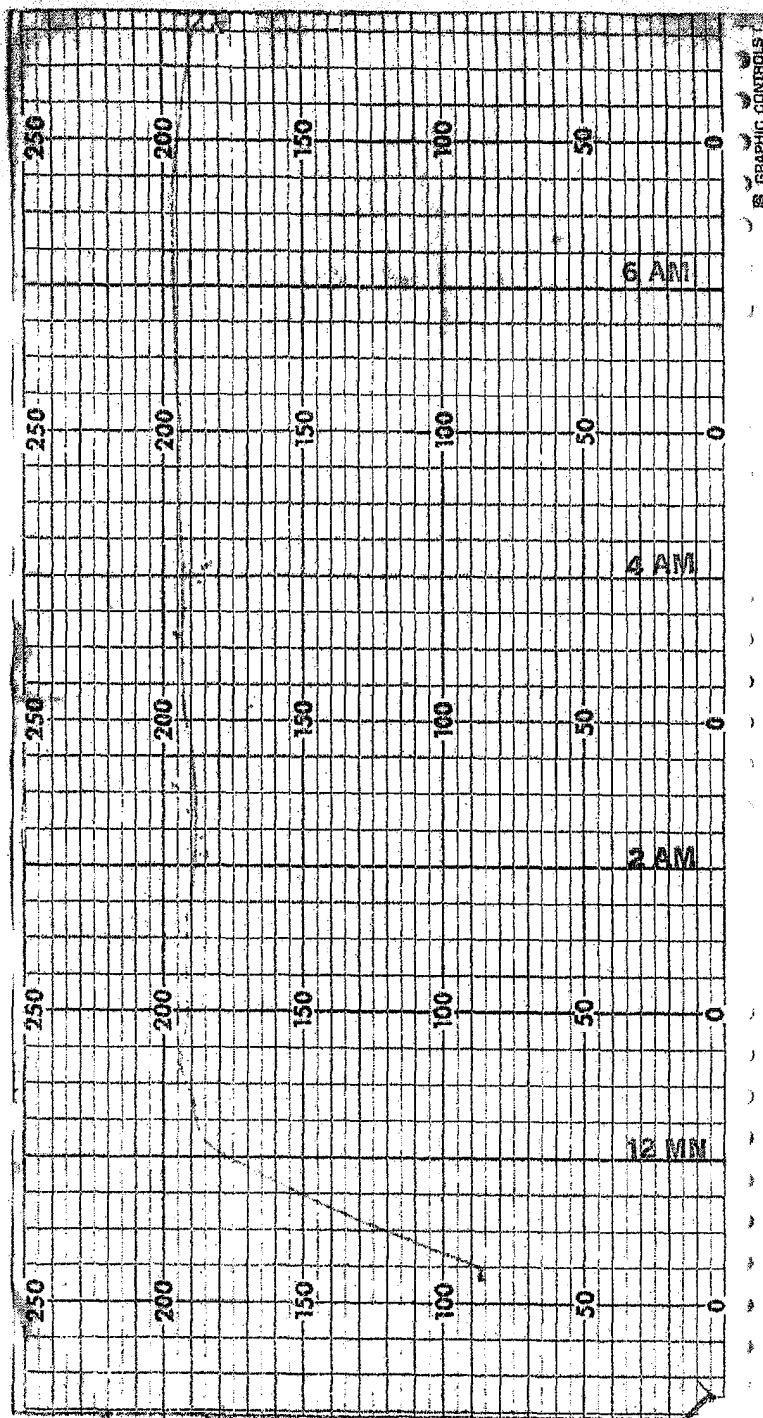
OPERATOR
 235-323

7:00 AM

7:00 AM

401

V-247



N32355.02

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