

CG 04 CODE KO-789-D PKG

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS MAY -0.81-1528 9

() KO-789-D (I)

FWP 01/16/81

STANDARD HRS. 10.8 TIME _____ M

() ()

JOB NAME: 04K0789-DMI

CG	CODE	PQ	LOT	LBS
01	YC016B	93	81225	1450
01	YC016B	93	39516	1300
01	YC016B	93	81231	1450

YC-16 98 72335

80 (2 bags)

Received Item # 2
AT 1:05 PM

Note step 37-

TOTAL EST'D WGT 5232 5312

REQ. NO. (10V42)

NON-BLEEDING

EQUIP	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 MIN LOT	84X50	YC16B	4200
1	RECORD: START <u>1:10</u>			
	FIN <u>8:32</u>			
	4 ADJUST TO 75" (1275 G)	2x40	YC16-B	80
	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 HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. <u>10</u> & ADJUST TO 54" (1890C)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-208, START AGITATOR & INSTALL TEMP CHART			
	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>10:10</u> TOTAL MINUTES <u>150</u>			
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 13 MIN			
	17 RECORD DENSITY: <u>1.082</u> G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
4	19 RECORD: PH <u>10.7</u> & ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	30	7-D	15
	SIPHON N-7-D INTO SV & RECORD: PH <u>11.3</u>			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>MAY 26 1981</u>			
	& RECORD: _____ #F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

343 21 WHILE HEATING SV, RUN (52) (1430 G) WATER INTO V-343
 & 22 METER IN FROM V-384 **M 16, 11.46# / GAL 35.0 GAL 35.0** 27-D 390
 386 23 STIR 15 MIN OR LONGER
 5 24 RECORD: DENSITY **1.018** G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH **10.3**
 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	2:25 PM	7:00 PM	4:35
V-349	6:15 PM	7:00 PM	45

	TIME	V-343	V-349	SV	NORMAL
		INCHES	INCHES	PH	PH
AT 20 MIN	2:45	(49)	(20)	10.0	(9.3-10.0)
40 MIN	3:05	(45)	(18)	10.0	(9.3-10.0)
1 HR	3:35	(41)	(16)	10.0	(9.3-10.0)
2 1/4 HR	4:40	(25)	(8)	9.8	(9.3-10.0)
3 1/2 HR	6:55	(9)	(0)	9.7	(9.3-10.0)
FINISH	6:40	(0)		7.9	(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%

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
 37 RECORD: START **7:00 PM**
 38 RUN IN V-385 FROM S 31 & STIR 5 MIN
 39 RECORD: PH **3.4** (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
 40 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN
 41 RECORD: PH **6.4** (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH _____ ASSUME 77%
 DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%
 SIPHON N-7-D INTO SV
 42 POUR IN STIR 15 MIN 50 978-A 50
 43 STOP AGITATOR

NOTE: Pumped In
 N-15
 27 MIN

START **1:05 PM** FINISH **3:00 PM** OPERATOR **235-244**
11:00 PM **7:00 PM** **301-126**
7:00 PM **8:30 AM - 235-244**