

MA-0-81
(DATE)

1392
(LOT)

9 01/16/81
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KD-906-D (C) FWP 01/16/81

STANDARD HRS.

TIME _____ M

JOB NAME: 04K0906DMC

CG	CODE	PQ	LOT	LBS
01	YC010B	93	E1050	3750
01	YC010B	93		
01	YC010B	93		

Homog #2 Repacked 6:15 AM

TOTAL EST'D WGT 5077

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.	26	7-D	13
208	2 WEIGH IN DRUM AND POUR IN	245	32-D	245
	3 DUMP IN AND STIR 5 MINS. LOT E1050	3750	YC10B	3750
1	RECORD: START 1:25 pm			
	FIN 1:30 pm			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208			
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 1800-2200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 4.2" & ADJUST TO 45" (1662G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 15" (793 G) WATER INTO V-208 & START AGITATOR & INSTALL TEMP CHART			
2	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 6:30A TOTAL MINUTES 140			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
11	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 5" (237 G) WATER INTO V-349			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
3	14 WEIGH INTO V-384 & PUMP TO V-349	2165	32-D	2165
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16 ADJ V-349 TO 20 (946 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.028 G/ML (1.078-1.081)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
4	19 RECORD: PH 10.2 & ADJ TO 10.4-10.8 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	12	7-D	6
	SIPHON N-7-D INTO SV & RECORD: PH 10.5			
20	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F & RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

DM

V-246

343 21 WHILE HEATING SV, RUN 46" (1265 G) WATER INTO V-343
 & 22 METER IN FROM V-386 M15- 1020 #/GAL 299 GAL
 386 23 STIR 15 MIN OR LONGER
 5 24 RECORD: DENSITY 1.018 G/ML (1.018-1.020)

SV 25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
 26 SET V-343 ACID PUMP AT 65 SETTING (225 MIN)
 27 SET V-349 SILICATE PUMP AT 57 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 11:30 A.M. 3:45 P. 253
 V-349 2:35 P.M. 185
 TIME V-343 V-349 SV NORMAL
 INCHES INCHES PH PH
 AT 20 MIN 11:50 A (43) (18) 9.5 (9.3-10.0)
 40 MIN 12:10 P (39) (16) 9.5 (9.3-10.0)
 1 HR 12:30 P (35) 34 (13) 14 9.5 (9.3-10.0)
 2 HRS 1:30 P (22) 23 (7) 8 9.5 (9.3-10.0)
 3 HRS 2:30 P (10) 10 (0) 0 9.5 (9.3-10.0)
 FINISH 3:45 P (0) 0 8.2 (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 31 RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F
 7 32 DUMP IN & STIR TO DISSOLVE FOR S-60 270 15-A 270

302 33 ADD 24" (295 G) WATER TO V-302
 8 34 ADD & STIR FOR 2 MIN FOR S 63 D ASSUME 50% 136 7-D 68

PT 35 DURING STRIKE PUMP INTO PT 464 169-A 464
 36 36 PUMP IN 52 155-A 52
 9 37 PUMP IN 52 160-A 52
 38 STIR 10 MIN WITH LIGHTENING MIXER FOR S 42

356 39 DURING STRIKE RUN 15" (268 G) WATER INTO V-356
 10 40 TURN ON STEAM
 41 ADJ TO 21" (366 G) AT 81-82°C
 42 PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE
 43 RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN
 44 SHUT OFF PUMP
 45 STIR 30 MIN AT 81-82°C FOR S 54
 46 DO NOT SHUT OFF AGITATOR

SV	47	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING.					
11	48	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR.					
	49	HEAT TO 198-200°F IN 5-10 MIN					
	50	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP					
	51	OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP INLET					
	52	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER					
	53	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER					
	54	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.					
	55	WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP					
	56	WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT WATER FROM HOT WATER MIXER					
	57	TURN OFF HOMOG & STEARATE PUMP					
	58	STIR 5 MIN AT 198-200°F					
	59	SHOT OFF STEAM					
	60	RUN IN V-385 FROM S-32 & STIR 5 MIN					
	61	RECORD: PH <u>3.3-3.7</u> (3.3-3.7)					
	62	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH <u> </u>					
	63	RUN IN N-7-D FROM S-34IN 4-6 MIN & STIR 5 MIN					
	64	RECORD: PH <u>4.0-4.2</u> (4.0-4.2) & IF NECESSARY, ADJ TO PH 4.0-4.2 & RECORD: PH <u> </u> ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50% SIPHON N-7-D INTO SV				27-D	
	65	DO NOT STOP AGITATOR				7-D	

START	FINISH - O PER
11:00P	7:00/AM - 235-244
7:00A.M	3:00PM - 381-201
3:00P	5:30P - 126-259