

10/11/82

K2K02

5179*

 () K0-789-D (I) FWP 10/04/82
 COMTYP JOB NAME: 04K0789DMI

 (DATE) (LOT) (EST WGT)
 WAREHOUSE REQUEST NO. 1099.3

3 P.M.

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC016B	93	K2H20	3300	100.00	66	50	3300	3300
	01	YC016B	93	D2K39	800	100.00	16	50	800	800
	01	YC016B	98	F2H88	100	100.00	2	50	100	100
	01	YC016B	93	H1018	100	100.00	2	50	100	100
	01	YC016B	93	H1278	200	100.00	4	50	200	200
	01	YC106	93	G2H92	50	100.00	1	50	50	50

EQUIP	NAME : "KROLOR" ORANGE Y	NON-BLEEDING	USE LBS	N-CODE	ACCT LBS
211	1	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF.			
208	2	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	3	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	530	32-D	530
	3	DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	84X50	YC16B	4200
		RECORD: START 330pm			
		FIN 52pm			
		LOT K2H20 = 66X50			
		D2K39 16X50			
		F2H88 2X50			
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	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. 49" & ADJUST TO 54" (1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9	RUN 10" (514 G) WATER INTO V-246, START			
SV	10	AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	2	RECORD: TIME START 1230. TOTAL MINUTES 132			
		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			
				OCT 15 1982	
349	12	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	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 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 10.8 & ADJ TO 11.1-11.3 USING N-7-D			
4		(CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
		ASSUME 50%	50	7-D	25
		SIPHON N-7-D INTO SV & RECORD: PH 11.3			
	120	HEAT TO 190-194°F IN 55-65 MIN & REC: HT ____ °F			
		& RECORD: ____ °F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			

EQUIP PAGE 2 CG 04 KD-789-D V-246 USE N- ACCT
MENT LBS CODE LBS

343 21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO
& 22 V-343
386 22 METER IN (SULFURIC ACID 60%) FROM V-386
5 23 M 25, 1145+ /GAL, 350 GAL
24 STIR 15 MIN OR LONGER
24 RECORD: DENSITY 1.019 /ML (1.018-1.020)
NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE.
BE SURE HOSE IS NOT IN UNDERSURFACE STRIKE LINE

SV 25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2
6 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 5:00 11:15 365
V-349 8:30 210
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 52.0 (49) (20) 10.0 (9.3-10.0)
40 MIN 54.0 (45) (18) 10.0 (9.3-10.0)
1 HR 6.00 (41) (16) 10.0 (9.3-10.0)
2 1/4 HR 7:15 (25) 36 (8) 10.0 (9.3-10.0)
3 1/2 HR 8:30 (9) 18 (0) 9.9 (9.3-10.0)
FINISH 9:15 (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 30 ADD 67" (514 G) WATER TO V-385
7 31 ADD & STIR 2 MIN 330 7-D 165

SV 32 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
8 33 SET PUMP AT ZERO SETTING
34 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
34 TURN OFF PUMP MOTOR
34 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
RECORD: START 11:05 AM 530
35 RUN IN LIQUID ALUM USING BADGER METER 1060 115-D 530
36 FLUSH ALM LINE WITH WATER
37 RECORD: PH 3.2 (3.4-3.8) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.4-3.8 & RECORD: PH
NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
BADGER METER. STIR 5 MIN AFTER EACH
ADDITION. ASSUME 50% 115-D
38 RUN IN N-7-D FROM S31 IN 10-12 MIN & STIR 5 MIN
39 RECORD: PH 6.3 (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
40 POUR IN (PLASTOLEIN 9746A) & STIR 15 MIN 50 978-A 50
41 STOP AGITATOR

START FINISH OPERATOR
7:00 AM 11:45 AM 522-320



