

CG 04 CODE K0-789-D PKG
 10/4/82 K2H38 5179*
 (DATE) (LOT) (EST WGT)
 WAREHOUSE REQUEST NO.

PROCESSES APPROVED BY
 () K0-789-D (I) FWP 07/28/82
 COMTYP JOB NAME: 04K0789DM1
 3 PM

LOCATN	CG	CODE	PR	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC016B	93	F2H65	300	100.00	6✓	50	300	300
	01	YC016B	93	J2K72	3200	100.00	64✓	50	3200	3200
	01	YC016B	93	J2K73	700	100.00	14✓	50	700	700
	01	YC016B	93			100.00		50		
	01	YC016B	93			100.00		50		
						XX.XX				

EQUIP	NAME : "KROLOR" ORANGE Y	NON-BLEEDING	USE LBS	NCODE	ADCT LBS
211	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."				
208	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.				
	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN		530	32-D	530
	RECORD: START 3:15 PM LOT YC16-F2H65		84X50	YC16B	4200
	FIN 4:10 PM YC16-J2K72		6		
	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.		64		
	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208		14		
	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208				
	RECORD: V-208 VOL 56 & ADJUST TO 54" (1890G)				
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY				
208	RUN 10" (514 G) WATER INTO V-246 START				
SV	AGITATOR & INSTALL TEMP CHART				
	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV				
	RECORD: TIME START 7 PM TOTAL MINUTES 160				
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208				
	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV				
349	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349				
384	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F		2545	32-D	2545
	WEIGH INTO V-384 & PUMP TO V-349				
	RUN 1000# WATER INTO V-384 & PUMP TO V-349				
	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN				
	RECORD DENSITY 1.0835 G/ML (1.082-1.086)				
SV	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)				
	RECORD: PH 10.2 & ADJ TO 11.1-11.3 USING N-7-D				
	AT 5% (10 PARTS WATER TO 1 PART N-7-D)				
	ASSUME 50%		20	7-D	10
	SIPHON N-7-D INTO SV & RECORD: PH 11.4				
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT *F				
	& RECORD: *F				
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.				

USE N- IACCT
LBS CODE LBS

343 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343
386 METER IN FROM V-386 M25 11.155 GAL 34.9 GAL 478 27-D 390
5 STIR 15 MIN OR LONGER
124 RECORD: DENSITY 1.0182 G/ML (1.018-1.020)
NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE.
BE SURE THAT HOSE IS NOT IN UNDERSURFACE STRIKE LINE.

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
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 AT 190-194°F DURING STRIKE
SV 6 129 RECORD: START FINISH MINUTES
V-343 1030 305 225
V-349 210 210 210
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 1050 (49) (20) 9.9 (9.3-10.0)
40 MIN 1110 (45) (18) 9.0 (9.3-10.0)
1 HR 1130 (41) (16) 9.9 (9.3-10.0)
2 1/4 HR 1243 (25) 27 (8) 10 9.5 (9.3-10.0)
3 1/2 HR 200 (9) 11 (0) 4 7.8 (9.3-10.0)
FINISH 245 (0) 4 6.9 (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% 27-D

385 130 ADD 67" (514 G) WATER TO V-385
7 131 ADD & STIR 2 MIN 330 7-D 165

SV 132 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING
8 133 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR
134 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
RECORD: START 3.50
135 RUN IN ALUM USING BADGER METER 1060 115-A 530
136 FLUSH ALM LINE WITH WATER
137 RECORD: PH 3.5 (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%
138 RUN IN N-7-D FROM S31 IN 10-12 MIN & STIR 5 MIN 115-A
139 RECORD: PH 3.8 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.4 ASSUME 77%
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 90 27-D 45
SIPHON N-7-D INTO SV
40 POUR IN STIR 15 MIN 50 978-A 50
41 STOP AGITATOR

START FINISH OPERATOR
7:10 3:20 PM 114
342



