CG 04 CODE KO-789-D PKG

EST'D WGT 1032 LBS MAY -0·81-E1526

STANDARD HRS. 10.8 TIME _____ M

PROCESSES APPROVED BY
( ) KO-789-D (I) FWP 01/16/81
( ) ( )
( ) ( )
( ) ( )
JOB NAME: 04KO789-DMI

| CG | CODE | PQ | LOT | LBS |
|---|---|---|---|---|
| 01 | YC016B | 93 | E1222 | 80.0 |
| 01 | YC016B | 93 | 39516 | 1250 |
| 01 | YC016B | 93 | E1232 | 2150 |
| | YC-16 | 98 | 72335 | 80# (2 bags) |

VAT - 24C MT. @ 1200 AM

TOTAL EST'D WGT ~~5232~~ 5312 . REQ. NO.(10241) 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 |
| | | RECORD: START 4AM E1232 | 2150 | _____ | |
| 1 | | FIN 5:45AM 39516 | 1250 | _____ | |
| | | E1222 | 800 | _____ | |
| | 4 | ADJUST TO 75" (1275 G) | 2x40 | YC-16 | 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. 41 " & ADJUST TO 54"(1890G) | | | |
| | 8 | INSPECT HOMOG STRAINER & CLEAN IF NECESSARY | | | |
| 208 & SV | 9 | RUN 10" (514 G) WATER INTO V-246, START AGITATOR & INSTALL TEMP CHART | | | |
| | 10 | PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1:15 AM TOTAL MINUTES 140 | | | |
| 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 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 10.0 & ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D) | | | |
| 4 | | ASSUME 50% | 30 | 7-D | 15 |
| | | SIPHON N-7-D INTO SV & RECORD: PH 11.3 | | | |
| | 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. | | | |

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| EQUIP | | PAGE 2 CG-04 KO-789-D EST WGT 52320# V-246 | USE LBS | N-- CODE | USE LBS |
|---|---|---|---|---|---|
| 343 & 386 5 | 21 | WHILE HEATING SV, RUN 52* (1430 G) WATER INTO V-343 | | | |
| | 22 | METER IN FROM V-386 M 16,146 #/GAL 35.0 GAL | | 27-D | 390 |
| | 23 | STIR 15 MIN OR LONGER | | | |
| | 24 | RECORD: DENSITY 1.030 G/ML (1.018-1.020) | | | |
| | 25 | WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1 . | | | |
| | 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 | | | |
| SV | | AT 190-194*F DURING STRIKE | | | |
| | 29 | RECORD: START FINISH MINUTES | | | |
| | | V-343 5:20 9:00 PM 220 | | | |
| | | V-349 5:AM 9:55 PM 235 | | | |
| | | TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH | | | |
| | | AT 20 MIN 5:40 (49) 50 (20) 20 10.0 (9.3-10.0) | | | |
| | | 40 MIN 6:00 (45) 46 (18) 18 10.0 (9.3-10.0) | | | |
| | | 1 HR 6:20 (41) 41 (16) 16 10.0 (9.3-10.0) | | | |
| | | 2 1/4 HR 7:30 (25) 26 ( 8) 8 9.5 (9.3-10.0) | | | |
| | | 3 1/2 HR 8:30 ( 9) 10 ( 0) 1 9.0 (9.3-10.0) | | | |
| | | FINISH 9:35 ( 0) 0 8.8 ( 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: 8.2 PH | | | |
| | | ASSUME 77% | 12 | 27-D | 8 |
| 385 7 | 30 | RUN 40* (308 G) WATER INTO V-385 & HEAT TO 135-140*F | | | |
| | 31 | DUMP IN & STIR TO DISSOLVE | 530 | 15-A | 530 |
| 302 8 | 32 | ADD 42* (514 G) WATER TO V-302 | | | |
| | 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 | | | |
| LOOK | 36 | STIR 30 MIN AT 190-194*F, THEN TURN OFF STEAM | | | |
| | | RECORD: START 9:45 PM | | | |
| | 37 | RUN IN V-385 FROM S 31 & STIR 5 MIN 35 MIN. | | | |
| | 38 | RECORD: PH 3.1 (3.4-3.8) & IF NECESSARY ADJ | | | |
| | | (DOWN ONLY) TO 3.4-3.8 & RECORD: PH____ | | 15-A | |
| | | 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 | | | |
| | 39 | RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN | | | |
| | 40 | RECORD: PH 7.2 (6.2-6.4) & IF NECESSARY ADJ TO | | | |
| | | PH 6.2-6.4. RECORD: PH 6.3 ASSUME 77% | 8 | 27-D | 6 |
| | | DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% | | 7-D | |
| | | SIPHON N-7-D INTO SV | | | |
| | 41 | POUR IN STIR 15 MIN | 50 | 978-A | 50 |
| | 42 | STOP AGITATOR | | | |
| | | START 4:30 PM FINISH 7:05 PM OPERATOR 126-409 37 | | | |

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