

S.V. (247) 720
 CG 104 CODE KO-789-D PKG PROCESSES APPROVED BY
 EST'D WGT 1032 LBS MAY -0.81-21527 9 () KO-789-D (I) FWP 01/16/81
 STANDARD HRS. 10.8 TIME _____ M () ()
 JOB NAME: 04KO789-DNI

CG CODE PQ LOT LBS
 01 YC016B 93 E1232 900
 01 YC016B 93 E1235 1650
 01 YC016B 93 E1225 1650
 YC-16 98 72335 x 80 (2 bags) ✓
160

TOTAL EST'D WGT 5232 5312 REQ. NO. (10V43) NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MIN	9450	YC16B	4200
1	RECORD: START <u>11:32</u> LOT <u>E1225</u>	<u>1650</u>		
	FIN <u>1:02</u> LOT <u>E1232</u>	<u>900</u>		
	4 ADJUST TO 75" (1275 G) LOT <u>E1235</u>	<u>1650</u>		
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU	<u>4x40</u>	YC-16	<u>80</u>
	HOMOG AT 2800-3200 PSI INTO V-208			<u>160</u>
	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>40</u> & ADJUST TO 54" (1890C)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V- <u>247</u> , START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <u>6:25</u> TOTAL MINUTES <u>120</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	11 WHILE HOMOG, RUN 4" (284 G) WATER INTO V-349			
	12 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	13 WEIGH INTO V-384 & PUMP TO V-349	2545	32-D	2545
	14 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	15 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	16 RECORD DENSITY: <u>1.0825</u> G/ML (1.082-1.086)			
SV	17 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	18 RECORD: PH <u>10.7</u> & ADJ TO 11.1-11.3 USING N-7-D			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	SIPHON N-7-D INTO SV & RECORD: PH <u>11.1</u> ASSUME 50%	<u>10</u>	7-D	<u>5</u>
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____ #F			
	& RECORD <u>9.4</u> #F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-247

343 121 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343
 & 122 METER IN FROM V-386 M 16 11.146 35.0
 386 123 STIR 15 MIN OR LONGER
 5 124 RECORD: DENSITY 1.029 G/ML (1.018-1.020)

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
 SV AT 190-194°F DURING STRIKE

RECORD: START FINISH MINUTES
 V-343 11:39 4:10 PM 280
 V-349 11:39 3:15 PM 225

TIME V-343 V-349 SV NORMAL
 11:30 INCHES 55 INCHES 22 PH PH
 AT 20 MIN 11:50 (49) (20) 9.7 (9.3-10.0)
 40 MIN 12:10 (45) (18) 9.7 (9.3-10.0)
 1 HR 12:30 (41) (16) 9.5 (9.3-10.0)
 2 1/4 HR 1:45 (25) (8) 9.5 (9.3-10.0)
 3 1/2 HR 3:00 (9) (0) 7+ 9.4 (9.3-10.0)
 FINISH 3:45 (0) 7.2 (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%

385 130 RUN 40" (308 G) WATER INTO V-385 & HEAT TO
 7 135-140°F
 131 PUMP IN & STIR TO DISSOLVE 530 15-A 530

302 132 ADD 42" (514 G) WATER TO V-302
 8 133 ADD & STIR 2 MIN 330 7-D 165

SV 134 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 SET PUMP AT ZERO SETTING
 9 135 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
 LOOK 136 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
 RECORD: START 4:10 PM
 137 RUN IN V-385 FROM S 31 & STIR 5 MIN
 138 RECORD: PH 3.2 (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
 139 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5
 MIN
 140 RECORD: PH 6.4 (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
 141 POUR IN STIR 15 MIN ✓ 50 978-A 50
 142 STOP AGITATOR

START
 11:00 PM
 7:00 PM

FINISH
 2:00 PM
 3:00 PM

OPERATOR
 409-30/
 225-244