

CODE RU-785-D PKG 5084* () KD-786-D (P) FWP 09/08/82
 OCT 24/1982 K2K86 (EST WGT) COMTYP J02NAME: 04K0786DMP
 (DATE) (LOT) TIME: 5:00 A.M. STANDARD HRS. 10.5

LOCATN	CG	CODE	PR	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
01	YC-16	98		G2J23	300	100.00	6	50	300	300
01	YC-10	93		F2K69	2000	100.00	40	50	2000	2000
01	YC-10	93		J2H10	2000	100.00	40	50	2000	2000
01	YC-10	93								

SUBSTANDARD BLEND-BACK FOR S-40: CODE _____ LOT _____ PR _____
 REQ. NO. (11001) NON-BLEEDING

EQUIP MENT	NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
211	*BEFORE USING SV, MAKE SURE THAT N-28-D (HYDRO-CHLORIC ACID) LINE, IF ANY IS BLANKED OFF*.			
208	RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% (CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
1	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	270	32-D	270
	DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	80X50	YC10B	4000
	RECORD: START 9:30AM LOT G2J23	6X50	YC16B	300
	FIN 10:45AM	300		
		2000		
		2000		
	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU			
	HOMOG AT 1800-2200 PSI INTO V-208			
	WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN			
	HOT WATER AT 1800-2200 PSI INTO V-208			
	RECORD: V-208 VOL. 41 & ADJUST TO 50" (1840G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 15" (771 G) WATER INTO V-246 START			
SV	AGITATOR & INSTALL TEMP CHART			
2	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 2:55AM TOTAL MINUTES 100			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	S-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			
	WEIGH INTO V-384 & PUMP TO V-349	2400	32-D	2400
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	RECORD DENSITY: 1.0782 G/ML (1.078-1.081)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			
	RECORD: PH 9.8 & ADJ TO 10.4-10.8 USING N-7-D			
	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH 10.8			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190°F			
	& RECORD: 194°F			

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EQUIP PAGE 2 CG 04 KO-786-D V-246 USE N- ACCT
MENT LBS CODE LBS

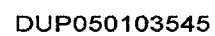
21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
343 V-343
& 22 METER IN (SULFURIC ACID 60%) FROM V-386 456 27-D 355
386 M 27, 11.020+/GAL, 32.1 GAL
5 23 STIR 15 MIN OR LONGER
24 RECORD: DENSITY 1.0194/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
26 SET V-343 ACID PUMP AT 72 SETTING (225 MIN)
27 SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)
28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE
6 29 RECORD: START FINISH MINUTES
V-343 7:40 11:20 225
V-349 7:40 10:40 180
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 8:00 AM (47) 47 (20) 20 9.7 (9.3-10.0)
40 MIN 8:20 (43) 43 (17) 17 9.5 (9.3-10.0)
1 HR 8:40 (38) 38 (15) 15 9.5 (9.3-10.0)
2 HR 9:40 (24) 24 (7) 7 9.3 (9.3-10.0)
3 HR 10:40 (10) 11 (0) 0 9.3 (9.3-10.0)
FINISH 11:25 (0) 6.4 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 150 7-D 75

SV 32 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
8 33 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
34 TURN OFF STEAM
35 RUN IN LIQUID ALUM USING BADGER METER 600 115-D 300
36 FLUSH ALUM LINE WITH WATER.
37 RECORD: PH 3.3 (3.3-3.7) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.3-3.7 & 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 S 33 IN 4-6 MIN & STIR 5 MIN
39 RECORD: PH 4.1 (4.0-4.2) & IF NECESSARY ADJ TO
PH 4.0-4.2. 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 WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN
SUBSTANDARD TO BE BLENDED BACK.
RECORD: CODE _____, LOT _____

41 STOP AGITATOR
START FINISH OPERATOR
2:00 AM 12:30 PM 227-109



V-246