

S.V. 246, 247 (MANUAL)

DATE PRINTED: 6/14/82

CG 04 CODE KO-786-D PKG

PROCESS APPROVED BY
() KO-786-D (P) FWP 06/14/82JUL 26 1982
(DATE)

G2J79

5084*

(LOT) (EST WGT)

COMTYP JOB NAME: 04KO786DMQ
(CONTAINS RE-WORK)

TIME: 3:00 P.M., STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	04	KO786D	98	84960-1	200	✓	4	50	200	200
	01	YC-10	93	H1018	100	✓	2	50	100	100
	01	YC-10	93	FRY06-1	4000	✓	80	50	4000	4000

WAREHOUSE REQUISITION NO. 10894

NON-BLEEDING

EQUIP MENT	NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208	1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2 WEIGH IN DRUM AND POUR IN	270	32-D	270
	3 DUMP IN AND STIR 5 MIN RECORD: START 8:00 PM LOT FRY06-1 FIN 9:30 PM H1018	82X50 4X50	YC10B KO786D	4100 200
	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 1800-2200 PSI INTO V-208			
	6 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 40" & ADJUST TO 50" (1840G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 15" (771 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 PM TOTAL MINUTES 120			
	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	2400	32-D	2400
	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: 1.082 G/ML (1.078-1.081)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			

JUL 28 1982

N32922

DUP050464739

EQUIP
MENT

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V-246

USE N- ACCT
LBS CODE LBS

19 RECORD: PH 10.8 & ADJ TO 10.4-10.8 USING N-7-D
4 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)
ASSUME 50% 7-D
SIPHON N-7-D INTO SV & RECORD: PH _____
120 HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____*F
& RECORD: _____*F
343 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
& V-343
386 METER IN FROM V-386 M19, 10.89 #/GAL, 32.6 GAL
5 STIR 15 MIN OR LONGER 27-D 355
5 RECORD: DENSITY 1.019 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 8.0
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 RECORD: START FINISH MINUTES
V-343 5:20 PM 9:10 890
V-349 8:25 185
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 5.40 (47) 48 (20) 2 9.7 (9.3-10.0)
40 MIN 6:00 (43) 44 (17) 17 9.7 (9.3-10.0)
1 HR 6:30 (38) 37 (15) 15 9.7 (9.3-10.0)
2 HR 7:00 (24) 28 (7) 7 9.7 (9.3-10.0)
3 HR 8:00 (10) 11 (0) 0 9.7 (9.3-10.0)
FINISH 9:00 (0) 0 0 7.5 (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 ALUM USING BADGER METER 600 115-A 300
36 FLUSH ALUM LINE WITH WATER.
37 RECORD: PH 3.7 (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-A
38 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN
39 RECORD: PH 3.7 (4.0-4.2) & IF NECESSARY ADJ TO
PH 4.0-4.2. RECORD: PH 4.2 ASSUME 77% 27-D
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 30 7-D 15
SIPHON N-7-D INTO SV
40 STOP AGITATOR

START

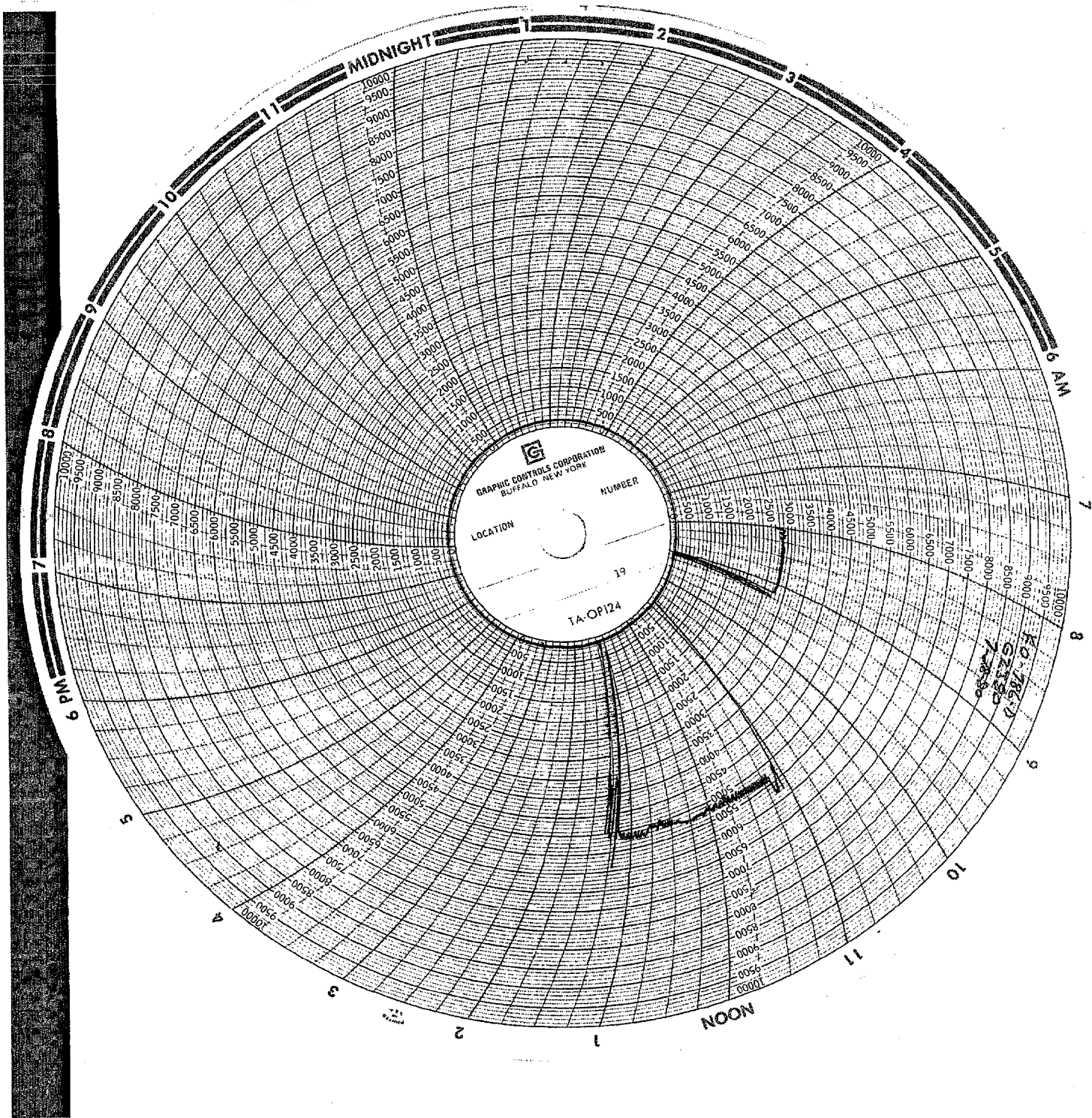
FINISH

OPERATOR

7:00 PM
5:00 PM

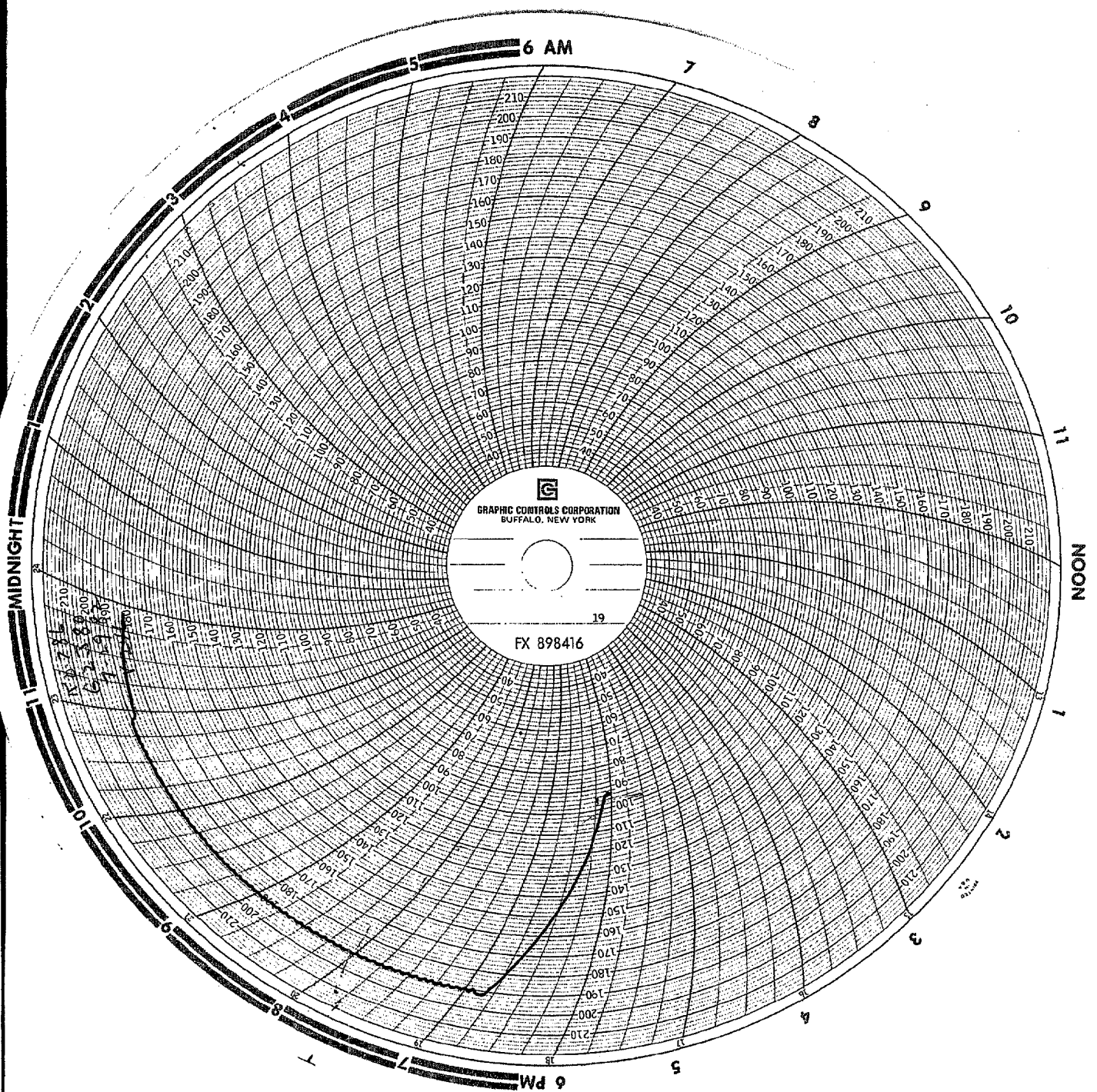
7:11
3:00 PM
10:00 PM

120-306
237-223
57



N32922.01

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N32922.02

DUP050464742