CG 04 CODE KO-786-D PKG

EST'D WGT 862 LBS MAY -0-81-Σ1379

STANDARD HRS. 10.5 TIME H

PROCESSES
( ) KO-786-D (P)
( ) ( )
( ) ( )
( ) ( )

APPROVED BY
FWP 01/16/81

COMTYP JOBNAME: 04KO786DMP

CG	CODE	PQ	LOT	LBS
01	YC010B	~~98~~	37757	~~300~~
01	YC010B	93	39665	1200
01	YC010B	93	D1097	2050
01	YC010B	93	Σ1181	750

TOTAL EST'D WGT ~~4962~~ 5162 REQ. NO.(10226) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60*(990 G) WATER IN V-211 & ADD ASSUME 50%	30	7-D	15
		& SET AGITATOR ON HIGH SPEED			
	2	WEIGH IN DRUM AND POUR IN	270	32-D	270
	3	DUMP IN AND STIR 5 MIN LOT 86	~~300~~	YC10B	~~4100~~
		RECORD: START 7:25AM 37757	300		1300
1		FIN 7:35AM 39665	1200		
		D1097	2050		
		Σ1181	750		
	4	ADJUST TO 75" (1275 G)			
	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. 39" & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV 2	9	RUN 15" (771 G) WATER INTO V-~~247~~ 247 START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 7:29 TOTAL MINUTES 160			
		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 3	~~12~~	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	~~13~~	RUN 1000# WATER INTO V-384 & HEAT TO 116-120*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			
→	16	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.079 G/ML (1.078-1.081)			
SV 4	~~18~~	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.2 & ADJ TO 10.4-10.8 USING N-7-D			
		DILUTED TO 5% (19 PARTS WATER TO 1 PART N-7-D)			
		ASSUME 50%	____	7-D	____
		SIPHON N-7-D INTO SV & RECORD: PH ____			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT 185 *F			
		& RECORD: 192 *F			

EQUIP		PAGE 2 CG 04 KO-786-D EST WGT 4962# V-247	USE LBS	N-CODE	USE LBS
	21	WHILE HEATING SV, RUN 51* (1400 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M 15 ,10.2#/GAL, 33.1 GAL		27-D	355
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.018 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
	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			
	29	RECORD: START FINISH MINUTES			
		V-343 2:10A 6:05A 235			
		V-349 2:10A 5:15A 185			
		TIME V-343 V-349 SV NORMAL			
		2:10 INCHES 54 INCHES 22 PH PH			
		AT 20 MIN 2:30 (47) 50 (20) 9.6 (9.3-10.0)			
		40 MIN 2:50 (43) 45 (17) 9.6 (9.3-10.0)			
		1 HR 3:10 (38) 40 (15) 9.6 (9.3-10.0)			
		2 HR 4:10 (24) 26 (7) 9.5 (9.3-10.0)			
		3 HR 5:10 (10) 14 (0) 9.5 (9.3-10.0)			
		FINISH 5:55 (0) 7.3 (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	RUN 40* (308 G) WATER INTO V-385 & HEAT TO			
7		135-140*F			
	31	DUMP IN & STIR TO DISSOLVE	300	15-A	300
302	32	ADD 42* (514 G) WATER TO V-302			
8	33	ADD & STIR 2 MIN	150	7-D	75
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			
	36	TURN OFF STEAM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.1 (3.3-3.7) & IF NECESSARY ADJ			
		(DOWN ONLY) TO 3.3-3.7 & 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 4-6 MIN & STIR 5 MIN			
	40	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%	16	7-D	8
		SIPHON N-7-D INTO SV			
	41	STOP AGITATOR			

START	FINISH	OPERATOR
11:00P	6:55AM	235-244

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