

CG 04 CODE KD-786-D PKG PROCESSES APPROVED BY  
 EST'D WGT 862 LBS DEC 28 80 38422 ( ) KD-786-D (P) FWP 11/20/80  
 STANDARD HRS. 10.5 TIME DEC 30 1980 12/18 JOB NAME: 04K0786DMP

| CG | CODE   | PQ | LOT   | LBS         |
|----|--------|----|-------|-------------|
| 01 | YC010B | 93 | 36289 | 1450        |
| 01 | YC010B | 93 | 36263 | 1150 - sub- |
| 01 | YC010B | 93 | 36263 | 1500        |

*Handwritten: 36263, 1450, 1150, 1500*

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

| EQUIP | NAME : "KROLOR" ORANGE R                                                                                                                                                                                                                                                                                                                                                             | USE LBS                              | NCODE          | ACCT LBS    |
|-------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|----------------|-------------|
| 211   | 1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50%<br>& SET AGITATOR ON HIGH SPEED                                                                                                                                                                                                                                                                                                    | 30                                   | 7-D            | 15          |
| 208   | 2 WEIGH IN DRUM AND POUR IN<br>3 DUMP IN AND STIR 5 MIN<br>RECORD: START 10:55 AM<br>FIN 2:15 PM                                                                                                                                                                                                                                                                                     | 280<br>52X58<br>1500<br>1150<br>1450 | 983-D<br>YC10B | 280<br>4100 |
| 1     | 4 ADJUST TO 75" (1275 G)<br>5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU<br>HOMOG AT 1800-2200 PSI INTO V-208<br>6 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN<br>HOT WATER AT 1800-2200 PSI INTO V-208<br>7 RECORD: V-208 VOL. 3.5" & ADJUST TO 50" (1840G)<br>8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY                                                                      |                                      |                |             |
| 208   | 9 RUN 15" (771 G) WATER INTO V-247, START<br>& AGITATOR & INSTALL TEMP CHART<br>SV 10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.<br>RECORD: TIME START 9:15 PM TOTAL MINUTES 2:10<br>2 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,<br>3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208<br>11 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP<br>THRU HOMOG AT 4800-5200 PSI INTO SV |                                      |                |             |
| 349   | 12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349<br>& 13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F<br>384 14 WEIGH INTO V-384 & PUMP TO V-349<br>15 RUN 1000# WATER INTO V-384 & PUMP TO V-349<br>3 16 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN<br>17 RECORD DENSITY: 1.02 G/ML (1.078-1.081)                                                                                     | 2450                                 | 983-D          | 2450        |
| SV    | 18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)<br>19 RECORD: PH 12.6 & ADJ TO 10.4-10.8 USING N-7-D<br>4 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)<br>ASSUME 50%<br>SIPHON N-7-D INTO SV & RECORD: PH<br>20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190 *F<br>& RECORD: 190 *F                                                                                            |                                      | 7-D            |             |

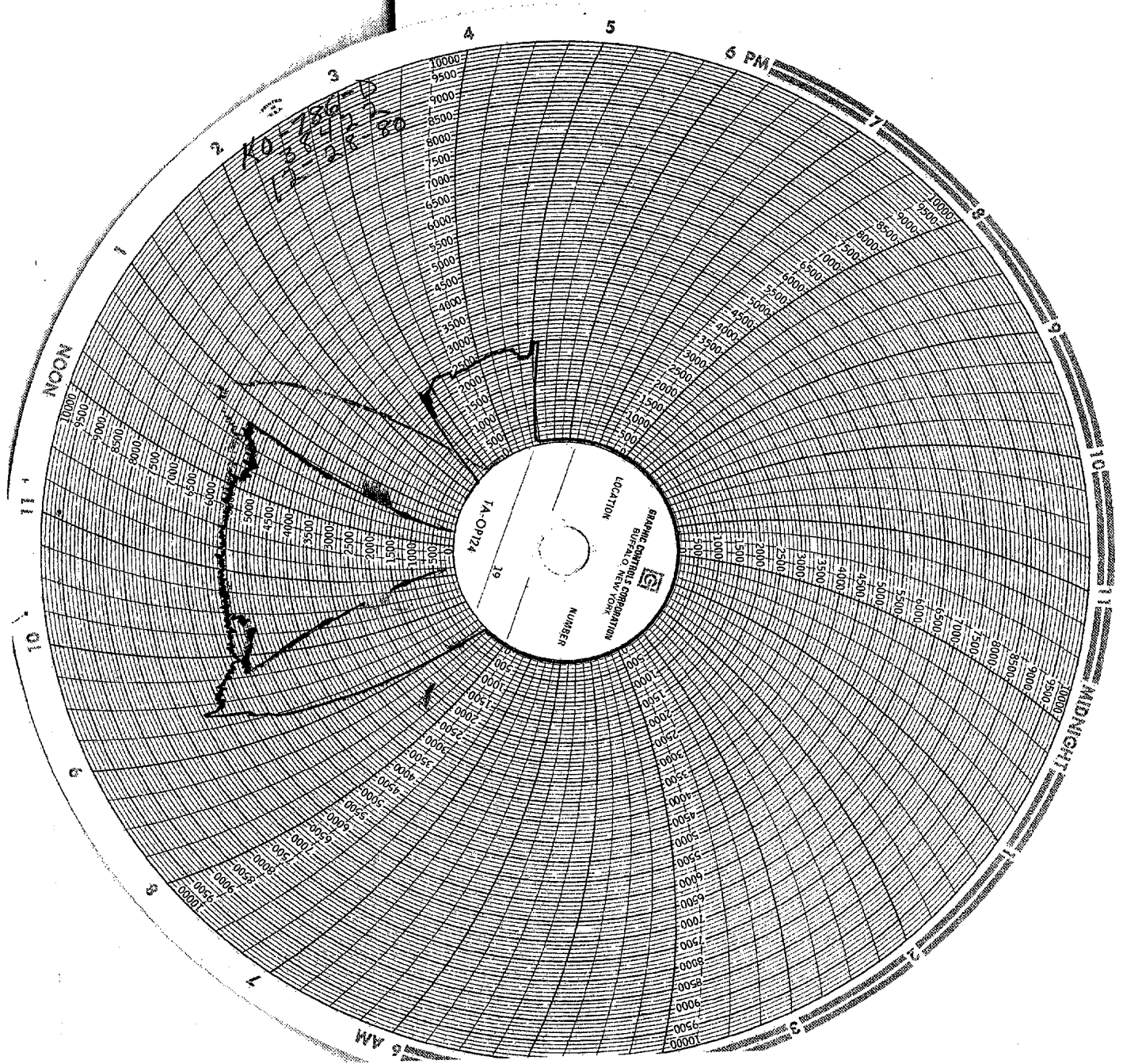
*Handwritten: 36263, 1450, 1150, 1500, 3.5, 2.10, 12.6, 190*

**PUNCHED & CHECKED**  
 DEC 30 1980

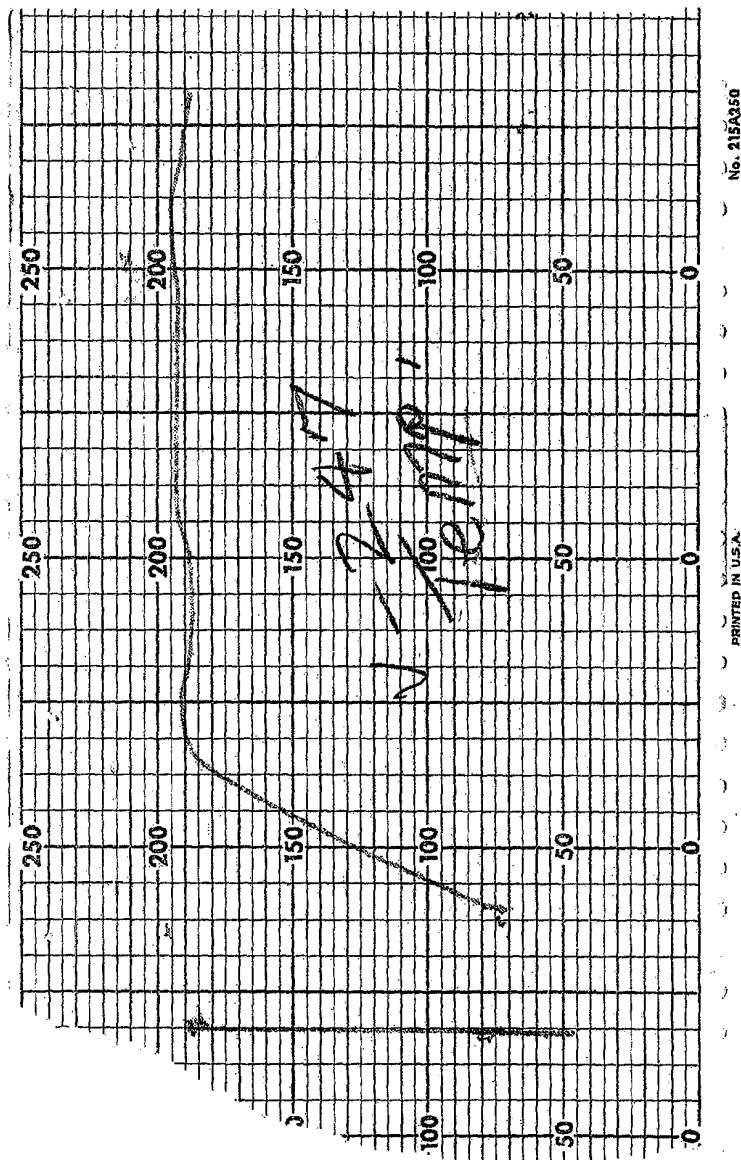
*Handwritten: (Signature)*

N34554

|     |       |                                                                                                                              | LBS | CODE | LBS |
|-----|-------|------------------------------------------------------------------------------------------------------------------------------|-----|------|-----|
|     | V 247 |                                                                                                                              |     |      |     |
| 343 | 21    | WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343                                                                          |     |      |     |
| &   | 22    | METER IN FROM V-386 M. 31 9.642 #/GAL 36.8 GAL                                                                               |     | 27-D | 355 |
| 386 | 23    | STIR 15 MIN OR LONGER                                                                                                        |     |      |     |
| 5   | 24    | RECORD: DENSITY 1.019 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)                                                                              |     |      |     |
| SV  | 28    | IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE                                                   |     |      |     |
|     | 29    | RECORD:                                                                                                                      |     |      |     |
|     |       | START FINISH MINUTES                                                                                                         |     |      |     |
|     |       | V-343 9:20 6:30 PM 2:40                                                                                                      |     |      |     |
|     |       | V-349 5:30 PM 1:80                                                                                                           |     |      |     |
|     |       | TIME V-343 V-349 SV NORMAL                                                                                                   |     |      |     |
|     |       | INCHES INCHES PH PH                                                                                                          |     |      |     |
|     |       | AT 20 MIN 2:50 (47) (20) 9.15 (9.3-10.0)                                                                                     |     |      |     |
|     |       | 40 MIN 3:10 (43) 4:14 (17) 9.57 (9.3-10.0)                                                                                   |     |      |     |
|     |       | 1 HR 3:30 (38) 3:30 (15) 9.5 (9.3-10.0)                                                                                      |     |      |     |
|     |       | 2 HR 4:30 (24) 2:7 (7) 8 9.5 (9.3-10.0)                                                                                      |     |      |     |
|     |       | 3 HR 5:30 (10) 1:2+ (0) 9.6 (9.3-10.0)                                                                                       |     |      |     |
|     |       | FINISH 6:30 (0) 6:9 (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 135-140°F                                                                         |     |      |     |
| 7   | 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 3.3 (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 4.1 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH                                                        |     | 27-D |     |
|     |       | DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 77%                                                                                   |     | 7-D  |     |
|     |       | SIPHON N-7-D INTO SV ASSUME 50%                                                                                              |     |      |     |
|     | 41    | STOP AGITATOR                                                                                                                |     |      |     |
|     |       | START FINISH OPERATOR                                                                                                        |     |      |     |
|     |       | 2:30 PM 3:00 PM 54                                                                                                           |     |      |     |
|     |       | 9:00 A 11:00 PM 2:35                                                                                                         |     |      |     |
|     |       | 3:00 PM 7:30 PM 120-126                                                                                                      |     |      |     |
|     |       |                                                                                                                              |     |      |     |



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