CG 04 CODE KO-786-D PKG DEC 12 80 38250 PROCESSES APPROVED BY
EST'D WGT 862 LBS ( ) KO-786-D (P) FWP 11/20/80
STANDARD HRS. 10.5 TIME M ( ) ( )
( ) ( )
( ) ( )
JOB NAME: 04KO786DMP

CC	CODE	PQ	LOT	LBS
01	YC010B	93	36260	600
01	YC010B	93	36689	3050
01	YC010B	93	36675	450

PUNCHED & CHECKED 36689 x
DEC 1 1980

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%	30	7-D	15
&		& SET AGITATOR ON HIGH SPEED			
208	2	WEIGH IN DRUM AND POUR IN	280	983-D	280
	3	DUMP IN AND STIR 5 MIN LOT	82X50	YC10B	4100
		RECORD: START 2:15A 36689	3850		
1		FIN 2:35A 36260	600		
		36675	450		
	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. 54 " & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
V-247	9	RUN 15" (771 G) WATER INTO V-247, START			
&		AGITATOR & INSTALL TEMP CHART			
SV	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 5:00 PM TOTAL MINUTES 180			
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	12	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
&	13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120*F			
384	14	WEIGH INTO V-384 & PUMP TO V-349	2450	983-D	2450
	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: 1.081 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.7 & 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 —			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT 190 *F			
		& RECORD:190 *F			

N4459

EQUIP		PAGE 2 LG 04 KO-188-D EST WGT 4/02# V-247	LBS	CODE	LBS
	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M 27, 9660 #/GAL, 36.7 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 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			
	29	RECORD: START FINISH MINUTES			
		V-343 ____ 1:40 240			
		V-349 ____ 12:45 185			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH	9:40 PM		
		AT 20 MIN 10:00 PM (47)___ (20)___ 9.8 (9.3-10.0)			
		40 MIN 10:20 (43)___ (17)___ 9.8 (9.3-10.0)			
		1 HR 10:40 (38)___ (15)___ 9.7 (9.3-10.0)			
		2 HR 11:40 (24) 26 (7) 9 9.7 (9.3-10.0)			
		3 HR 12:40 (10) 14 (0) 2 9.7 (9.3-10.0)			
		FINISH 1:20 AM 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	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 3.4 (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 ___ ASSUME 77%	_____	27-D	_____
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	_____	7-D	_____
		SIPHON N-7-D INTO SV			
	41	STOP AGITATOR			

START	FINISH	OPERATOR
11 PM	7 AM	282
3:00 PM	11:00 PM	237-244
11:00 PM	3:40 AM	342

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