CG 04 CODE KO-786-D PKG 5084* PROCESS APPROVED BY:
OCT 19, 1982 K2K26 (EST WGT) OK KO) KO-786-D (P) FWP 09/08/82
("DATE") (LOT) COMTYP JOBNAME: 04KO786DMP
TIME: 7:00 A.M. STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC-10	93	H2L08	2000	100.00	40	50	2000	2000
	01	YC-10	93	D2H59	2000	100.00	40	50	2000	2000
	01	YE721D	98	D2H90	300	100.00	6	50	300	300
	01	YC-10	93							

SUBSTANDARD BLEND-BACK FOR S-40: CODE _____, LOT _____, PQ ___, _____
REQ. NO.(10995) NON-BLEEDING

EQUIPMENT		NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D (HYDROCHLORIC ACID) LINE, IF ANY IS BLANKED OFF".			
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	270	32-D	270
	3	DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	80X50	YC10B	4000
1		RECORD: START 11:30 AM FIN 1:30 PM LOT H2L08 D2H59 D2H90	6X50 2000 2000 310	YE721D	300
	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. 50 " & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 15" (771 G) WATER INTO V-245, START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 2:50 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 1.079 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.9 & 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 ____*F & RECORD: ____*F			

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EQUIPMENT		PAGE 2 CG 04 KO-786-D	USE LBS	N-CODE	ACCT LBS
	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
343 & 386	22	METER IN (SULFURIC ACID 60%) FROM V-386 M 25, 11.145 #/GAL, 31.8 GAL	31.8	27-D	355
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.018 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH____			
	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 AT 190-194*F DURING STRIKE			
SV 6	29	RECORD: START FINISH MINUTES V-343 8:35 1225 235 V-349 ____ 1140 190 TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH AT 20 MIN 8:55 (47) 49 (20) + 9.5 (9.3-10.0) 40 MIN 9:15 (43) 44 (17) 17 9.5 (9.3-10.0) 1 HR 9:35 (38) 39 (15) 14 9.6 (9.3-10.0) 2 HR 10:35 (24) 26 (7) 8 9.6 (9.3-10.0) 3 HR 11:35 (10) 10+ (0) +-1 9.6 (9.3-10.0) FINISH 12:20 A (0) ___ 7.4 (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	480		
	35	RUN IN LIQUID ALUM USING BADGER METER	600	115-D	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-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 11P 7A 120 11PM 1A 120			

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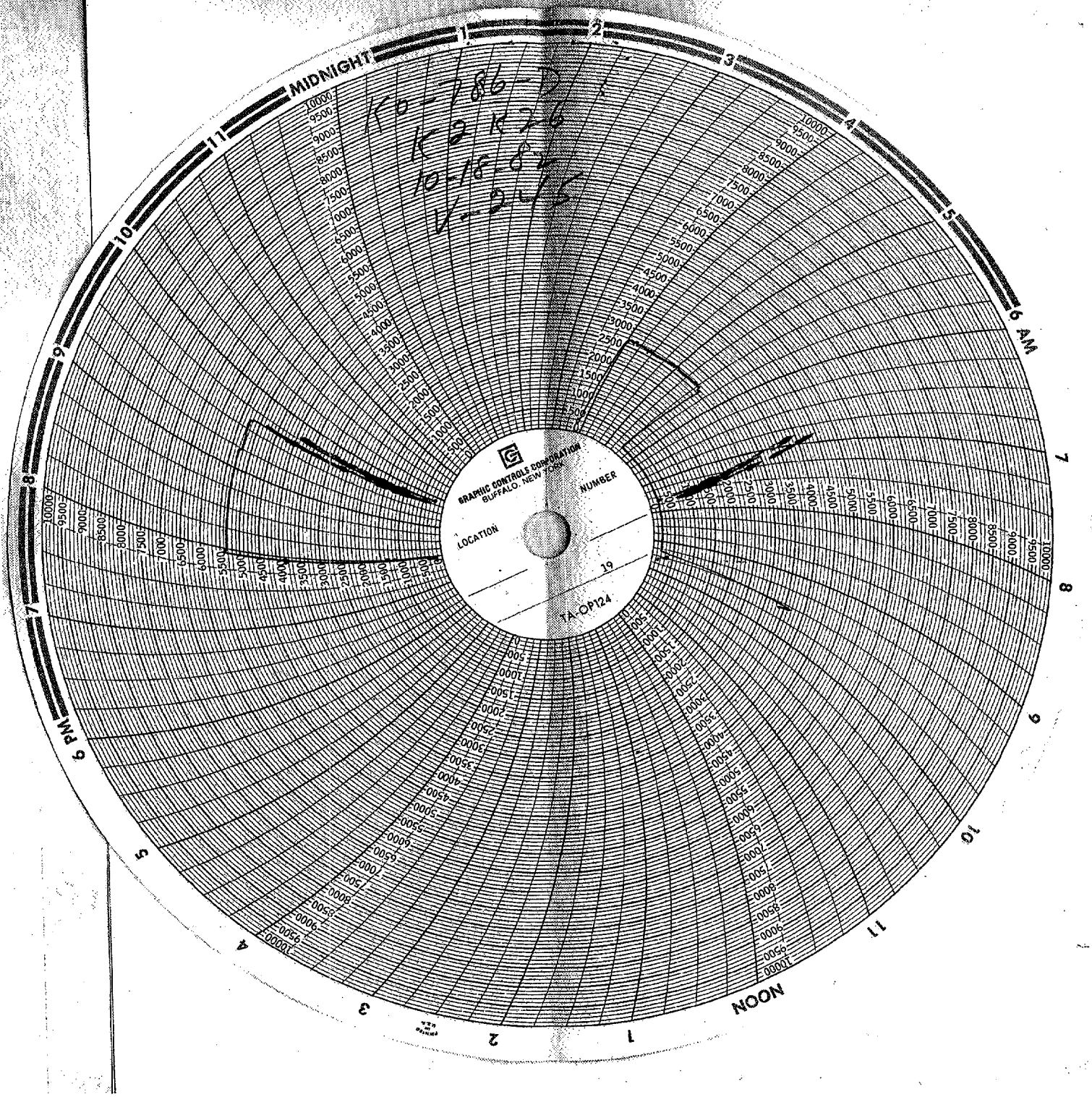

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