

CG 04 CODE KO-786-D PKG PROCESS APPROVED BY:
 11/17/82 L2K35 5084* () KO-786-D (P) FWP 10/04/82
 (DATE) (LOT) (EST WGT) COMTYP JOBNAME: 04K0786DMP
 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
	01	YC-16	98	C2166	200	100.00	5	40	200	200
	01	YC-10	93	62191	3500	100.00	70	50	3500	3500
	01	YC-10	93	L2Y084	600	100.00	12	50	600	600
	01	YC-10	93			100.00				

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

EQUIP MENT	NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
211 & 208	"BEFORE USING SV, MAKE SURE THAT N-28-D (HYDRO-CHLORIC ACID) LINE, IF ANY IS BLANKED OFF". 1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% (CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED 2 WEIGH IN DRUM AND POUR IN (SODIUM SILICATE) 3 DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE) RECORD: START 1 PM LOT _____ FIN 3 PM 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	30	7-D	15
208 & SV	1 RUN 15" (771 G) WATER INTO V-246, START AGITATOR & INSTALL TEMP CHART 2 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 12:40 TOTAL MINUTES 120 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208 3 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV	2700 82X50 5 X 40	32-D YC10B YC16B	270 4700 200
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 15 RUN 1000# WATER INTO V-384 & PUMP TO V-349 3 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN 17 RECORD DENSITY: 1.080 G/ML (1.078-1.081)	2400	32-D	2400
SV & 4	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G) 19 RECORD: PH 10.8 & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% 120 SIPHON N-7-D INTO SV & RECORD: PH 1 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 193°F & RECORD: 194°F		7-D	

NOV 19 1982

11/14/82

PAGE 2 CG 04 KO-786-D | USE LBS | N- CODE | ACCT LBS

343 21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343
 & 22 METER IN (SULFURIC ACID 60%) FROM V-386
 386 M 2.9, 16.057# / GAL, 32.1 GAL
 5 23 STIR 15 MIN OR LONGER
 24 RECORD: DENSITY 1.020 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 9.7
 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 6 AT 190-194°F DURING STRIKE
 29 RECORD: START FINISH MINUTES
 V-343 3:35 AM 7:20 225
 V-349 3:35 AM 6:35 AM 180
 TIME V-343 V-349 SV NORMAL
 INCHES INCHES PH PH
 AT 20 MIN 3:55 AM 47) 47 (20) 7.0 9.8 (9.3-10.0)
 40 MIN 4:15 (43) 42 (17) 7.7 9.7 (9.3-10.0)
 1 HR 4:35 (38) 37 (15) 7.4 9.7 (9.3-10.0)
 2 HR 5:35 (24) 23 (7) 7.7 9.7 (9.3-10.0)
 3 HR 6:35 (10) 9 (0) 6 9.7 (9.3-10.0)
 FINISH 7:20 AM 0) 7.1 (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 LIQUID ALUM USING BADGER METER 600 115-D 300
 36 FLUSH ALUM LINE WITH WATER.
 37 RECORD: PH 3.35 (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 5.3 (4.0-4.2) & IF NECESSARY ADJ TO
 PH 4.0-4.2. RECORD: PH 4.5 ASSUME 77% 15 27-D
 DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 7-D

40 SIPHON N-7-D INTO SV
 WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN
 SUBSTANDARD TO BE BLENDED BACK.

RECORD: CODE , LOT , #

41 STOP AGITATOR
 START FINISH OPERATOR
 11:00 PM 7:00 AM 320
 7 AM 8 AM 120



