

CG 04 CODE KO-909-D PKG

PROCESSES

APPROVED BY

JUN 3 1982

F2H77

() KO-909-D (C)

FWP 03/25/82

DATE

LOT NUMBER

STD. HRS.

TIME

3 P.M.

JOB NAME: 04KO909DMC

CG	CODE	PQ	LOT	LBS
01	YC-16-B	94	F1288	100
01	YC-16-B	93	B2H74	600
01	YC-16-B	93	D2K34	3050

EST. WT. 5243* LBS.

REQ. NO. (10828)

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
208	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MINS	480	32-D	480
	RECORD: START 12:30 A.M. LOT F1288 FIN 1:45 A.M. B2H74 D2K34	75X50 100 600 3050	YC16B	3750
	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
	RECORD: V-208 VOL. 40 " & ADJUST TO 54" (1890G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 10" (514 G) WATER INTO V-246 START AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 10:00 A.M. TOTAL MINUTES 85			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	WEIGH INTO V-384 & PUMP TO V-349	2500	32-D	2500
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	RECORD DENSITY 1.094 G/ML (1.091-1.094)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	RECORD: PH 10.9 & ADJ TO 11.1-11.3 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%			
	SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 194 *F			
	& RECORD: 194 *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

JUN 9 1982

7-D

8/7

EQUIP PAGE 2 CG 04 KO-909-D
MENTI COMTYP JOB NAME: 04KO909DMC

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USE N- ACCU
LBS CODE LBS

343 21 WHILE HEATING SV, RUN 49" (1348 G) WATER INTO
V-343
8 22 METER IN FROM V-386 M 17, 10.304/GAL, 31.1 GAL
386 23 STIR 15 MIN OR LONGER
5 24 RECORD: DENSITY 1.022 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2
26 SET V-343 ACID PUMP AT 69 SETTING (225 MIN)
27 SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)
28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE
6 29 RECORD: START FINISH MINUTES
V-343 2:40 6:00 2:40
V-349 5:20 5:20 2:00
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 2:40 (46) 46 (17) 17 10.2 9.3-10.0
40 MIN 3:40 (41) 41 (15) 15 9.9 9.3-10.0
1 HR 4:40 (37) 38 (13) 13 9.7 9.3-10.0
2 HRS 5:40 (23) 25 (6) 7 9.8 9.3-10.0
3 HRS 6:40 (10) 12 (0) 7 9.6 9.3-10.0
FINISH 3:45 (0) (0) 7 9.6 (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

30 SIFT IN

50 128-A 50

385 31 ADD 60" (465 G) WATER TO V-385
7 32 ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50% 296 7-D 148

33 DURING STRIKE CHECK LEVEL IN V-387.
387 34 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37
8 35 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING
THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE
36 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW
STEARATE MAKE-UP PROCEDURE.

37 RUN IN 27" (268 GAL). DO NOT MAKE UP THIS
SOLUTION MORE THAN 30 MINUTES IN ADVANCE.
DELAY BETWEEN END OF STEP 43 HEAT-UP AND
START OF STEP 53 HOMOGENIZATION SHOULD BE
LESS THAN 30 MINUTES.

388 38 TURN ON STEAM & AGITATOR
9 39 ADJUST TO 37" (366 GAL) AT 178-182°F
40 SET BADGER METER FOR 590±
41 PUMP IN FROM V-387 THRU UNDERSURFACE
DISTRIBUTORS AS FAST AS POSSIBLE 482 169-A 482
54 155-A 54
54 160-A 54
42 SHUT OFF PUMP
43 STIR 30 MIN AT 178-182°F FOR S 53
44 DO NOT SHUT OFF AGITATOR

SV 45 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
10 46 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
47 STIR 60 MIN AT 190-194°F 600

EQUIP. | PAGE 3 CG 04' KD-909-D
MENTI | COMTYP JOB NAME: 04K0909DMC

USE | N- | ACCT
LBS | CODE | LBS

SV 148	HEAT TO 198-200°F IN 5-10 MIN			
10 149	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
CONT 150	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
151	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
152	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
153	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
154	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
155	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
156	TURN OFF HOMOG & STEARATE PUMP			
157	STIR 5 MIN AT 198-200°F			
158	SHUT OFF STEAM			
159	RUN IN ALUM USING BADGER METER	950	115-D	475
160	FLUSH ALUM LINE WITH WATER			
161	RECORD: PH <u>3.1</u> (3.4-3.8)			
162	IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH _____. NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN. AFTER EACH ADDITION. ASSUME 50%		115-D	
163	RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
164	RECORD: PH <u>4.2</u> (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH <u>6.2</u> ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	60	27-D 7-D	30
165	SIPHON N-7-D INTO SV			
166	DO NOT STOP AGITATOR			

7:00 AM
300 P

3:00 PM
8145 PM

320-342
126-301









