

STD. HRS. TIME 7 AM JOB NAME: 04K0909DMC

CG	CODE	PQ	LOT	LBS
01	YC-16-B	93	B2H78	450
01	YC-16-B	93	D2K32	2200
01	YC-16-B	93	F2H87	1000
01	YC-16-B	98	39503	100

EST. WT. 5243* LBS. REQ. NO. (10846) 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 & 208	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
	2 WEIGH IN DRUM AND POUR IN	480	32-D	480
	3 DUMP IN AND STIR 5 MINS. LOT	75X50	YC16B	3750
	RECORD: START 12:00 PM B2H78	450		
	FIN 1:30 PM D2K32	2200		
		1000		
		100		
	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 2800-3200 PSI INTO V-208			
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-246, START AGITATOR & INSTALL TEMP CHART			
	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1450 TOTAL MINUTES 13.5			
	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	2500	32-D	2500
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	3 16 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.094 G/ML (1.091-1.094)			
SV 4	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	19 RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	20 ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH 11.2	16	7-D	8
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F & RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

JUN 17 1982

EQUIP PAGE 2 CG 04 KO-909-D U-246 USE N- ACCT
MENTI COMTYP JOB NAME: 04KO909DMC LBS CODE LBS

121 WHILE HEATING SV, RUN 49" (1348 G) WATER INTO
343 V-343
& 122 METER IN FROM V-386 M/8 1.0814/GAL 34.5 GAL 27-D 373
386 123 STIR 15 MIN OR LONGER
5 124 RECORD: DENSITY 1.018 G/ML (1.018-1.020)

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.4
126 SET V-343 ACID PUMP AT 69 SETTING (225 MIN)
127 SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)
128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE
6 129 RECORD: START FINISH MINUTES
V-343 10:35 A.M. 2:30 P.M. 235
V-349 1:35 P.M. 180
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 10:55 A (46) (17) 10.0 (9.3-10.0)
40 MIN 11:15 A (41) (15) 10.0 (9.3-10.0)
1 HR 11:35 A (37) (13) 9.7 (9.3-10.0)
2 HRS 12:35 P (23) 24 (6) 6 9.7 (9.3-10.0)
3 HRS 1:35 P (10) 10 (0) 0 9.7 (9.3-10.0)
FINISH 2:30 P (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-L 50 128-A 50

385 131 ADD 60" (465 G) WATER TO V-385
132 ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50% 296 7-I 148

133 DURING STRIKE CHECK LEVEL IN V-387.
387 134 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37
8 135 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING
THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE
136 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW
STEARATE MAKE-UP PROCEDURE.

137 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.
388 138 TURN ON STEAM & AGITATOR
9 139 ADJUST TO 37" (366 GAL) AT 178-182°F
140 SET BADGER METER FOR 590±
141 PUMP IN FROM V-387 THRU UNDERSURFACE
DISTRIBUTORS AS FAST AS POSSIBLE 482 169-A 482
54 155-A 54
54 160-A 54
142 SHUT OFF PUMP
143 STIR 30 MIN AT 178-182°F FOR S 53
144 DO NOT SHUT OFF AGITATOR

SV 145 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
10 146 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
147 STIR 60 MIN AT 190-194°F - STARTED 2:30 P.M.

EQUIP PAGE 3 CG 04 KO-909-D
 MENT COMTYP JOB NAME: 04KO909DMC

V-246

USE N- ACCT
 LBS CODE LBS

SV 48	HEAT TO 198-200°F IN 5-10 MIN			
10 49	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
CONT 50	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
51	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
52	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
53	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
54	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
55	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
56	TURN OFF HOMOG & STEARATE PUMP			
57	STIR 5 MIN AT 198-200°F			
58	SHUT OFF STEAM			
59	RUN IN ALUM USING BADGER METER	950	115-D	475
60	FLUSH ALUM LINE WITH WATER			
61	RECORD: PH <u>3.1</u> . (3.4-3.8)			
62	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	
63	RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
64	RECORD: PH <u>3.8</u> . (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH <u>6.4</u> . ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	<u>6</u> <u>110</u>	27-D 7-D	<u>4</u> <u>55</u>
65	SIPHON N-7-D INTO SV			
66	DO NOT STOP AGITATOR			

7:00A.M - 3:00P.M - 381.237
 3:00PM 5:45PM 320.087

DELAYED HAD TO HAVE NEW HOSE PUT ON METERING Pump.



