

CG 04

CODE KO-789-D

PKG

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS MAY -0-81-21488

() KO-789-D (I)

FWP 01/16/81

STANDARD HRS. 10.8 TIME _____ M

JOB NAME: 04KO789-DMI

CG	CODE	PQ	LOT	LBS
01	YC016B	93	D-1177	3050
01	YC016B	93	D-1189	1150
01	YC016B	93		

TOTAL EST'D WGT 5232

REQ. NO. (10231)

NON-BLEEDING

EQUIP.	NAME : "KROLOR" DRANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
	RECORD: START 9:30 AM D-1177	3050		
	FIN 10:55 AM D-1189	1150		
	4 ADJUST TO 75" (1275 G)			
	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 HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 42" & ADJUST TO 54" (1890C)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-208, START AGITATOR & INSTALL TEMP CHART			
	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 6:35 PM TOTAL MINUTES 180			
	11 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	12 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384	13 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	14 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	15 WEIGH INTO V-384 & PUMP TO V-349	2545	32-D	2545
	16 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	17 ADJ V-349 TO 22" (1040 G) & STIR 13 MIN			
	18 RECORD DENSITY: 1.082 G/ML (1.082-1.086)			
SV	19 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	20 RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D			
	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	30	7-D	15
	SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	21 HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____ °F			
	& RECORD: _____ °F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-247

343 24 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO
& 22 V-343
386 22 METER IN FROM V-386 M 15 10.10# / GAL 36.1 GAL 36.4 27-D 390
5 23 STIR 15 MIN OR LONGER
24 RECORD: DENSITY 1.01 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.7
26 SET V-343 ACID PUMP AT 65 SETTING (255 MIN)
27 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)
SV 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
AT 190-194#F DURING STRIKE
29 RECORD: START FINISH MINUTES
V-343 3.25 30.5
V-349 4.10 2.20
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 12.05 (49) 51 (20) 20 10.5 (9.3-10.0)
40 MIN 12.25 (45) 46 (18) 18 10.4 (9.3-10.0)
1 HR 12.45 (41) 42 (16) 16 10.3 (9.3-10.0)
2 1/4 HR 2.25 (25) 22 (8) 8 9.9 (9.3-10.0)
3 1/2 HR 3.12 (9) 8 (0) 0 9.7 (9.3-10.0)
FINISH 4.2 (0) 9.7 (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: 8.3 PH
ASSUME 77% 12 27-D 4

385 30 RUN 40" (308 G) WATER INTO V-385 & HEAT TO
7 135-140#F
34 DUMP IN & STIR TO DISSOLVE 530 15-A 530

302 22 ADD 42" (514 G) WATER TO V-302
8 23 ADD & STIR 2 MIN 330 7-D 165

SV 34 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
9 35 SET PUMP AT ZERO SETTING
35 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
36 STIR 30 MIN AT 190-194#F, THEN TURN OFF STEAM
RECORD: START 4.10
37 RUN IN V-385 FROM S 31 & STIR 5 MIN
38 RECORD: PH 3.1 (3.4-3.8) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.4-3.8 & RECORD: PH
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 10-12 MIN & STIR 5
MIN
40 RECORD: PH 5.0 (6.2-6.4) & IF NECESSARY ADJ TO
PH 6.2-6.4. RECORD: PH 6.0 ASSUME 77% 27-D
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 7-D 9
41 SIPHON N-7-D INTO SV 50 978-A 50
42 STOP AGITATOR

START FINISH OPERATOR
7:10 PM 5:45 A 54-120