

JUN 10 1982

F2J97

() KD-909-D (C)

FWP 03/25/82

DATE

LOT NUMBER

STD. HRS.

TIME _____ M

JOB NAME: 04KD909DMC

CG	CODE	PQ	LOT	LBS
01	YC-16-B	93	62H37	3050
01	YC-16-B	93	F2H63	700
01	YC-16-B	93		

EST. WT. 5243* LBS.

REQ. NO. (10839)

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 8:PM F2H63	700		
1	FIN 10:PM 82H37	3050		
	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. 56 & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 G) WATER INTO V-247 START			
	10 AGITATOR & INSTALL TEMP CHART			
	11 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 11:5 TOTAL MINUTES 135			
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)			
	ASSUME 50%	30	7-D	15
	SIPHON N-7-D INTO SV & RECORD: PH 11.2			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT ____*F			
	& RECORD: ____*F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

JUN 14 1982

[Signature]

247

21 WHILE HEATING SV, RUN 49" (1348 G) WATER INTO
343 V-343
& 22 METER IN FROM V-386 M 12 10318 / GAL 36.2 GAL
386 23 STIR 15 MIN OR LONGER
5 24 RECORD: DENSITY 10.19 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 6:15 AM 10:15 AM 240

V-349 6:15 AM 9:30 AM 195

TIME V-343 V-349 SV NORMAL

INCHES INCHES PH PH

AT 20 MIN 6:35 AM (46) (17) 9.8 (9.3-10.0)

40 MIN 6:55 AM (41) (15) 9.8 (9.3-10.0)

1 HR 7:15 AM (37) 38 (13) 7 9.9 (9.3-10.0)

2 HRS 8:15 AM (23) 24 (6) 7 9.9 (9.3-10.0)

3 HRS 9:15 AM (10) 11 (0) 1 9.9 (9.3-10.0)

FINISH 10:15 AM (0) 0 8.4 (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

130 SIFT IN

50 128 A 50

385 31 ADD 60" (465 G) WATER TO V-385 302
386 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

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

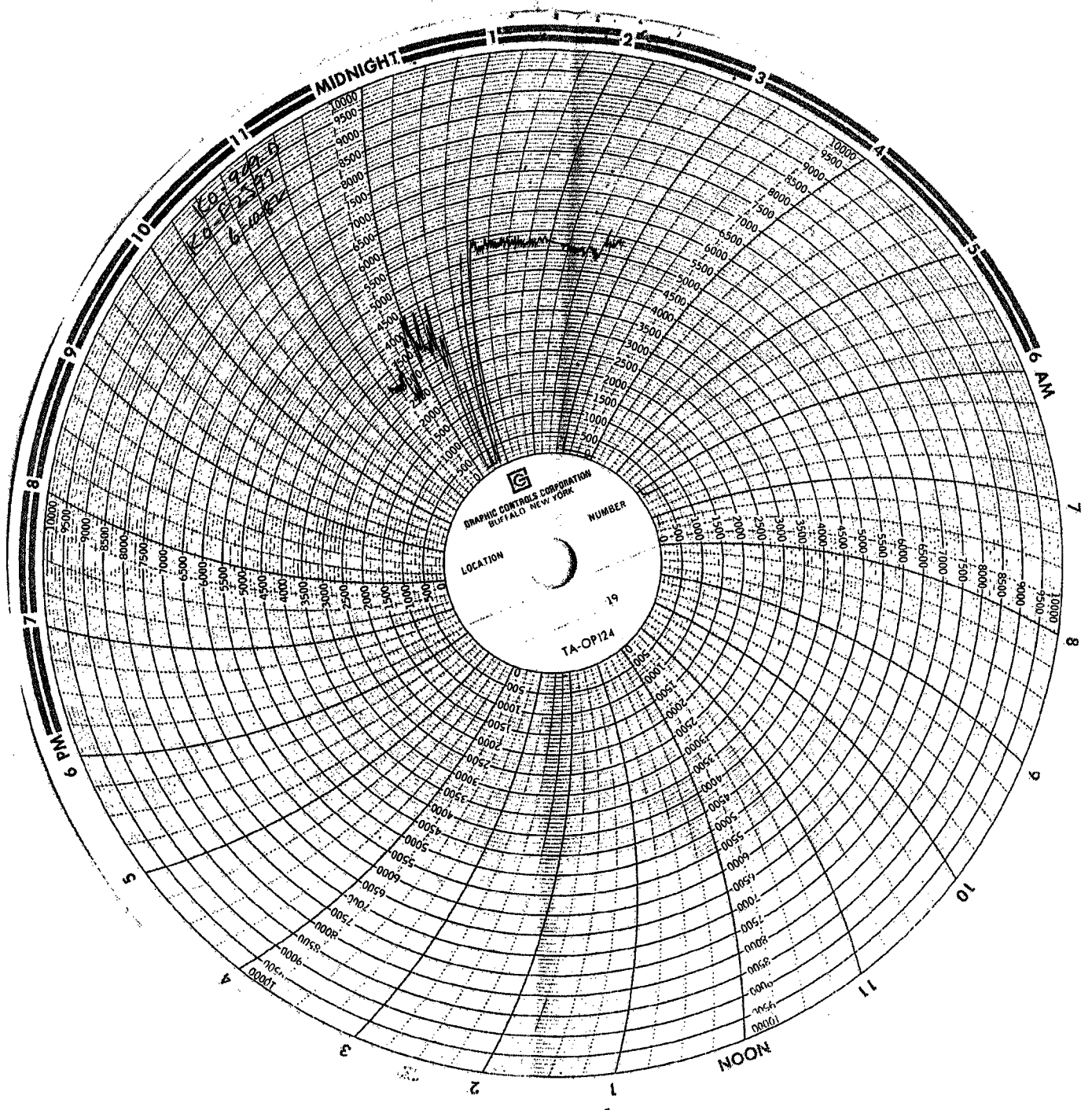
10 46 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR

47 STIR 60 MIN AT 190-194°F START 10:15 AM

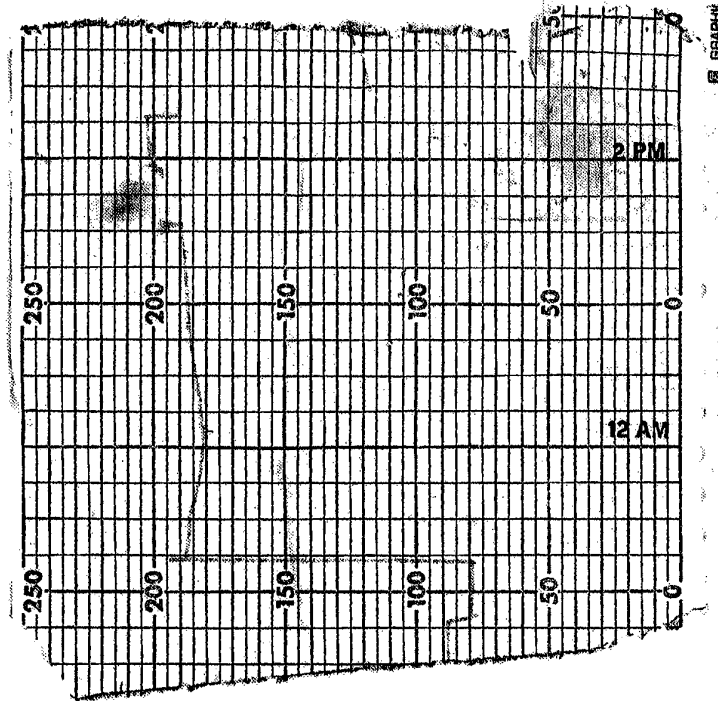
EQUIP PAGE 3 CG 04 KO-909-D
MENTI COMTYP JOB NAME: 04KO909DMC

USE N- ACCT
LBS CODE LBS

SV	10	CONT	USE	N-	ACCT
			LBS	CODE	LBS
48	HEAT TO 198-200°F IN 5-10 MIN				
49	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP				
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>2.9</u> . (3.4-3.8)				
62	IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH <u>5.2</u> . 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>6.4</u> . (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH <u>7.8</u> . ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50% SIPHON N-7-D INTO SV	7.8	27-D 7-D	7	
65	DO NOT STOP AGITATOR				



70
34
120



DUP050046924