

CG 04 CODE KO-786-D PKG JUL - 2 1980

PROCESSES APPROVED BY

EST'D WGT 862 LBS

() KO-786-D (P) FWP 5/22/80

STANDARD HRS. 10.5 TIME 11AM

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TYPED BY: FWP 5/22/80

CG CODE PQ LOT LBS
 01 YC010B 93 35778 4100
 01 YC010B 93
 01 YC010B 93
 01 YC16-B 98 72335 80

OK
AP

Note Step 29

JUN 30 1980

TOTAL EST'D WGT 4962 5042 REQ. NO. ()

NON-BLEEDING

EQUIP	NAME	USE LBS	NCODE	ACCT LBS
211 & 208	1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
2	WEIGH IN DRUM AND POUR IN	270	32-D	270
2	DUMP IN AND STIR 5 MIN	82X50	YC10B	4100
1	RECORD: START 11:15 PM 35778 FIN 1:30 AM 72335	2x40	YC16B	80
4	ADJUST TO 75" (1275 G)			
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 54 & ADJUST TO 50" (1840G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 15" (771 G) WATER INTO V-208 START & AGITATOR & INSTALL TEMP CHART			
10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV			
2	RECORD: TIME START 1:30 TOTAL MINUTES 1:10			
11	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	2400	32-D	2400
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)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			
19	RECORD: PH 10.5 & ADJ TO 10.4-10.8 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%		7-D	
20	SIPHON N-7-D INTO SV & RECORD: PH			
20	HEAT TO 190-194°F IN 55-65 MIN. & REC: HT 192°F & RECORD: 192°F			

N5452L

21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO			
343	V-343			
&	METER IN FROM V-386	M 40, 1046# / GAL, 33.9 GAL	27-D	355
386	STIR 15 MIN OR LONGER			
5	RECORD: DENSITY 1.020 G/ML ()			
25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
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	AT 190-194°F DURING STRIKE			
29	RECORD: START FINISH MINUTES			
	V-343 6:15 11:15 3.5			
	V-349 6:15 11:00 1.0			
	TIME V-343 V-349 SV NORMAL			
	INCHES INCHES PH PH			
AT 20 MIN	6:20 (47) (20) 10.0 (9.3-10.0)			
40 MIN	6:20 (43) (17) 10.0 (9.3-10.0)			
1 HR	7:00 (38) (15) 10.0 (9.3-10.0)			
2 HR	8:00 (24) (7) 10.0 (9.3-10.0)			
3 HR	9:00 (10) (0) 10.0 (9.3-10.0)			
FINISH	9:25 (0) 7.5 (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	

305	7	RUN 31" (238 G) WATER INTO V-305 & HEAT TO 135-140°F	V-356		
31		DUMP IN & STIR TO DISSOLVE	300	15-A	300

302	8	ADD 42" (514 G) WATER TO V-302			
37		ADD & STIR 2 MIN	150	7-D	75

SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	36	TURN OFF STEAM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.5 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH		15-A	
		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 4-6 MIN & STIR 5 MIN			
	40	RECORD: PH 4.35 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.2	12	27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER		7-D	
		SIPHON N-7-D INTO SV			
	41	STOP AGITATOR			

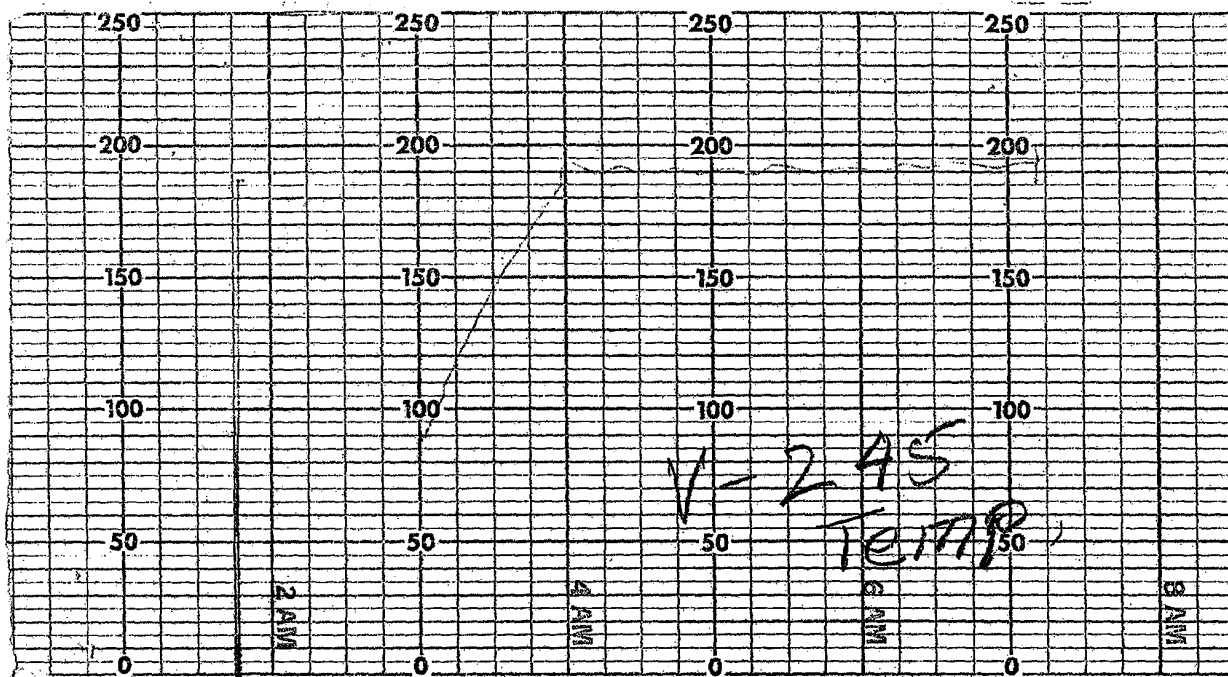
Note → STEP 29: X 1/2 90 MIN TO GET V-343 METERED LINE + SCREEN FOREIGN MATERIAL BLOCKING LINE

START	FINISH	OPERATOR
11:00 PM	11:55 PM	282-381
11:00 PM	11:55 PM	301-27
		235-320

SEE LOG

245

225
90
315



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