

03 04 CODE KJ-786-D PKG 5084* () KJ-786-D (P) FWP 10/04/82
 NOV 2, 1982 L2H89 (EST WGT) COMPTYP JOBNAME: 04K0786DMP
 (DATE) (LOT) Y TIME: 7:00 P.M., STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC-16	94	J1314	200	100.00	4	50	200	200
	01	YC-10	93	J2K69	4000	100.00	80	50	4000	4000
	01	YC-10	93	J2J04	100	100.00	2	50	100	100
	01	YC-10	93			100.00				

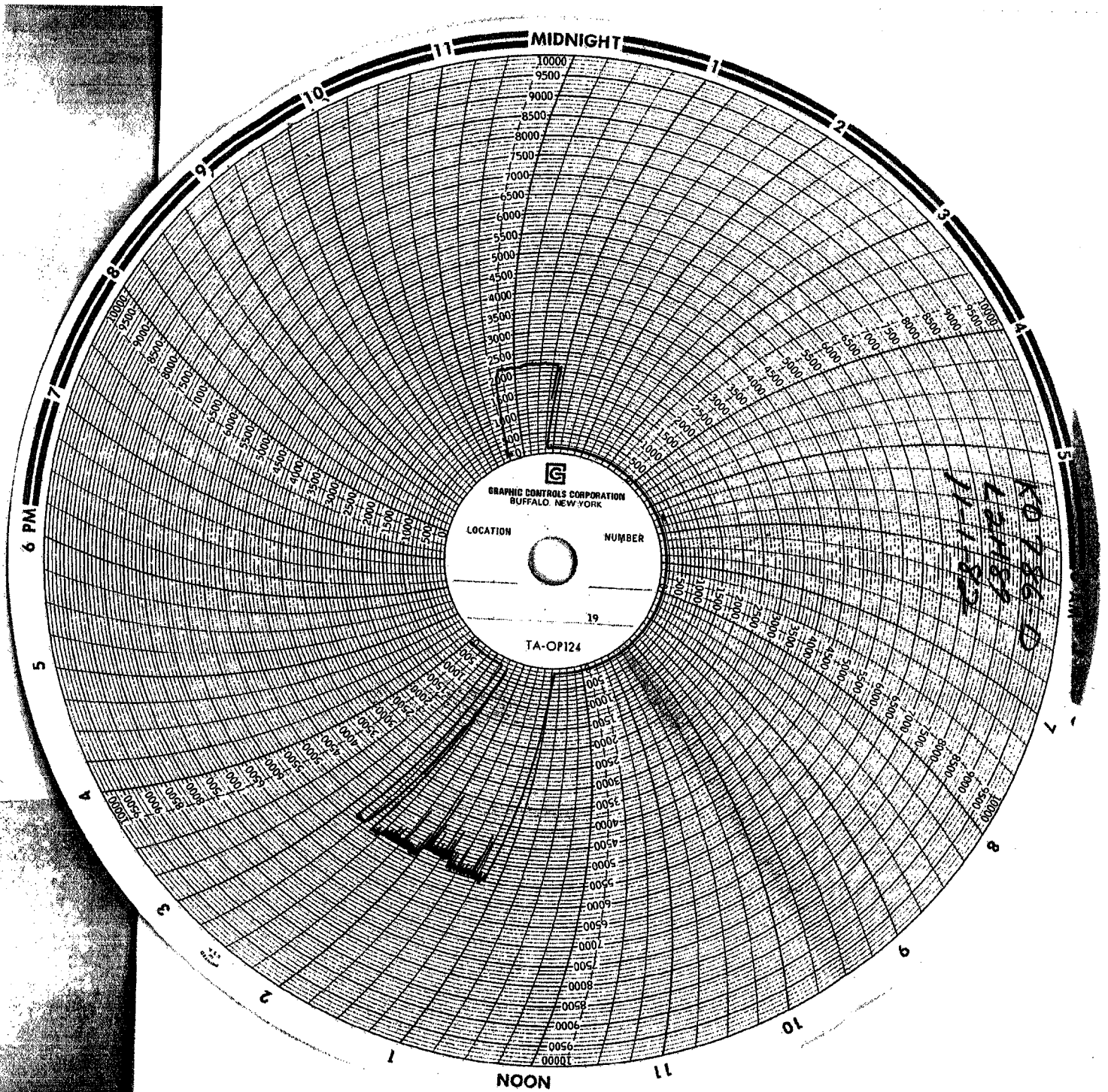
SUBSTANDARD BLEND-BACK FOR S-40: CODE _____, LOT _____, PQ _____, REQ. NO. (11070) NON-BLEEDING

EQUIP MENT	NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
211	BEFORE USING SV, MAKE SURE THAT N-28-D (HYDRO-CHLORIC ACID) LINE, IF ANY IS BLANKED OFF.			
208	1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2 WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	270	32-D	270
	3 DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	82X50	YC10B	4100
	RECORD: START 8:30 AM, LOT J1314, FIN 7:00 PM, J2K69, J2J04	4X50	YC16B	200
	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 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. 43 & ADJUST TO 50" (1840G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 15" (771 G) WATER INTO V-246 START			
	10 AGITATOR & INSTALL TEMP CHART			
SV	11 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 1:00 PM, TOTAL MINUTES 110			
	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	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	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 16 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.082/ML (1.078-1.081)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			
	19 RECORD: PH 10.8 & 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	
	SIPHON N-7-D INTO SV & RECORD: PH			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT			
	& RECORD: *F			

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EQUIP	MENT	PAGE 2 CG 04 KO-786-D	246	USE	N-	ACCT
				LBS	CODE	LBS
343	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO				
&	22	METER IN (SULFURIC ACID 60%) FROM V-386			27-D	355
386	23	STIR 15 MIN OR LONGER				
5	24	RECORD: DENSITY 1.018 G/ML (1.018-1.020)				
SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0				
6	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				
		AT 190-194°F DURING STRIKE				
	29	RECORD: START FINISH MINUTES				
		V-343 3:55P 3:25				
		V-349 18.0 6:58				
		TIME V-343 V-349 SV NORMAL				
		INCHES INCHES PH PH				
		AT 20 MIN 4:15 (47) 51 (20) 20 9.9 (9.3-10.0)				
		40 MIN 4:35 (43) 47 (17) 16 9.8 (9.3-10.0)				
		1 HR 4:55 (38) 42 (15) 14 9.8 (9.3-10.0)				
		2 HR 5:55 (24) 26 (7) 7 9.7 (9.3-10.0)				
		3 HR 6:55 (10) 12 (0) 0 9.7 (9.3-10.0)				
		FINISH 7:40 (0) 0 8.0 (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	
385	30	ADD 67" (514 G) WATER TO V-385				
7	31	ADD & STIR 2 MIN		150	7-D	75
SV	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &				
		SET PUMP AT ZERO SETTING				
8	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &				
		TURN OFF PUMP MOTOR				
	34	TURN OFF STEAM				
	35	RUN IN LIQUID ALUM USING BADGER METER		600	115-D	300
	36	FLUSH ALUM LINE WITH WATER.				
	37	RECORD: PH 3.5 (3.3-3.7) & IF NECESSARY ADJ				
		(DOWN ONLY) TO 3.3-3.7 & RECORD: PH				
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA				
		BADGER METER. STIR 5 MIN AFTER EACH				
		ADDITION. ASSUME 50%			115-D	
	38	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN				
	39	RECORD: PH 5.1 (4.0-4.2) & IF NECESSARY ADJ TO				
		PH 4.0-4.2. RECORD: PH 4.1 ASSUME 77%		10	27-D	8
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%			7-D	
		SIPHON N-7-D INTO SV				
	40	WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN				
		SUBSTANDARD TO BE BLENDED BACK.				
		RECORD: CODE _____, LOT _____				
	41	STOP AGITATOR				
		START FINISH OPERATOR				
		11:00 PM 7:00 AM 409-438				
		3:00 P 3:00 P 37				
		3:00 P 3:00 P 54-126				



V-246

