

CG 04
OCT 19 1982
(DATE)

CODE KD-784-D
K2K85
(LOT)

PKG
5084*
(EST WGT)

PROCESS
() KD-784-D (P)
COMTYP JOBNAME: 04KD784DMP
TIME: 7:00 P.M. STANDARD HRS. 10.5

APPROVED BY:
FWF 09/08/82

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC-16-B	98	G2J23	300	100.00	3	50	300	300
	01	YC-10	93	F2K71	2250	100.00	23	50	2250	2250
	01	YC-10	93	J2H10	1350	100.00	27	50	1350	1350
	01	YC-10	93	J2J36	400	100.00	8	50	400	400

SUBSTANDARD BLEND-BACK FOR S-40: CODE , LOT , PQ
REQ. NO. (11000) NON-BLEEDING

EQUIP MENT	NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
211	1 4 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% (CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
208	2 WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	270	32-D	270
	3 DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	80X50	YC16B	4000
	RECORD: START 7:10 P.M. 1st LOT	400	6X50	300
	FIN 8:10 P.M. G2J23	300		
		2250		
		1350		
	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. 42" & ADJUST TO 50" (1840G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 15" (771 G) WATER INTO V-208, START AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 8:46 TOTAL MINUTES 160			
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			

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349	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	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	16 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 10.4 & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
4	ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190 *F			
	& RECORD: 194 *F			

EQUIP PAGE 2 CG 04 KO-786-D V-245 USE N- ACCT
MENT LBS CODE LBS

21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
343 V-343
& 22 METER IN (SULFURIC ACID 60%) FROM V-386 454 27-D 355
386 M 25 1145 #/GAL 31.9 GAL
5 23 STIR 15 MIN OR LONGER
24 RECORD: DENSITY 1.018 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
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
6 29 RECORD: START FINISH MINUTES
V-343 3:15 PM 7:00 PM 8:25
V-349 6:20 PM 1:35
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 3:15 (47) 48 (20) 20 9.7 (9.3-10.0)
40 MIN 3:45 (43) 50 (17) 17 9.7 (9.3-10.0)
1 HR 4:15 (38) 35 (15) 15 9.7 (9.3-10.0)
2 HR 5:15 (24) 25 (7) 7 9.7 (9.3-10.0)
3 HR 6:15 (10) 4 (0) 0 9.7 (9.3-10.0)
FINISH 7:00 (0) 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-D

385 130 ADD 67" (514 G) WATER TO V-385
7 131 ADD & STIR 2 MIN 150 7-D 75

SV 132 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
8 133 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
134 TURN OFF STEAM
135 RUN IN LIQUID ALUM USING BADGER METER 600 115-D 300
136 FLUSH ALUM LINE WITH WATER.
137 RECORD: PH 3.2 (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
138 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN
139 RECORD: PH 4.2 (4.0-4.2) & IF NECESSARY ADJ TO
PH 4.0-4.2. RECORD: PH 4.2 ASSUME 77% 28 27-D 22
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

STOP AGITATOR
START FINISH OPERATOR
7:00 AM 3:00 PM 237-438
3:00 7:30 345

