CG 04 CODE KO789D JUN-3 35975 PUNCHED & CHECKED PROCESSES ( ) KO789D (I) APPROVED BY FWP 4/28/80

EST'D WGT 1032 LBS JUN - 6 1980 ( ) ( )

STANDARD HRS. 10.8 TIME 7A M ( ) ( )

TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	34572	2200 Cu 44
01	YC016B	93	35784	2000 — 40
01	YC016B	93		4200

TOTAL EST'D WGT 5232 REQ. NO.(3430) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE 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 MINS. LOT	84X50	YC16B	4200
		RECORD: START 8 Am 34572	40		
1		FIN 9.45 Am 35784	44		
	4	ADJUST TO 75" (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HIMOG 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. 45 " & ADJUST TO 54" (1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 10" (514 G) WATER INTO V-245 & START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 3:30 A 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 & 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	2545	32-D	2545
	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: 1.083 G/ML (1.082-1.086)			
SV	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19	RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D			
4		DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	28	7-D	14
		SIPHON N-7-D INTO SV & RECORD: PH 11.3			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC: HT 192 *F & RECORD: 192 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34593

V-245

EQUIP		PAGE 2 CG 04 KO-789-D EST WGT 5232#	USE LBS	N-CODE	USE LBS
343 & 386 5	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
	24	METER IN FROM V-386 M37- 1.085#/GAL 359 GAL	_____	27-D	390
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.019 GM/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)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
SV		AT 190-194*F DURING STRIKE.			
	29	RECORD: START 7:30 FINISH 11:10 MINUTES 220			
		V-343 _____			
		V-349 _____			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 7:50 (49) ___ (20) ___ 10.0 (9.3-10.0)			
		40 MIN 8:30 (45) ___ (18) ___ 10.0 (9.3-10.0)			
		1 HR 8:45 (41) 42 (16) 16 10.0 (9.3-10.0)			
		2 1/4 HR 9:45 (25) ___ (8) ___ 10.0 (9.3-10.0)			
		3 1/2 HR 11:45 (9) ± (0) ± 9.95 (9.3-10.0)			
		FINISH 11:10 (0) ___ 7.25 (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	_____
356 7 385	30	RUN 31" (238 G) WATER INTO V-356 & HEAT TO 135-140*F			
	31	DUMP IN & STIR TO DISSOLVE	530	15-A	530
302 8	32	ADD 42" (514 G) WATER TO V-302			
	33	ADD & STIR 2 MIN	330	7-D	165
SV 9	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & 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 12:25			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.9 (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 6.4 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4 & RECORD: PH____ ASSUME 77%	_____	27-D	_____
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	_____	7-D	_____
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN	50	978-A	50
	42	STOP AGITATOR			

START	FINISH	OPERATOR
7:30 AM	9:45 AM	382
3:00 PM	11:00 PM	235-320
7:00 AM	7:00 AM	342.381
7 AM	14:30	320-301

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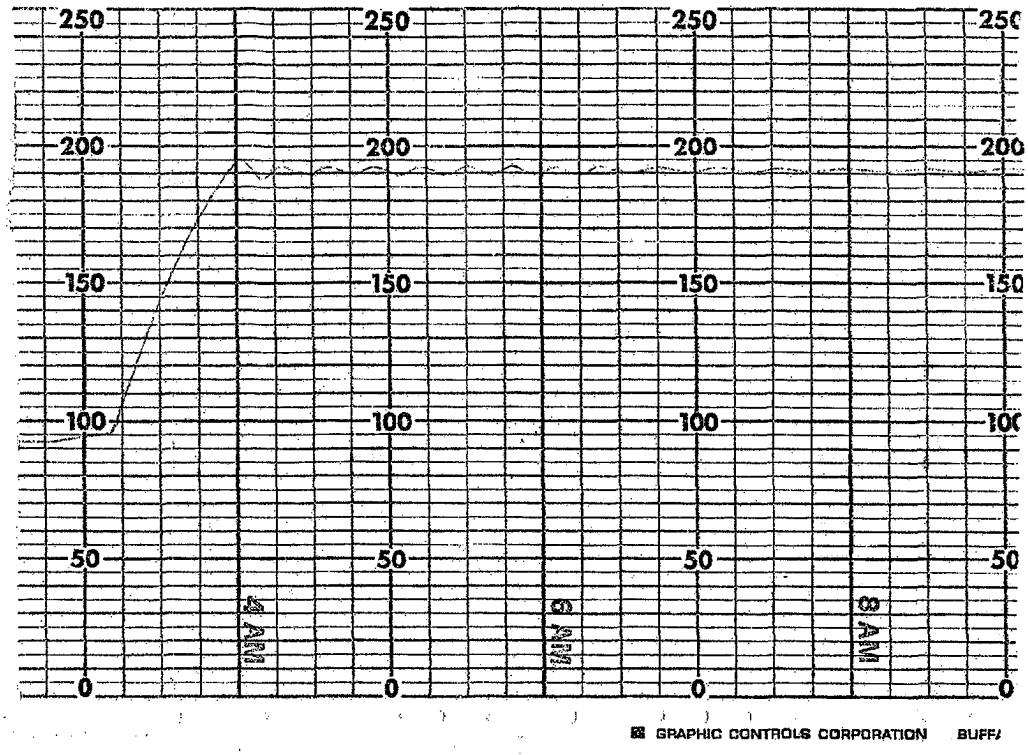

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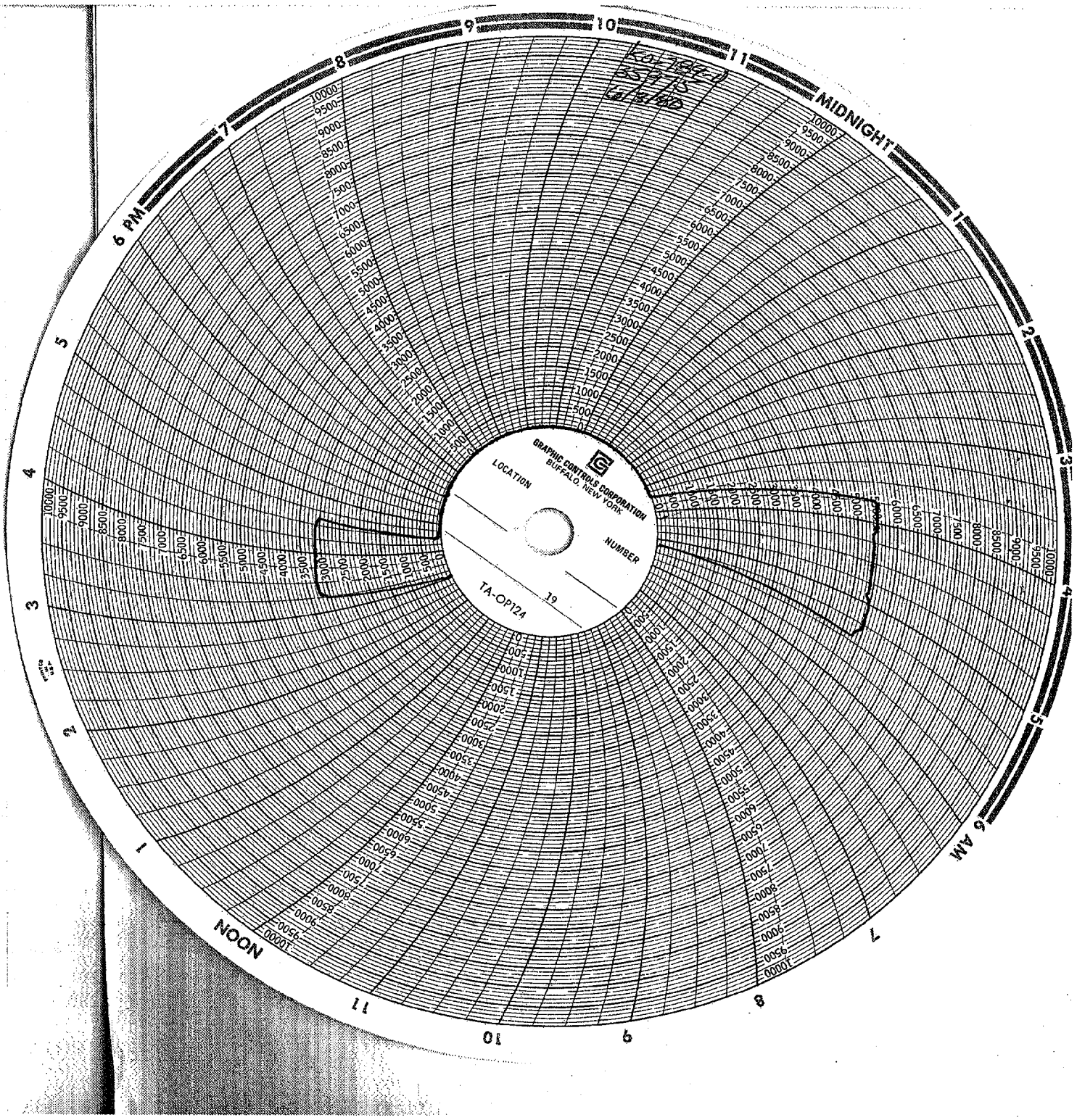

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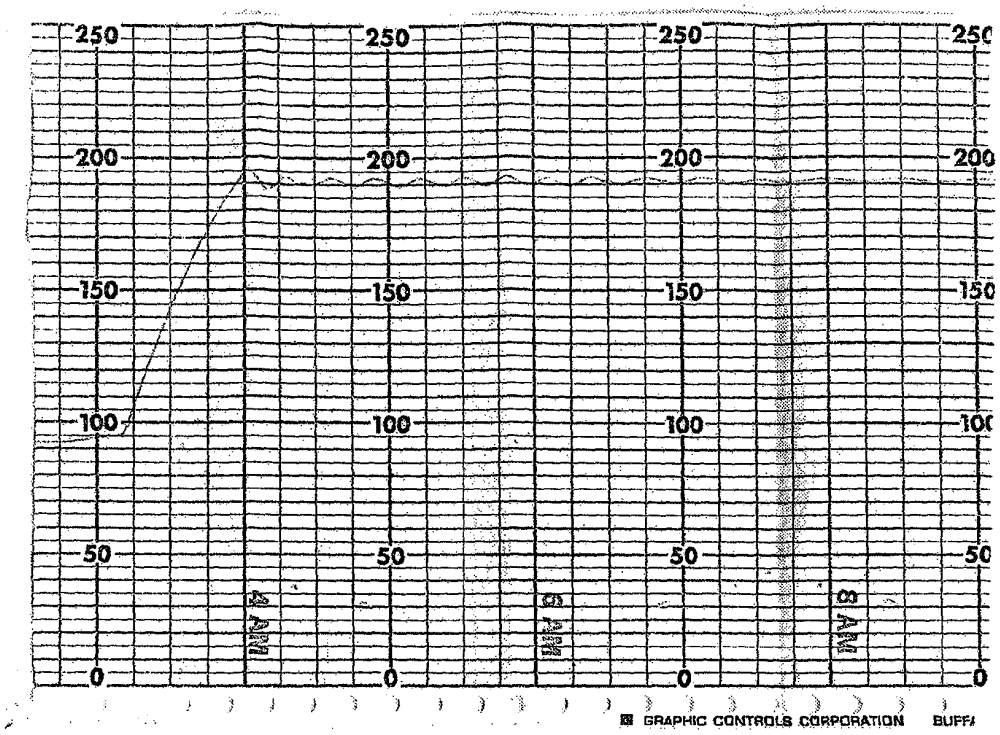

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