

CG 04

CODE KO-786-D

PKG

PROCESS

APPROVED BY

() KO-786-D (P)

FWP 06/14/82

JUN 17 1982

F2K74

5084*

(DATE)

(LOT)

(EST WGT)

COMTYP JOB NAME: 04K0786DMQ

(CONTAINS RE-WORK)

TIME: 7:00 A.M., STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT.	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	04	KO786D	98	84960-1	200	100	4	50	200	200
	01	YC-10B	93	D2H27	3600	100	72	50	3600	3600
	01	YE-7RI-D	98	D2H85	500	100	10	50	500	500

REQ. NO. (10849)

NON-BLEEDING

EQUIP MENT	NAME : "KROLOR" DRANGE R	USE LBS	N CODE	ACCT LBS.
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"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."

211 1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% 30 7-D 15
& SET AGITATOR ON HIGH SPEED

208 2 WEIGH IN DRUM AND POUR IN KO-786 200 270 32-D 270

3 DUMP IN AND STIR 5 MIN LOT D2H27 3600 2X50 YC10B 3600

1 RECORD: START 12:30 P 2:00 A D2H85 500 4X50 KO786D 200

FIN 2:00 A D2H85 500 10X50 YE7RI-D 500

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

7 HOT WATER AT 1800-2200 PSI INTO V-208

8 RECORD: V-208 VOL. 36 " & ADJUST TO 50" (1840G)

9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY

208 9 RUN 15" (771 G) WATER INTO V-246, START
& AGITATOR & INSTALL TEMP CHART

SV 10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.
RECORD: TIME START 8:00 P TOTAL MINUTES 150

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 1.0826 G/ML (1.078-1.081) JUN 21 1982

SV 18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)

19 RECORD: PH 10.6 & 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 *F

& RECORD: *F

N20214

JES
6/18

EQUIP PAGE 2 CG 04 KO-786-D V-246 USE N- ACCT
MENT LBS CODE LBS

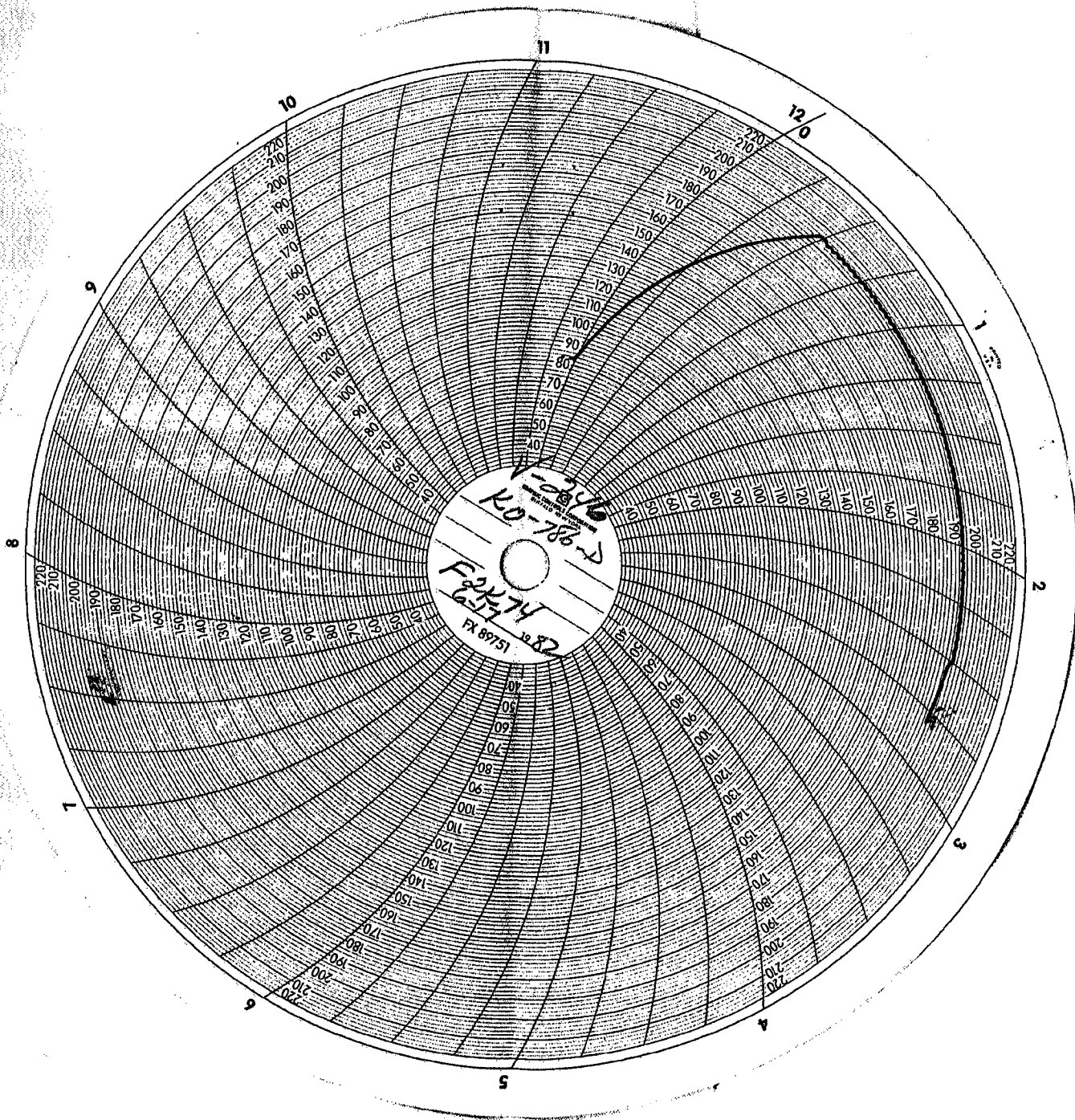
343 21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
& 22 V-343
386 23 METER IN FROM V-384 M 18 108.11# / GAL 32.8 GAL
5 24 STIR 15 MIN OR LONGER
24 RECORD: DENSITY 1.018 G/ML (1.018-1.020)

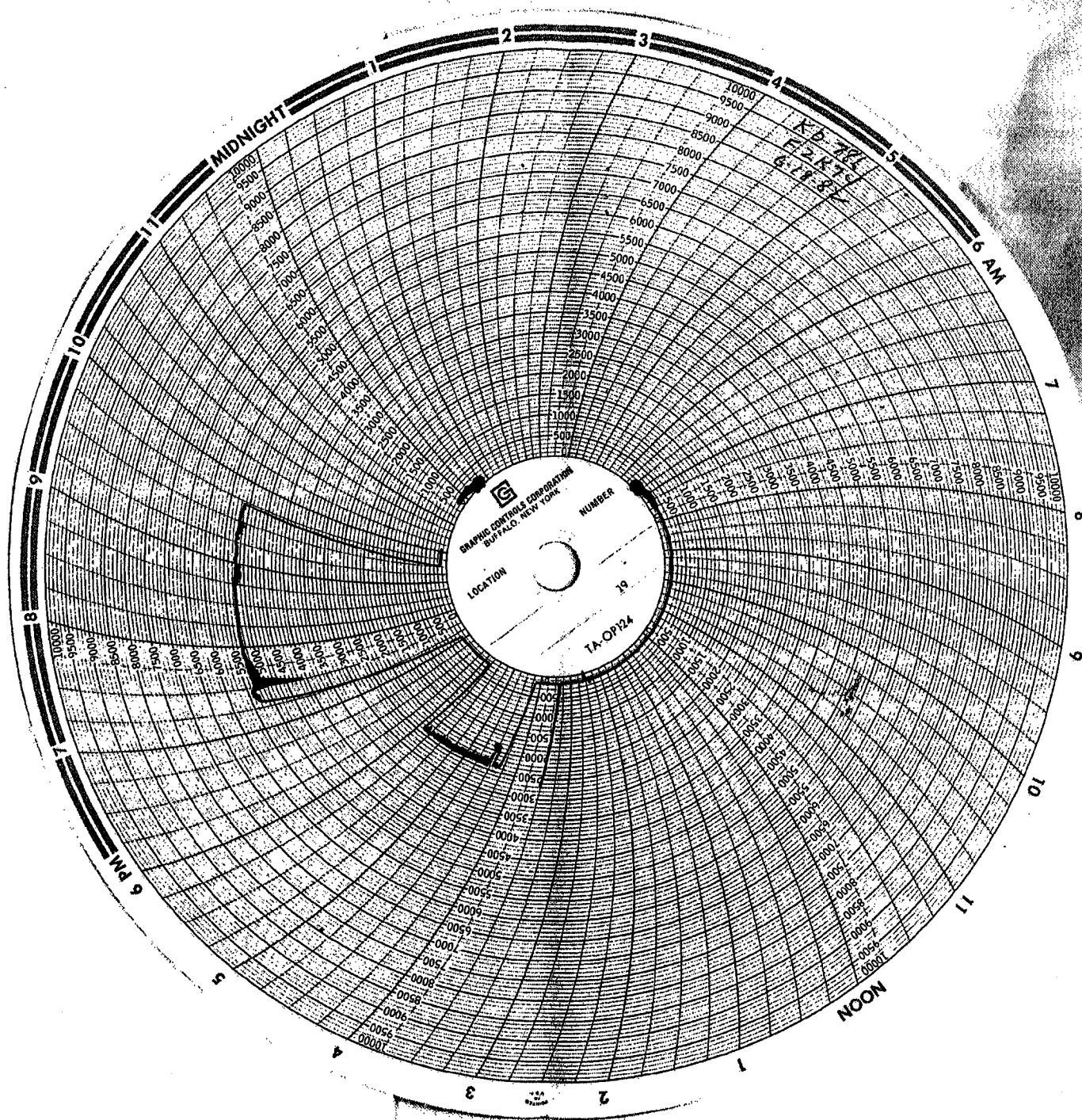
SV 25 WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9
6 26 SET V-343 ACID PUMP AT 72 SETTING (225 MIN)
27 SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)
28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
AT 190-194°F DURING STRIKE
29 RECORD: START FINISH MINUTES
V-343 1:00 A.M. 4:49 A.M. 2:29
V-349 1:00 A.M. 4:02 A.M. 1:02
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 1:20 (47) 48 (20) 20 9.5 (9.3-10.0)
40 MIN 1:40 (43) 44 (17) 17 9.5 (9.3-10.0)
1 HR 2:00 (38) 38 (15) 15 9.5 (9.3-10.0)
2 HR 3:00 (24) 24 (7) 7 9.5 (9.3-10.0)
3 HR 4:00 (10) 11 (0) 0 9.5 (9.3-10.0)
FINISH 4:45 (0) 24 (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 &
8 33 SET PUMP AT ZERO SETTING
34 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
35 TURN OFF PUMP MOTOR
36 TURN OFF STEAM
37 RUN IN ALUM USING BADGER METER 600 115-A 300
38 FLUSH ALUM LINE WITH WATER.
39 RECORD: PH 3.4 (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-A
38 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN
39 RECORD: PH 3.9 (4.0-4.2) & IF NECESSARY ADJ TO
PH 4.0-4.2. RECORD: PH 4.0 ASSUME 77% 27-D
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 10 7-D 5
40 SIPHON N-7-D INTO SV
STOP AGITATOR

START FINISH OPERATOR
2:49 A.M. 4:49 A.M. 32-229
11-11-11 5-9-114





N-246