

EST'D WGT 862 LBS 38429

STANDARD HRS. 10.5 TIME M

RO-786-D (P) FWP 11/20/80
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 JOB NAME: 04K0786DMP

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36782	3350
01	YC010B	93	36262	750
01	YC010B	93		

OK / PUNCHED & CHECKED
 JAN 1 1981

TOTAL EST'D WGT 4962

REQ. NO. 1

EQUIP		NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
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	280	983-D	280
	3	DUMP IN AND STIR 5 MIN	82X50	YC10B	4100
		RECORD: START 11:05	36782		
		FIN	36262		
	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. 52" & ADJUST TO 50" (1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9	RUN 15" (771 G) WATER INTO V-211, START			
&		AGITATOR & INSTALL TEMP CHART			
SV	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 12:15 TOTAL MINUTES 120			
	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	2450	983-D	2450
	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: 1.079 G/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 187°F			
		& RECORD: 19.9°F			

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N34551

		V-247	LBS	CODE	LBS
343	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
&	22	METER IN FROM V-386 M. 9.64 #/GAL, 36.8 GAL		27-D	355
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.018 G/ML (1.018-1.020)			
125	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
126	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
127	27	SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)			
128	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
SV		AT 190-194°F DURING STRIKE			
129		RECORD: START FINISH MINUTES			
		V-343 5:30 9:30 240			
		V-349 5:30 8:30 120			
		5:30 TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 5:50 (47) 4 (20) 9.65 (9.3-10.0)			
		40 MIN 6:10 (43) 4 (17) 9.6 (9.3-10.0)			
		1 HR 6:30 (38) 4 (15) 9.6 (9.3-10.0)			
		2 HR 7:30 (24) 2 (7) 9.6 (9.3-10.0)			
		3 HR 8:30 (10) 1 (0) 9.6 (9.3-10.0)			
		FINISH 9:30 (0) 2.6 (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	RUN 40" (308 G) WATER INTO V-385 & HEAT TO			
7		135-140°F			
131		DUMP IN & STIR TO DISSOLVE	300	15-A	300
302	32	ADD 42" (514 G) WATER TO V-302			
B	33	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			
136		TURN OFF STEAM			
137		RUN IN V-385 FROM S 31 & STIR 5 MIN			
138		RECORD: PH 3.25 (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			
139		RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
140		RECORD: PH 4.4 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.2 ASSUME 77%	10	27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
141		STOP AGITATOR			
		START FINISH OPERATOR			
		2:00P 3:00P 7:00A 3:00P 10:20PM. 235-244			