CG 04 CODE KO-909-D PKG NOV 17 80 37930

EST'D WGT ~~4506~~ LBS

STANDARD HRS. TIME 11 AM

PROCESSES
( ) KO-909-D (C)
( ) ( )
( ) ( )
( ) ( )

APPROVED BY
FWP 11/3/80

TYPED BY: FWP 11/3/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	33698	1350
01	YC016B	93	34372	2350
01	YC016B	93	35439	200

OK / KP

USE FLAKE CAUSTIC

CLEAN UP AS YOU GO ALONG

TOTAL EST'D WGT 5296 REQ. NO.( ) 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	480	983-D	480
	3	DUMP IN AND STIR 5 MINS. LOT 78	~~74~~X50	YC16B	~~3700~~ 3900
		RECORD: START 9:30 AM 34372	2350		
1		FIN 11:45 AM 33698	1350		
		35439	200		
	4	ADJUST TO 75" (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG 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._____" & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 10" (514 G) WATER INTO V-247, START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 145P TOTAL MINUTES 135			
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	~~2500~~	983-D	~~2500~~
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349	2000	✓	2000
3	16	ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.079 G/ML ~~(1.091-1.094)~~ (1.077-1.079) 1.074	100	983	100
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60"(3084 G)			
	19	RECORD: PH 10.8 & 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%	8	721 ~~7-D~~	8
		SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT 190 *F & RECORD: 194 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

			LBS	CODE	
	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343			
343 & 386 5	22	METER IN FROM V-386 M____, 8.83#/GAL, 35.1 GAL	_____	27-D	~~373~~ 310
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.017 G/ML (~~1.018-1.020~~) (1.015-1.017)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
	26	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194*F DURING STRIKE			
SV	29	RECORD: START / FINISH / MINUTES V-343 4:30 PM / 8:15 PM / 225 V-349 4:30 PM / 7:30 PM / 180 TIME / V-343 INCHES / V-349 INCHES / SV PH / NORMAL PH AT 20 MIN 4:50 PM (46)___ (17)___ 9.8 (9.3-10.0) 40 MIN 5:10 (41)___ (15)___ 9.8 (9.3-10.0) 1 HR 5:30 (37)___ (13)___ 9.8 (9.3-10.0) 2 HRS 6:30 (23)___ (6)___ 9.6 (9.3-10.0) 3 HRS 7:30 (10)___ (0)___ 9.6 (9.3-10.0) FINISH 8:15 (0)___ 6.9 (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	_____
	30	~~SIFT IN~~	~~50~~	~~128-A~~	~~50~~
385 7	31	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140*F			
	32	PUMP IN & STIR TO DISSOLVE FOR S-61	477	15-A	477
302 8	33	ADD 38" (465 G) WATER TO V-302	148		
	34	ADD & STIR FOR 2 MIN FOR S 64 ASSUME 50%	~~296~~	721-D	148
	35	DURING STRIKE PUMP INTO PT	482	169-A	482
PT 9	36	PUMP IN	54	155-A	54
	37	PUMP IN	54	160-A	54
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			
	39	DURING STRIKE RUN 15" (268 G) WATER INTO V-356			
	40	TURN ON STEAM			
356 10	41	ADJ TO 21" (366 G) AT 81-82*C			
	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE			
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN			
	44	SHUT OFF PUMP			
	45	STIR 30 MIN AT 81-82*C FOR S 55			
	46	DO NOT SHUT OFF AGITATOR			

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SV	41	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
11	42	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	43	STIR 60 MIN AT 190-194*F			
	44	HEAT TO 198-200*F IN 5-10 MIN			
	45	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
	52	OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP INLET			
	53	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
	54	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
	55	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200*F.			
	56	WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
	57	WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT WATER FROM HOT WATER MIXER			
	58	TURN OFF HOMOG & STEARATE PUMP			
	59	STIR 5 MIN AT 198-200*F			
	60	SHUT OFF STEAM			
	61	RUN IN V-385 FROM S-32 & STIR 5 MIN			
	62	RECORD: PH 3.0. (3.4-3.8)			
	63	IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH____.			
	64	RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN			
	65	RECORD: PH 5.8. (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH 6.4. ASSUME 78%	____	27-D	____
		(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	12	7-D	12
		SIPHON N-7-D INTO SV		7L1	
	66	DO NOT STOP AGITATOR			

700 A 3:00 AM

300 P 10:30 PM

381-259 237-244

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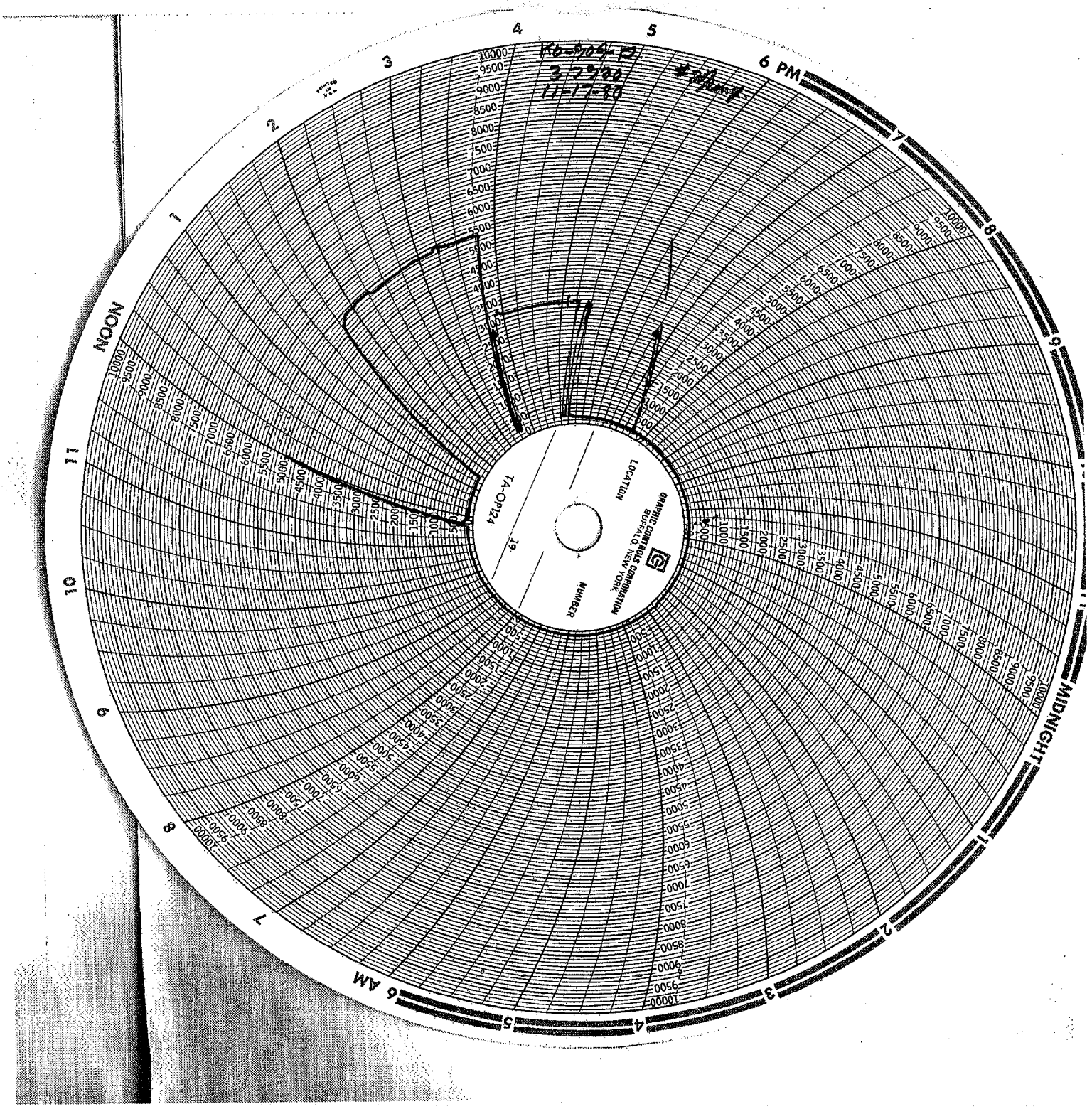

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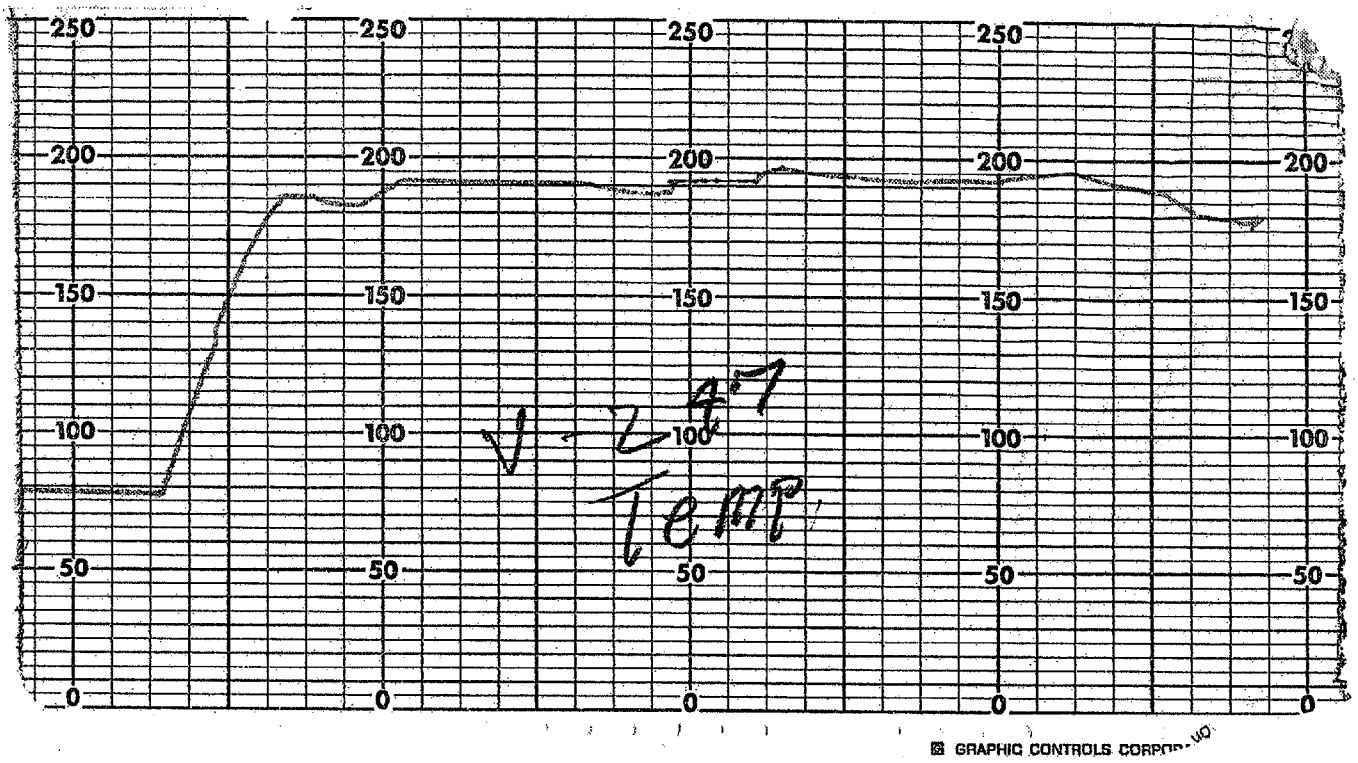

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