CG 04 CODE KO-786-D FKG

PROCESS ( ) KO-786-D (P) APPROVED BY FWP 06/14/82

JUN 25 1982 (DATE) F2L43 (LOT) 5084* (EST WGT)

COMTYP JOB NAME: 04KO786DMQ (CONTAINS RE-WORK)

TIME: 11:00 P.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-10	93	A21C39	1200	100	24	50	1200	1200
	01	YC-10	93	A21C41	2400	100	48	50	2400	2400
	01	YC-721D	98	02H90	500	100	10	50	500	500

WAREHOUSE REQUISITION NO. 10881 NON-BLEEDING

EQUIPMENT		NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2	WEIGH IN DRUM AND POUR IN	270	32-D	270
	3	DUMP IN AND STIR 5 MIN LOT	2X50	YC10B	3600
		RECORD: START 3PM 84960	4X50	KO786D	200
1		FIN 6PM A21K39	10X50	YC-721-D	500
		A21K41			
	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._____" & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV 2	9	RUN 15" (771 G) WATER INTO V-208, START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START 7:00PM TOTAL MINUTES 25			
		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 3	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	2400	32-D	2400
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.078 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			

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LOT= _____ _ COMTYP JOB NAME = 04K0786DMP PAGE 02 DATE PRINTED: 6/16/82

EQUIPMENT		PAGE 2 CG 04 KO-786-D V-246	USE LBS	N-CODE	ACCT LBS
4	19	RECORD: PH 10.5 & ADJ TO 10.4-10.8 USING N-7-D 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			
	21	WHILE HEATING SV, RUN 51* (1400 G) WATER INTO			
343 & 386 5		V-343			
	22	METER IN FROM V-386 M 19, 10,896 GAL 32.6 GAL	_____	27-D	355
	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 9.8			
	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 6		AT 190-194*F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 2:30PM 6:25 3:55			
		V-349 2:30PM 5:35 1:85			

	TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
AT 20 MIN	2:50	(47) 48	(20) 20	9.6	(9.3-10.0)
40 MIN	3:10	(43) 44	(17) 12	9.6	(9.3-10.0)
1 HR	3:30	(38) 39	(15) 15	9.6	(9.3-10.0)
2 HR	4:30	(24) 29	(7) 8	9.7	(9.3-10.0)
3 HR	5:30	(10) 13	(0) 1	9.8	(9.3-10.0)
FINISH	6:15	(0) ___		____	(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: 7.5 PH			
		ASSUME 77%	_____	27-D	_____
385 7	30	ADD 67* (514 G) WATER TO V-385			
	31	ADD & STIR 2 MIN	150	7-D	75
SV 8	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	34	TURN OFF STEAM			
	35	RUN IN ALUM USING BADGER METER	600	115-A	300
	36	FLUSH ALUM LINE WITH WATER.			
	37	RECORD: PH 3.3 (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 4.2 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH ___ ASSUME 77%	_____	27-D	_____
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	_____	7-D	_____
	40	SIPHON N-7-D INTO SV			
		STOP AGITATOR			

START	FINISH	OPERATOR
8:10 PM	11:1 PM	54-114
3:00 pm	11:00 pm	320
11 A	7 A	120-306

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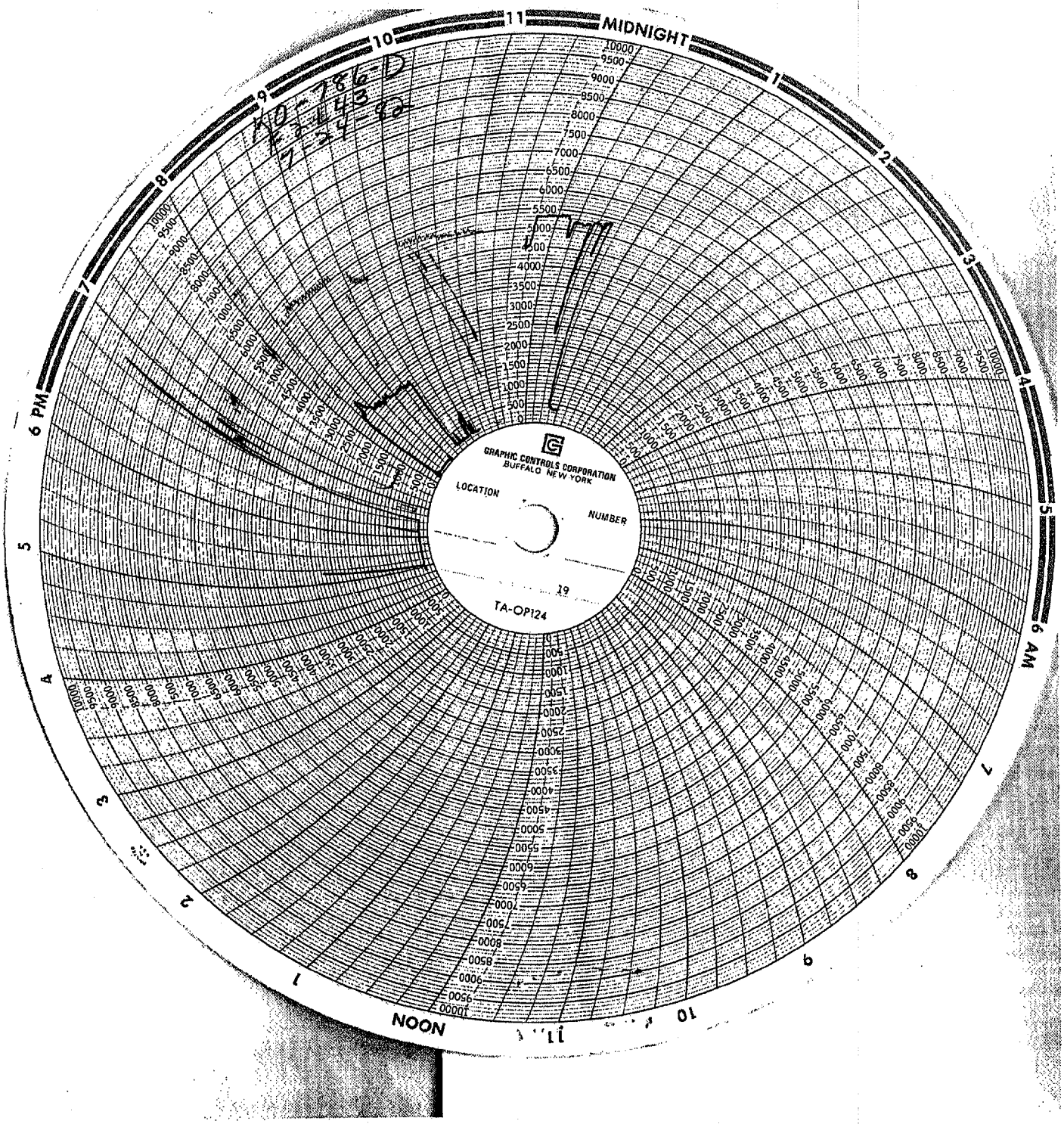

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