

CG 04

CODE KO-789-D

PKG

PROCESSES

APPROVED BY:

NOV 12 1982

L2J58

5179*

() KO-789-D (I)

FWP 11/04/82

COMTYP JOB NAME: 04KO789DMI

(DATE)

(LOT)

(EST. WGT)

WAREHOUSE REQUEST NO.

110.30

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC016B	93	12J89	3300	100.00	66	50	3300	3300
	01	YC016B	93	12J87	900	100.00	18	50	900	900
	01	YC016B	93			100.00		50		
	01	YC016B	93			100.00		50		
	01	YC016B	93			100.00		50		

EQUIP	NAME : 'KROLOR' ORANGE Y	NON-BLEEDING	USE LBS	N-CODE	ACCT LBS
211	BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF.				
208	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.				
	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)		530	32-D	530
	DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)		84X50	YC16B	4200
	RECORD: START 3:00 PM LOT 12J89		3300		
	FIN 5:45 PM LOT 12J87		900		
	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.				
	RECORD PH: (9.0-10.5)				
	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208				
	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208				
	RECORD: V-208 VOL. 49" & ADJUST TO 54" (1890G)				
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY				
208	RUN 10" (514 G) WATER INTO V-246 START				
SV	AGITATOR & INSTALL TEMP CHART				
	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.				
	RECORD: TIME START 8:00 AM TOTAL MINUTES 80				
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208				
	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV				
349	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349				
384	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F				
	WEIGH INTO V-384 & PUMP TO V-349		2545	32-D	2545
	RUN 1000# WATER INTO V-384 & PUMP TO V-349				
	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN				
	RECORD DENSITY: 1.085 G/ML (1.082-1.086)				
SV	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)				
	RECORD: PH 10.2 & ADJ TO 11.1-11.3 USING N-7-D				
	(CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%		20	7-D	10
	SIPHON N-7-D INTO SV & RECORD: PH 11.1				
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT *F				
	& RECORD: *F. STRIKE MUST START IMMEDIATELY				

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EQUIP MENT	PAGE 2 CG 04 KO-789-D	USE LBS	N- CODE	ACCT LBS
343 & 386	21 WHILE HEATING SV, RUN 52° (1430 G) WATER INTO V-343 22 METER IN (SULFURIC ACID 60%) FROM V-386 23 STIR 15 MIN OR LONGER 24 RECORD: DENSITY <u>1.020</u> G/ML (1.018-1.020) NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE. BE SURE HOSE IS NOT IN UNDERSURFACE STRIKE LINE	<u>353</u>	27-D	390
SV 6	25 WHEN S 20 HEATING COMPLETE, RECORD: PH <u>9.7</u> 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 AT 190-194°F DURING STRIKE 29 RECORD: START <u>10:25 AM</u> FINISH <u>2:40 PM</u> MINUTES <u>205 PM</u> V-343 <u>10:25 AM</u> V-349 <u>2:00 PM</u> <u>2:15 PM</u> TIME V-343 V-349 SV NORMAL INCHES INCHES PH PH AT 20 MIN <u>10:45</u> (49) <u>50</u> (20) <u>20</u> <u>9.5</u> (9.3-10.0) 40 MIN <u>11:05</u> (45) <u>46</u> (18) <u>18</u> <u>9.5</u> (9.3-10.0) 1 HR <u>11:25</u> (41) <u>42</u> (16) <u>16</u> <u>9.4</u> (9.3-10.0) 2 1/4 HR <u>12:40</u> (25) <u>26</u> (8) <u>8</u> <u>9.4</u> (9.3-10.0) 3 1/2 HR <u>1:36</u> (9) <u>9</u> (0) <u>0</u> <u>9.9</u> (9.3-10.0) FINISH <u>2:40</u> (0) <u>0</u> <u>0</u> <u>7.0</u> (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: <u>7.0</u> PH ASSUME 77%			
385 & 7	30 ADD 67° (514 G) WATER TO V-385 31 ADD & STIR 2 MIN	330	7-D	165
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 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM RECORD: START <u>2:40 PM</u> 35 RUN IN LIQUID ALUM USING BADGER METER 36 FLUSH ALM LINE WITH WATER 37 RECORD: PH <u>3.6</u> (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH <u>---</u> NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50% 38 RUN IN N-7-D FROM S31 IN 10-12 MIN & STIR 5 MIN 39 RECORD: PH <u>6.4</u> (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH <u>---</u> ASSUME 77% DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% SIPHON N-7-D INTO SV 40 POUR IN (PLASTOLEIN 9746A) & STIR 15 MIN 41 STOP AGITATOR	1060	115-D	530
	START <u>6:00 AM</u> FINISH <u>7:00 AM</u> OPERATOR <u>126</u> <u>7:00 AM</u> <u>3:00 PM</u> <u>3:01</u> <u>3:00 PM</u> <u>2:15 PM</u> <u>2:27</u>			



