

246, (247)

C.V.

D.V.

PG 04 CODE KO-789-D PKG:

1/25 JAN 24 33998

WGT 1032 1132 LBS.

10.8

TIME

11P

01 YC-16-B 93 4 Lot 33911, 1150 #

01 YC-16-B 93 4 Lot 33751, 1450 #

01 YC-16-B 93 4 Lot 33841, 1600 #

PROCESSES		APPROVED BY	
() KO-789-D	(I)	EWK	09-21-76
()	()	DCG	09-21-76
()	()	MTW	10-02-76
()	()	FWP	02-05-79
TYPED BY			
emw020579			

04 K0909 98 32769 570 #
 NOTE - ADD AT STEP #29

Total Weight 5332# (Req)

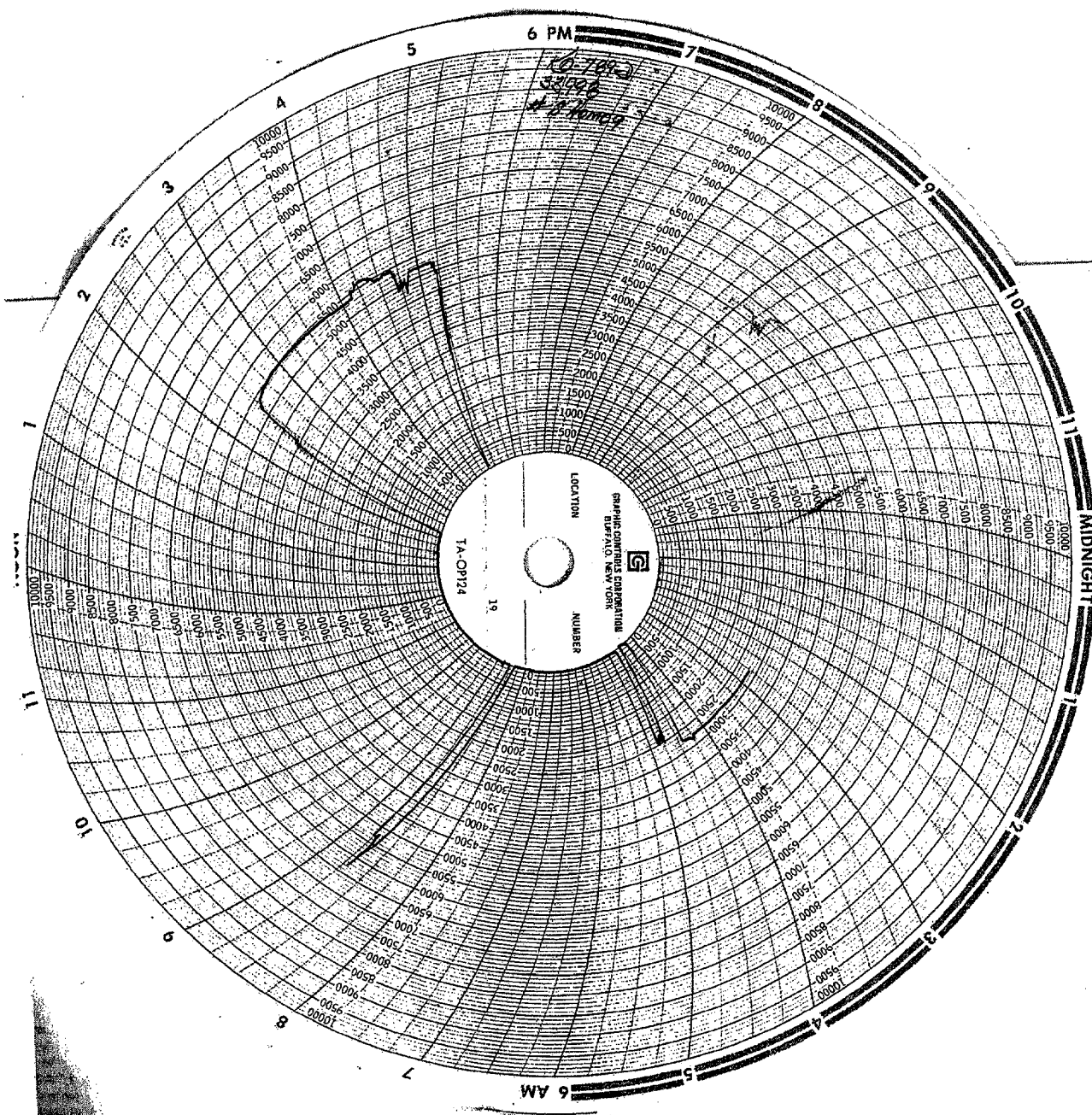
NON-BLEEDING

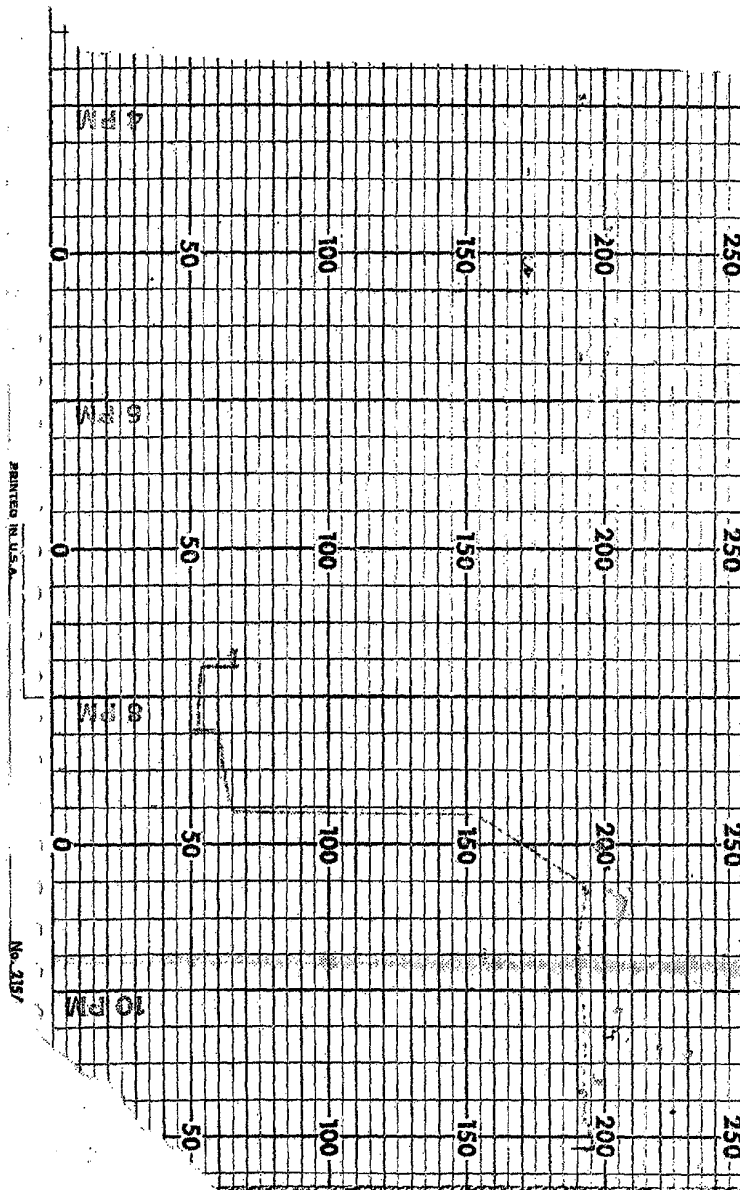
EST	NAME:	USE LBS.	N CODE	ACCT LBS.
211	1 Run 60" (990 G) water into V-211			
&	2 Weigh in drum & pour in	530	32-D	530
208	3 Dump in & stir 5 min	84 x 50	YC-16-B	4200
1	Record: Start 1130 PM	33911	1150	
	Fin 100 AM	33751	1450	
		33841	1600	
	4 Adj to 70" (1200 G) 2800-3300			
	5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi			
	minimum water. Use Hot Water			
	7 Record: V-208 Vol 42" & adj to 54" (1890 G)			
	8 Inspect Homog strainer & clean if necessary			
208	9 Run 10" (514 G) water into V-247 & start agitator &			
&	install temperature chart			
SV	10 Pump V-208 thru Homog at 4800-5200 psi into SV- 247			
	Record: Time Start 2:30 PM, Total Min 170			
	NOTE: If homog pressure falls below 4800 psi, 3-way			
	valve will recirculate slurry to V-208			
	11 When V-208 MTY, run in 5" (240 G) water & pump thru			
	at 4800-5200 psi. Rinse in using Hot Water			
349	12 While Homog, run 6" (284 G) water into V-349			
&	13 Run ± 1000 # water into V-384 & heat to 110-120°F	2545		2545
384	14 Weigh into V-384 & pump to V-349	2930	32-D	2930
3	15 Run ± 1000 # water into V-384 & pump to V-349			
	16 Adj V-349 to 36" (1400 G) & stir 10 min or longer 25" (1040 G)			
	17 Record: 0Be 1.085 (10.0 ± 0.2) (1.082 - 1.086)			
SV	18 When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19 Record: pH 10.8 & adj to 11.1-11.3 using N-7-D diluted to			
	5% (10 parts water to 1 part N-7-D) Assume 50%	18	7-D	6
	Siphon N-7-D into SV & Record: pH 11.2			
	20 Heat to 190-194°F in 55-65 min & Record: HT 19V of			
	& Rec 19V of			
	NOTE: Strike must be started immediately on completion			
	of heating 52" (1430 G)			
343	21 While heating SV, run 70" (1920 G) water into V-343			
&	22 Meter in from V-386 M 12, 94681 Gal 42.2 Gal			
386	23 Stir 15 min or longer			
	Record: 0Be 1.019 (2.5 ± 0.1) (1.019 - 1.021)			

440
 Hec
 JN

V-247

COMPONENT	PAGE 2	CG 04	CODE K0-789-D (I)	EST. WGT.	5332 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	25	When S 20 heating complete, Record: pH <u>10.1</u> (9.6-10.2)						
6	26	Set V-343 acid pump at <u>8 1/2</u> setting (± 255 minutes) <u>65</u>						
	27	Set V-349 silicate pump at <u>18</u> setting (± 210 minutes) <u>54</u>						
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike						
	29	Record: Start Fin Min						
		V-343 <u>7:00 P.M.</u> V-349 <u>10:45 P.M.</u> SV <u>225</u>						
		Record:	Time	V-343	V-349	SV	Normal	
				in	in	pH	pH	
		at 20 min	<u>7:20 P.M.</u>	<u>(65) 49.48</u>	<u>(27) 20.20</u>	<u>9.9</u>	9.3-10.0	
		40 min	<u>7:40 P.M.</u>	<u>(68) 45.45</u>	<u>(28) 18.18</u>	<u>9.8</u>	9.3-10.0	
		1 hr	<u>8:00 P.M.</u>	<u>(65) 41</u>	<u>(28) 16</u>	<u>9.8</u>	9.3-10.0	
		2 1/2 hrs	<u>9:15 P.M.</u>	<u>(34) 25</u>	<u>(18) 8</u>	<u>9.8</u>	9.3-10.0	
		3 1/2 hrs	<u>10:30 P.M.</u>	<u>(28) 9-11</u>	<u>(0) 1+</u>	<u>9.8</u>	9.3-10.0	
		Finish	<u>11:15 P.M.</u>	<u>(0)</u>		<u>6.0</u>	7.5-8.5	
		NOTE: If pH drops below 9.3 in 1st hr, stop pumps & see Supervisor. If final pH is above 8.5, adj to 7.5-8.5 & Record: pH Assume 77%					27-D	
		29A Add 1 drum at end of strike					570 K0909D	570
357	29	Run 33" (238 G) water into V-357 & heat to 135-140°F						
7	31	Dump in & stir to dissolve				530	15-A	530
302	32	Add 42" (514 G) water to V-302						
8	33	Add & stir 2 min				Assume 50%	330	7-D 165
SV	34	When V-349 MTY, rinse in with minimum water then set pump at zero setting						
9	35	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	36	Stir 30 min at 190-194°F then turn off steam						
		Record: Start <u>11:40 P.M.</u>						
	37	Run in V-357 from S 31 & stir 5 min						
	38	Record: pH <u>3.0</u> (3.4-3.8) & if necessary, adj (DOWN ONLY) to 3.4-3.8 & Record: pH					15-A	
		NOTE: Dissolve extra N-15-A in water at 135-140°F in drum, use ± 30 G water to 50# N-15-A. Stir SV 5 min after each addition						
	39	Run in N-7-D from S 33 in 10-12 min & stir 5 min						
	40	Record: pH <u>6.0</u> (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH <u>6.3</u>				Assume 77%	27-D	
		(Dilute 10 parts water to 1 part N-7-D)				Assume 50%	7-D	
		Siphon N-7-D into SV						
	41	Pour in & stir 15 min				50 25	978-A	25
	42	Stop agitator						50
		START	FIN	OPTR				
		<u>7:00 P.M.</u>	<u>11:00 P.M.</u>	<u>109-381</u>				
		<u>11:15 P.M.</u>	<u>1:15 A.M.</u>	<u>201-120</u>				





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