

JUN 4 1982

F2H79

KO-909-D (C)

FWP 03/25/82

DATE

LOT NUMBER

STD. HRS.

TIME

2 P.M.

JOB NAME: 04K0909DMC

CG	CODE	PG	LOT	LBS
01	YC-16-B	94	F1288	100
01	YC-16-B	93	B2H85	2000
01	YC-16-B	93	C2K64	1100
01	YC-16-B	93	B2H78	550

Handwritten notes:
 (2)
 Rec'd V. 247
 @ 10:45P

EST. WT. 5243* LBS.

REQ. NO. (10830)

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	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. SET AGITATOR ON HIGH SPEED			
	2 WEIGH IN DRUM AND POUR IN	480	32-D	480
	3 DUMP IN AND STIR 5 MINS. LOT	75X50	YC16B	3750
1	RECORD: START 9:30AM F1288	100		
	FIN 10:40PM B2H85	2000		
		1100		
	4 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.	550		
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208	5750		
	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. 58" & 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 11:20 TOTAL MINUTES 110			
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	2500	32-D	2500
	14 WEIGH INTO V-384 & PUMP TO V-349			
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.093 G/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	19 RECORD: PH 9.8 & 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%	20	7-D	10
	20 SIPHON N-7-D INTO SV & RECORD: PH 11.3			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT *F			
	& RECORD: *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

JUN 10 1982

Handwritten signature: (20)

343 21 WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343
& 22 METER IN FROM V-386 M 17 10.38 GAL, 36.2 GAL
386 23 STIR 15 MIN OR LONGER
5 24 RECORD: DENSITY 1.019 G/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
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
SV AT 190-194°F DURING STRIKE
6 29 RECORD: START FINISH MINUTES
V-343 245 630 225
V-349 545 545 180
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 305 (46) (17) 10.0 (9.3-10.0)
40 MIN 325 (41) (15) 10.0 (9.3-10.0)
1 HR 345 (37) (13) 9.9 (9.3-10.0)
2 HRS 445 (23) (6) 9.9 (9.3-10.0)
3 HRS 545 (10) (0) 9.5 (9.3-10.0)
FINISH 630 (0) 9.6 (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
30 SET IN 50 128 A 50

385 31 ADD 60" (465 G) WATER TO V-385
7 32 ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50% 296 7-D 148

33 DURING STRIKE CHECK LEVEL IN V-387.
387 34 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37
8 35 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING
THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE
36 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW
STEARATE MAKE-UP PROCEDURE.

37 RUN IN 27" (268 GAL). DO NOT MAKE UP THIS
SOLUTION MORE THAN 30 MINUTES IN ADVANCE.
DELAY BETWEEN END OF STEP 43 HEAT-UP AND
START OF STEP 53 HOMOGENIZATION SHOULD BE
LESS THAN 30 MINUTES.

388 38 TURN ON STEAM & AGITATOR
9 39 ADJUST TO 37" (366 GAL) AT 178-182°F
40 SET BADGER METER FOR 590
41 PUMP IN FROM V-387 THRU UNDERSURFACE
DISTRIBUTORS AS FAST AS POSSIBLE 482 169-A 482
54 155-A 54
54 160-A 54
42 SHUT OFF PUMP
43 STIR 30 MIN AT 178-182°F FOR S 53
44 DO NOT SHUT OFF AGITATOR

SV 45 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
10 46 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
47 STIR 60 MIN AT 190-194°F 730

EQUIP. | PAGE 3 CG 04 KD-909-D
MENTI | COMTYP JOB NAME: 04K0909DMC

USE | N- | ACCT
LBS | CODE | LBS

SV	10	CONT	USE	N-	ACCT
			LBS	CODE	LBS
148		HEAT TO 198-200°F IN 5-10 MIN			
149		CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
150		OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
151		OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
152		WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
153		IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
154		WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
155		WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
156		TURN OFF HOMOG & STEARATE PUMP			
157		STIR 5 MIN AT 198-200°F			
158		SHUT OFF STEAM			
159		RUN IN ALUM USING BADGER METER	950	115-D	475
160		FLUSH ALUM LINE WITH WATER			
161		RECORD: PH <u>5.2</u> (3.4-3.8)			
162		IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH <u>5.2</u> NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN. AFTER EACH ADDITION. ASSUME 50%		115-D	
163		RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
164		RECORD: PH <u>6.4</u> (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH <u>6.4</u> ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	60	27-D	
		SIPHON N-7-D INTO SV		7-D	30
165		DO NOT STOP AGITATOR			

