

CG 07

CODE KO-909-D

PKG

PROCESSES

APPROVED BY

JUN 14 1982

F2K15

DATE

LOT NUMBER

STD. HRS.

TIME

3 P.M.

JOB NAME:

04KO909DMC

CG	CODE	PQ	LOT	LBS
01	YC-16-B	93	B2H78	450
01	YC-16-B	93	C2J23	2000
01	YC-16-B	93	H1200	1200
01	YC-16-B	98	39503	100

EST. WT. 5243* LBS.

REQ. NO. (10845)

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	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
208	2 WEIGH IN DRUM AND POUR IN	480	32-D	480
	3 DUMP IN AND STIR 5 MINS. LOT B2H78	75X50	YC16B	3750
	RECORD: START 11:00	2100		
1	FIN 1:00	1200		
	4 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.	100		
	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. 58" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	1 RUN 10" (514 G) WATER INTO V-247 START			
SV	2 AGITATOR & INSTALL TEMP CHART			
	3 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 3:00 TOTAL MINUTES 120			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	4 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349	1 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	2 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F	2500	32-D	2500
	3 WEIGH INTO V-384 & PUMP TO V-349			
	4 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	5 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	6 RECORD DENSITY: 1.04 G/ML (1.091-1.094)			
SV	7 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	8 RECORD: PH 10.5 & ADJ TO 11.1-11.3 USING N-7-D			
4	9 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	10 ASSUME 50%	20	7-D	10
	11 SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	12 HEAT TO 190-194°F IN 55-65 MIN & REC: HT ____*F			
	13 & RECORD: ____*F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

JUN 16 1982

6/15

247

343 121 WHILE HEATING SV, RUN 49" (1348 G) WATER INTO
& 122 V-343
386 123 METER IN FROM V-386 N 18 14811 1/2 GAL, 34.5 GAL
5 124 STIR 15 MIN OR LONGER
124 RECORD: DENSITY 1.020 G/ML (1.018-1.020)

SV 125 WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9
6 126 SET V-343 ACID PUMP AT 69 SETTING (225 MIN)
127 SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)
128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
AT 190-194°F DURING STRIKE
29 RECORD: START FINISH MINUTES
V-343 7:30
V-349 10:40 190
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 7:50 (46) 47 (17) 17 9.7 (9.3-10.0)
40 MIN 8:10 (41) 43 (15) 15 9.7 (9.3-10.0)
1 HR 8:30 (37) 38 (13) 13 9.7 (9.3-10.0)
2 HRS 9:30 (23) 24 (6) 6 9.7 (9.3-10.0)
3 HRS 10:30 (10) 12 (0) 1 9.7 (9.3-10.0)
FINISH 11:15 (0) 0 7.6 (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%

30 SIFT IN 27-D 50

385 131 ADD 60" (465 G) WATER TO V-385
7 132 ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50% 296 7-D 148

133 DURING STRIKE CHECK LEVEL IN V-387.
387 134 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37
8 135 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING
THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE
136 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW
STEARATE MAKE-UP PROCEDURE.

137 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.

388 138 TURN ON STEAM & AGITATOR
9 139 ADJUST TO 37" (366 GAL) AT 178-182°F
140 SET BADGER METER FOR 590#
141 PUMP IN FROM V-387 THRU UNDERSURFACE
DISTRIBUTORS AS FAST AS POSSIBLE 482 169-A 482
54 155-A 54
54 160-A 54
142 SHUT OFF PUMP
143 STIR 30 MIN AT 178-182°F FOR S 53
144 DO NOT SHUT OFF AGITATOR

SV 145 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
10 146 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
147 STIR 60 MIN AT 190-194°F

EQUIP. PAGE 3 CG 04 KO-909-D
 MENT1 COMTYP JOB NAME: 04KO909DMC

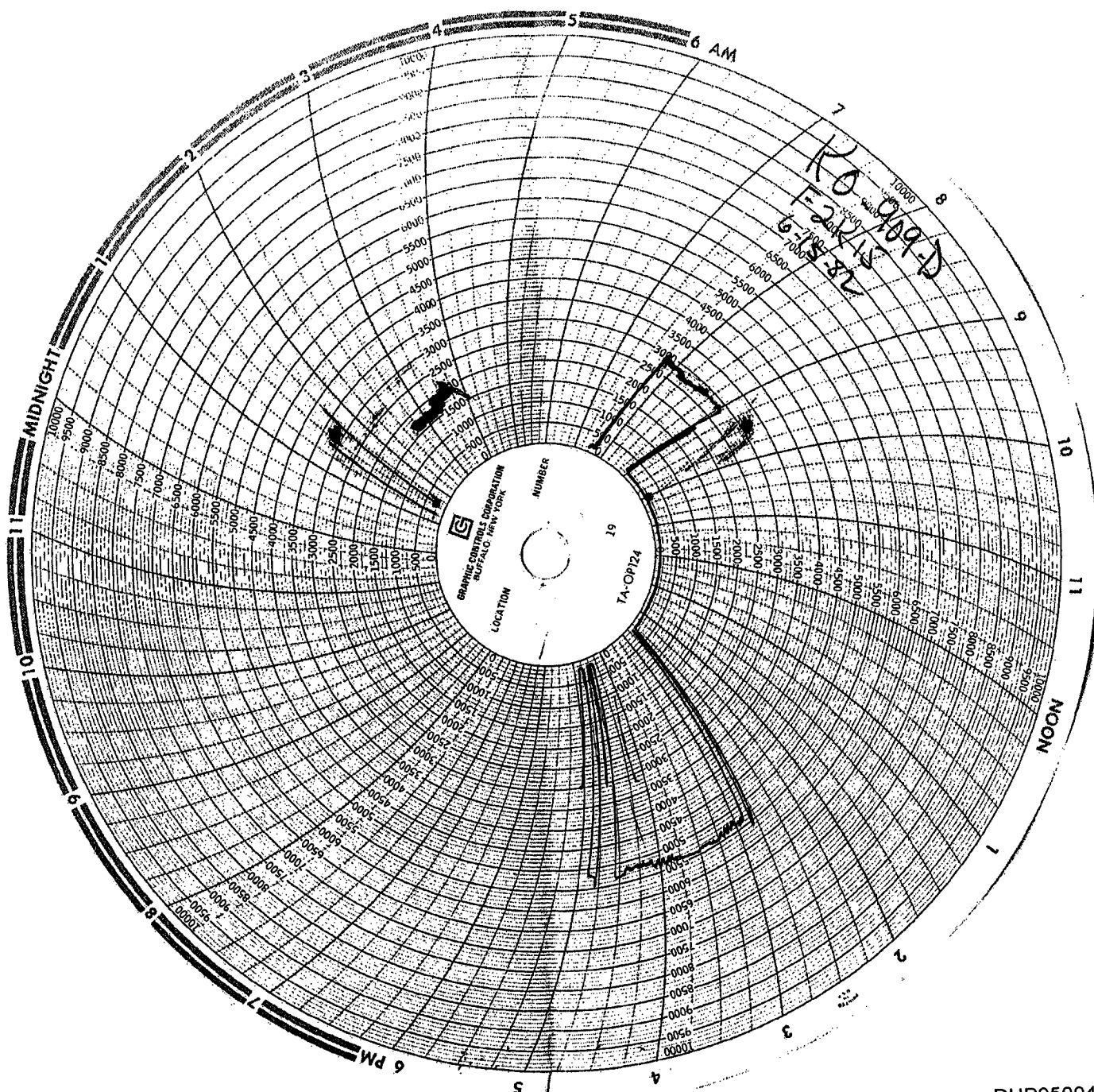
USE N- IACCT
 LBS CODE LBS

SV	10	CONT	USE	N-	IACCT
			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>3.7</u> (3.4-3.8)				
162	IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH <u>3.7</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>4.8</u> (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH <u>6.2</u> ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	24	27-D	12	
	SIPHON N-7-D INTO SV		7-D		
165	DO NOT STOP AGITATOR				

3:00 PM
 11/1/82

11:00 AM
 3/3/83

32-342
 259-114



DUP050046910

