

CG 04 CODE KO-909-D PKG

JUN 10 1982

F2K12

PROCESSES

() KO-909-D (C)

APPROVED BY
FWP 03/25/82

DATE

LOT NUMBER

STD. HRS.

TIME 11 P.M.

JOB NAME: 04KO909DMC

CG	CODE	PQ	LOT	LBS
01	YC-16-B	98	39503	100
01	YC-16-B	93	22K37	3050
01	YC-16-B	93	F2H63	600

EST. WT. 5243* LBS.

REQ. NO. (10842)

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	75X50	YC16B	3750
	RECORD: START 11:45	100		
	FIN 12 NOON	3050		
		600		
	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 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. 42" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9 RUN 10" (514 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 4:45 P TOTAL MINUTES 175			
	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 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.074/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	19 RECORD: PH 10.5 & 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%	30	7-D	15
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 120 *F			
	& RECORD: 190 *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

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V-240

343	121	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343			
386	122	METER IN FROM V-386	M17 10.318	7/GAL, 362	27-D 373
5	123	STIR 15 MIN OR LONGER			
	124	RECORD: DENSITY 1.019 G/ML (1.018-1.020)			
	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	126	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)			
	127	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)			
SV	128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
6	129	RECORD: START FINISH MINUTES			
		V-343 9:15P			
		V-349			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 9:35 (46) 43 (17) 17 10.0 (9.3-10.0)			
		40 MIN 9:56 (41) 42 (15) 16 10.0 (9.3-10.0)			
		1 HR 10:15 (37) 38 (13) 14 9.9 (9.3-10.0)			
		2 HRS 11:15 (23) 22 (6) 7 10.0 (9.3-10.0)			
		3 HRS 12:15 (10) (0) 7 9.9 (9.3-10.0)			
		FINISH 10:00 (0) 7 7.1 (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
					50 120 A 50
385	130	ADD 60" (465 G) WATER TO V-385			
7	131	ADD & STIR FOR 2 MIN FOR S 63	ASSUME 50%	296	7-D 148
	132				
	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			

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MENTI COMTYP JOB NAME: 04KO909DMC

USE N- ACCT
LBS CODE LBS

SV	10	CONT		USE	N-	ACCT
				LBS	CODE	LBS
48			HEAT TO 198-200°F IN 5-10 MIN			
49			CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
50			OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
51			OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
52			WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
53			IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
54			WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
55			WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
56			TURN OFF HOMOG & STEARATE PUMP			
57			STIR 5 MIN AT 198-200°F			
58			SHUT OFF STEAM			
59			RUN IN ALUM USING BADGER METER	950	115-D	475
60			FLUSH ALUM LINE WITH WATER			
61			RECORD: PH <u>3.7</u> (3.4-3.8)			
62			IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH _____. NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN. AFTER EACH ADDITION. ASSUME 50%		115-D	
63			RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
64			RECORD: PH <u>4.4</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%	100	27-D 7-D	50
65			SIPHON N-7-D INTO SV			
66			DO NOT STOP AGITATOR			

7:00 am

3:00 pm

320.342

