

245

CG 04 CODE KO-786-D PKG

JUNE 24 36276

EST'D WGT 842 LBS

PROCESSES

APPROVED BY

() KO-786-D (P) FWP 6/20/80

(MADE FROM CONTINUOUS UNIT
YE-698-D, JUNE '80 RUN)

STANDARD HRS. 10.5 TIME 7 PM

TYPED BY: FWP 6/20/80

CG CODE PQ LOT LBS
13 YE698D 94 24971 4000

PUNCHED & CHECKED

JUN 30 1980

70-BAG TO 60

TOTAL EST'D WGT 4842

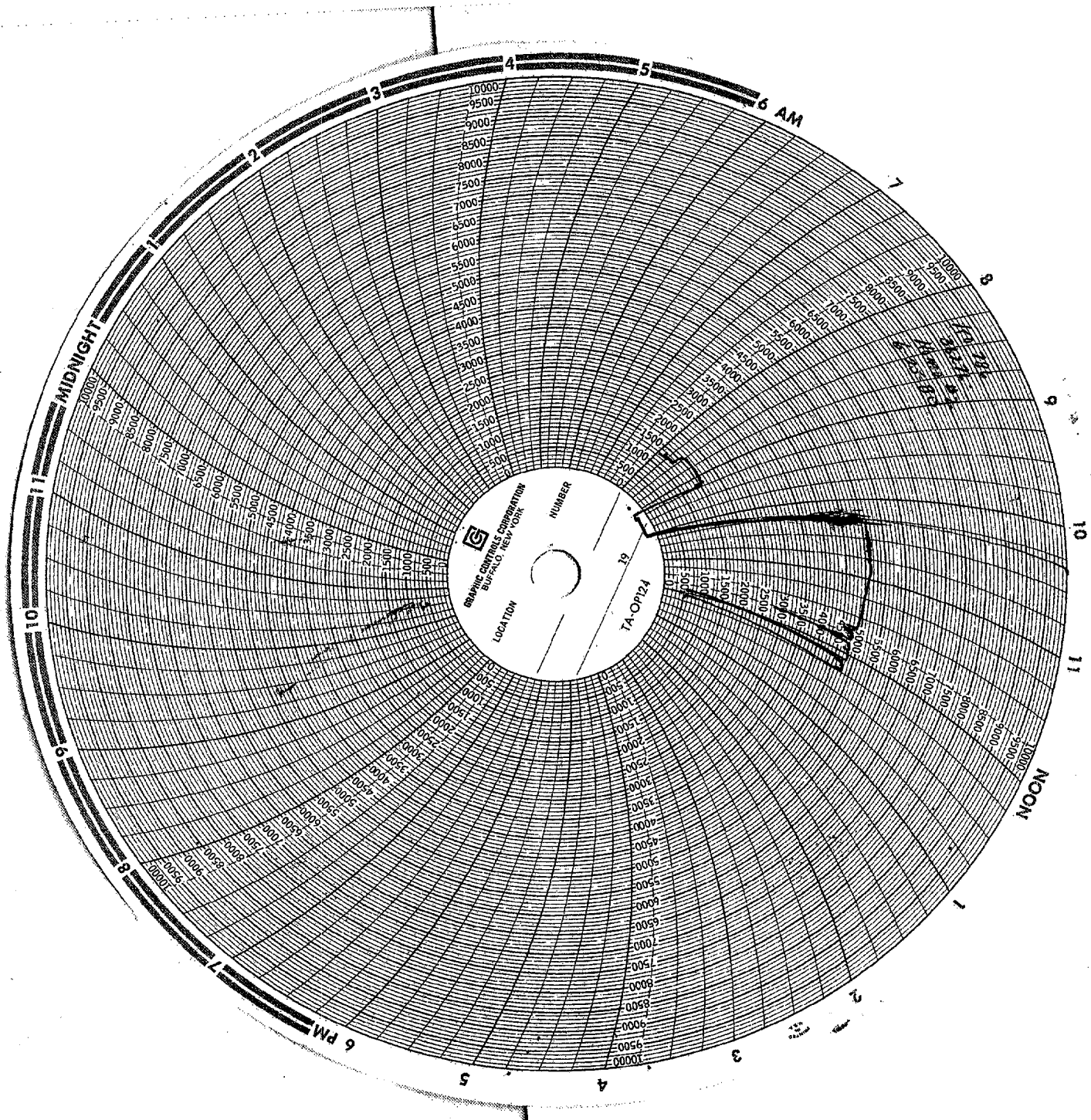
REQ. NO. ()

NON-BLEEDING

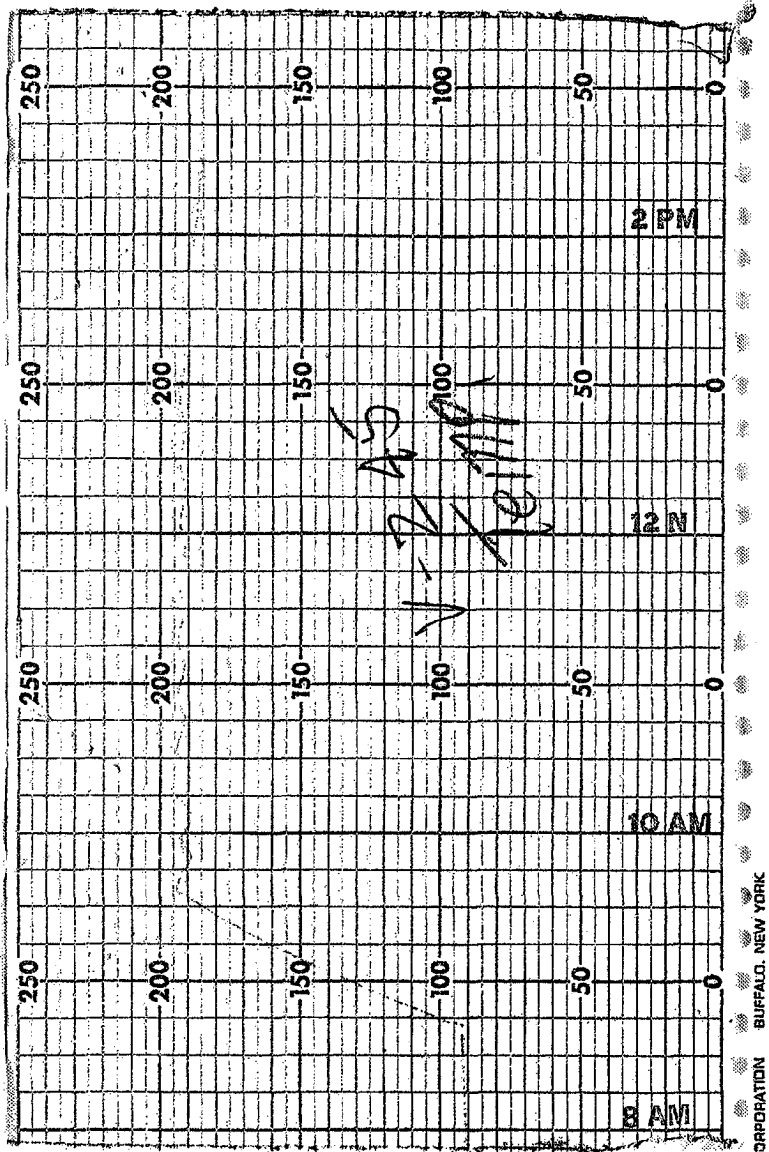
EQUIP	NAME	USE LBS	NCODE	ACC1 LBS
211	✓ RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
208	✓ WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN LOT RECORD: START 10:22 PM 24971 FIN 1 PM 4000	205 80X50	32-D YE698D	205 4000
208	✓ ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED. PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208 RECORD: V-208 VOL. " & ADJUST TO 50" (1840G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	✓ RUN 15" (771 G) WATER INTO V-245, START AGITATOR & INSTALL TEMP CHART PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 10:20A TOTAL MINUTES 120 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	112 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349 & 113 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F 384 114 WEIGH INTO V-384 & PUMP TO V-349 115 RUN 1000# WATER INTO V-384 & PUMP TO V-349 3 116 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN 117 RECORD DENSITY: 1.080G/ML (1.078-1.081)	2400	32-D	2400
SV	118 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 46" (3400 G) 119 RECORD: PH 11.0 & ADJ TO 10.4-10.8 USING N-7-D 4 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH 20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190°F & RECORD: 190°F		7-D	

N34513

EQUIP	PAGE 2	CG 04	KD-786-D	EST WGT 4962#	USE LBS	N- CODE	USE LBS
V-245							
343	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343					
&	22	METER IN FROM V-386 M <u>10.9%</u> GAL <u>31.6</u> GAL				27-D	346
386	23	STIR 15 MIN OR LONGER					
5	24	RECORD: DENSITY <u>1.018</u> G/ML (1.016-1.018)					
25 WHEN S 20 HEATING COMPLETE, RECORD: PH <u>10.1</u>							
26 SET V-343 ACID PUMP AT 72 SETTING (225 MIN)							
27 SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)							
28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV							
SV	AT 190-194°F DURING STRIKE						
29	RECORD: START FINISH MINUTES						
	V-343	2:30	6:30P	2:40			
	V-349	2:30	5:25PM	1:05			
	TIME	V-343	V-349	SV	NORMAL		
		INCHES	INCHES	PH	PH		
	AT 20 MIN	2:50 (47)	4:20 (20)	9.8	(9.3-10.0)		
	40 MIN	3:10 (43)	4:40 (17)	8.8	(9.3-10.0)		
	1 HR	3:30 (38)	5:00 (15)	9.8	(9.3-10.0)		
	2 HR	4:30 (24)	6:20 (7)	9.85	(9.3-10.0)		
	3 HR	5:30 (10)	7:30 (0)	9.8	(9.3-10.0)		
	FINISH	6:30 (0)	7:40	7.4	(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							
385	30	RUN 31" (238 G) WATER INTO V-385 & HEAT TO					
7	31	135-140°F					
	31	DUMP IN & STIR TO DISSOLVE			300	15-A	300
302	32	ADD 42" (514 G) WATER TO V-302					
8	33	ADD & STIR 2 MIN			150	7-D	75
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING					
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR					
	36	TURN OFF STEAM					
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN					
	38	RECORD: PH <u>3.5</u> (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH				15-A	
NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140°F IN DRUM, USE 30 GAL WATER TO 50# N-15-A. STIR SV 5 MIN AFTER EACH ADDITION							
	39	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN					
	40	RECORD: PH <u>4.65</u> (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH <u>4.2</u> ASSUME 77% <u>20</u> 27-D <u>10</u>					
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 7-D					
		SIPHON N-7-D INTO SV					
	41	STOP AGITATOR					
		START	FINISH	OPERATOR			
		<u>7:00A</u>	<u>3:00P</u>	<u>126-259</u>			
		<u>3:00P</u>	<u>7:30P</u>	<u>235-</u>			



DUP050104253



CORPORATION BUFFALO, NEW YORK