

EST'D WGT 1378 LBS CODE RD-909-D NOV-18 80 37935 PROCESSES () KO-909-D (C) APPROVED BY FWP 11/3/80

STANDARD HRS.

TIME 11 AM

TYPED BY: FWP 11/3/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	34374	250
01	YC016B	93	36036	850
01	YC016B	93	37372	2800

(2M)

Use FINE
LAUSTIC

TOTAL EST'D WGT 5296

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
208	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MINS. RECORD: START 830/200 34374-200 78 24X50 YC16B 3700 3900	480	983-D	480
1	FIN 030/245 36036-850 37372-2800			
1	ADJUST TO 75" (1275 G) PM 22510 50			
1	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
1	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
1	RECORD: V-208 VOL. 40 " & ADJUST TO 54" (1890G)			
1	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 10" (514 G) WATER INTO V-208, START AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 6:05 PM TOTAL MINUTES 105			
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	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F	2500	983-D	2500
384	WEIGH INTO V-384 & PUMP TO V-349	2000		2000
3	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
11	ADJ V-349 TO 19 (899 G) & STIR 15 MIN	100	983-D	100
11	RECORD DENSITY: 1.078 G/ML (1.071-1.094) (1.077-1.079)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
11	RECORD: PH 10.6 & 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%	12	N-7210 7-D	12
	SIPHON N-7-D INTO SV & RECORD: PH 11.3			
20	HEAT TO 190-194°F IN 55-65 MIN. & REC: HT 192°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34635

V-247

343	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343			
&	22	METER IN FROM V-386	M 68	83324/GAL, 35.1 GAL	27-D 373
386	23	STIR 15 MIN OR LONGER			310
5	24	RECORD: DENSITY 1.017 G/ML (1.018-1.020)			
		(1.015-1.017)			

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1			
	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 AT 190-194°F DURING STRIKE			
	29	RECORD:	START	FINISH	MINUTES
		V-343	2:00 P.M.	6:30 P.M.	310
		V-349		5:10 P.M.	146
		TIME	V-343	V-349	SV NORMAL
			INCHES	INCHES	PH PH
		AT 20 MIN	2:20 P.M. (46) 47	(17) 17	9.9 (9.3-10.0)
		40 MIN	3:40 P.M. (41) 41	(15) 15	9.9 (9.3-10.0)
		1 HR	3: P.M. (37) 37	(13) 13	9.9 (9.3-10.0)
		2 HRS	4: P.M. (23) 23	(6) 6	9.9 (9.3-10.0)
		3 HRS	5: P.M. (10) 10	(0) 0	9.9 (9.3-10.0)
		FINISH	5:45 P.M. (0)		7.9 (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	21	STIR IN			50	150-A	50
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385	31	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	32	DUMP IN & STIR TO DISSOLVE FOR S-61		477	15-A 477

302	33	ADD 38" (465 G) WATER TO V-302		148	
8	34	ADD & STIR FOR 2 MIN FOR S 64	ASSUME 50%	721D	148

PT	35	DURING STRIKE PUMP INTO PT		482	169-A 482
9	36	PUMP IN		54	155-A 54
	37	PUMP IN		54	160-A 54
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			

	39	DURING STRIKE RUN 15" (268 G) WATER INTO V-356			
	40	TURN ON STEAM			
356	41	ADJ TO 21" (366 G) AT 81-82°C			
10	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE			
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN			
	44	SHUT OFF PUMP			
	45	STIR 30 MIN AT 81-82°C FOR S 55			
	46	DO NOT SHUT OFF AGITATOR			

V-247

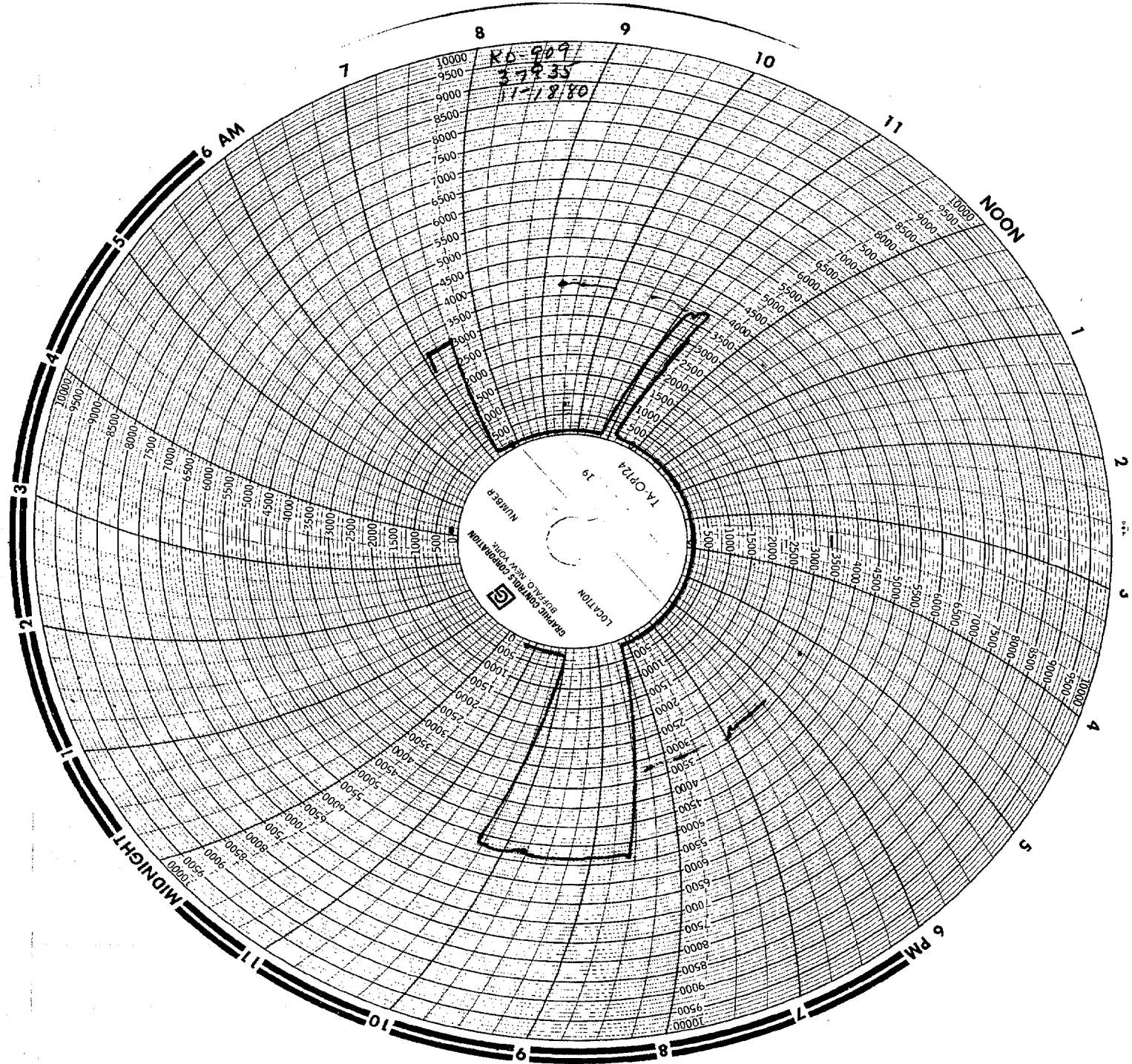
SV 147 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 SET PUMP AT ZERO SETTING
 11 148 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
 149 STIR 60 MIN AT 190-194°F
 150 HEAT TO 198-200°F IN 5-10 MIN
 151 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
 PUMP
 152 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
 INLET
 153 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
 THRU HOMOG AT 2900-3100 PSI TO SEWER
 154 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
 TO SV & CLOSE VALVE TO SEWER
 155 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
 TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
 PSI. MAINTAIN SV AT 198-200°F.
 156 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
 AT STEARATE PUMP ASAP
 157 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
 WATER FROM HOT WATER MIXER
 158 TURN OFF HOMOG & STEARATE PUMP
 159 STIR 5 MIN AT 198-200°F
 160 SHUT OFF STEAM
 161 RUN IN V-385 FROM S-32 & STIR 5 MIN
 162 RECORD: PH 3.5 (3.4-3.8)
 163 IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY)
 & RECORD: PH ____
 164 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
 165 RECORD: PH 7.0 (6.2-6.4) & IF NECESSARY, ADJ
 TO PH 6.2-6.4 & RECORD: PH 6.4 ASSUME 78%
 (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
 SIPHON N-7-D INTO SV
 166 DO NOT STOP AGITATOR

14

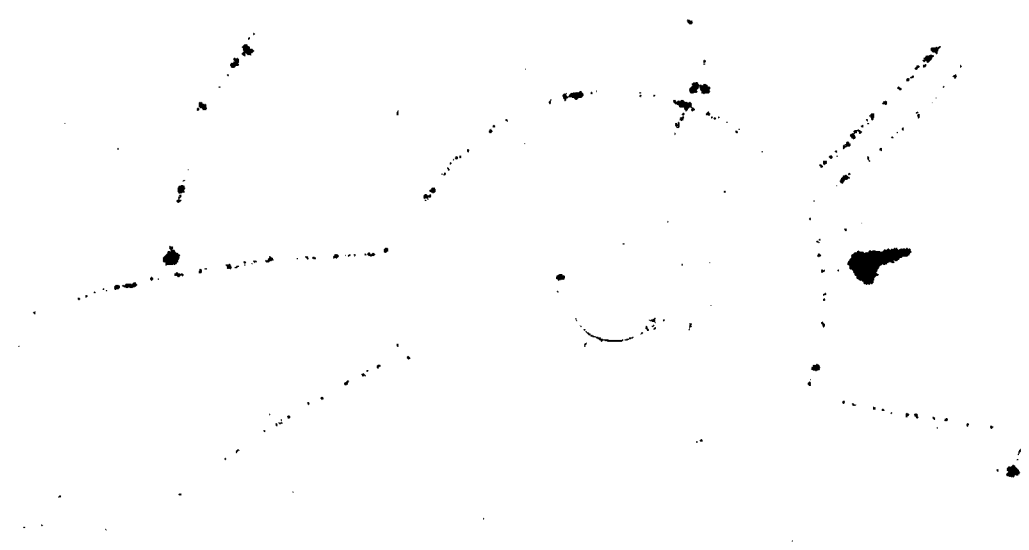
27-D
7-D

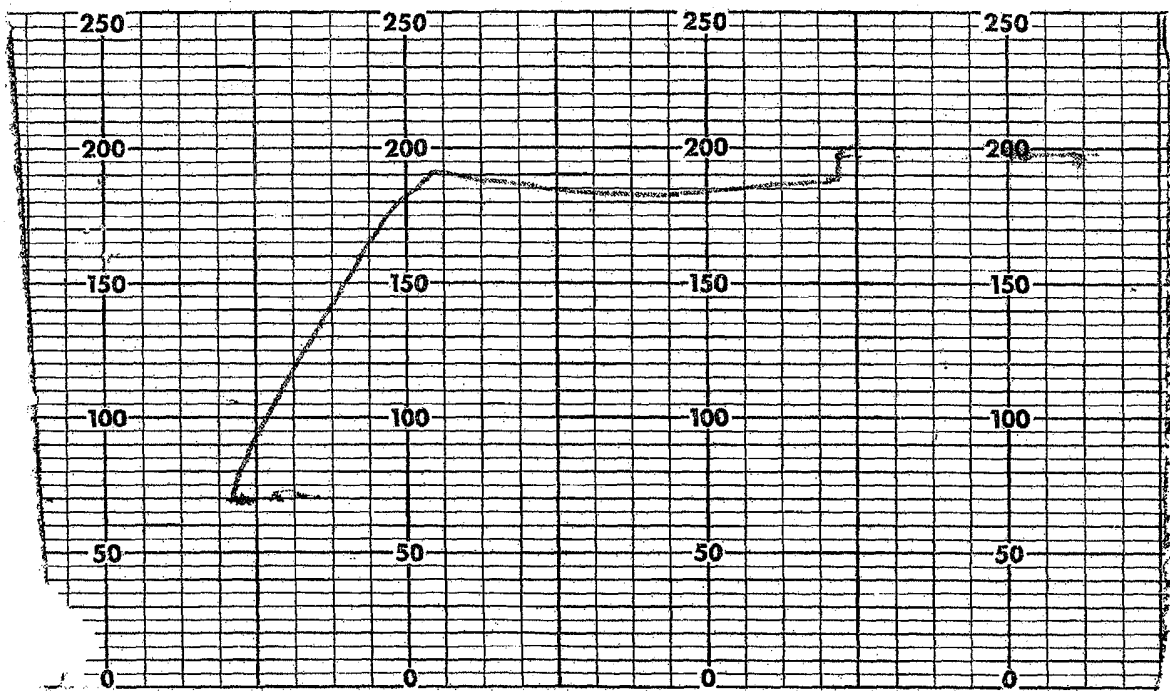
11

7:00 AM
3:00 PM3:00 PM
11:00 PM381-223
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V-247





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