

CG 04 CODE KO-909-D

PKG

PROCESSES

APPROVED BY

EST'D WGT 1546 LBS

JUN 12 1980 36096

() KO-909-D (C)

FWP 5/19/80

STANDARD HRS.

TIME 11A

()

()

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TYPED BY: FWP 5/19/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	34186	600
01	YC016B	93	35903	3100
01	YC016B	93	35903	356
0A	KO-909-D	98	32169	

NOTE REWORK AT STEP 30 (NOT FOR V-211)

TOTAL EST'D WGT 5296 5435

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
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 34186	74X50	YC16B	3700
1	RECORD: START 8:16 AM	600		
	FIN 10:20 AM	3100		
	4 ADJUST TO 75" (1275 G)			
	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. 40 & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-245 START			
&	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 7:10 PM TOTAL MINUTES 100			
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	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
&	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	14 WEIGH INTO V-384 & PUMP TO V-349	2500	32-D	2500
	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: 1.094 G/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	19 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%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 12.7			
	& RECORD: 12.7			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N32353

V-245

EQUIP

PAGE 2 CG 04 KO-909-D EST WGT 52964

USE
LBS

N-
CODE

USE
LBS

343	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343			
&	22	METER IN FROM V-386	38	10.86 GAL	343
386	23	STIR 15 MIN OR LONGER			27-D 373
5	24	RECORD: DENSITY 1.018 G/ML (1.018-1.020)			

SV	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 AT 190-194°F DURING STRIKE			
	29	RECORD:	START	FINISH	MINUTES
		V-343	10:10	2:30A	2:45
		V-349	10:25	1:30A	2:30
		TIME	V-343	V-349	SV
			INCHES	INCHES	PH
		AT 20 MIN	10:45 (46)	(17)	10.0 (9.3-10.0)
		40 MIN	11:05 (41)	(15)	9.9 (9.3-10.0)
		1 HR	11:25 (37)	(13)	9.9 (9.3-10.0)
		2 HRS	12:25 (23)	(6)	9.9 (9.3-10.0)
		3 HRS	1:25 (10)	(0)	9.9 (9.3-10.0)
		FINISH	2:30 (0)	2:30	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

356	30	DUMP IN ONE DRUM, KO-909-D, LOT 32769 (DC=53%)	50	120-A	50
			356	KO-909-D	356

356	31	RUN 200" (216 G) WATER INTO V-356 & HEAT TO 135-140°F			
3857	32	DUMP IN & STIR TO DISSOLVE FOR S-61	477	15-A	477

302	33	ADD 38" (465 G) WATER TO V-302			
8	34	ADD & STIR FOR 2 MIN FOR S 64	ASSUME 50%	296	7-D 148

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

356	39	DURING STRIKE RUN 15" (268 G) WATER INTO V-356			
	40	TURN ON STEAM			
10	41	ADJ TO 21" (366 G) AT 81-82°C			
	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-245

- SV 47 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
- 11 48 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
- 49 STIR 60 MIN AT 190-194°F
- 50 HEAT TO 198-200°F IN 5-10 MIN
- 51 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP
- 52 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET
- 53 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER
- 54 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER
- 55 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
- 56 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
- 57 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER
- 58 TURN OFF HOMOG & STEARATE PUMP
- 59 STIR 5 MIN AT 198-200°F
- 60 SHUT OFF STEAM
- 61 RUN IN V-385 FROM S-32 & STIR 5 MIN
- 62 RECORD: PH 3.2 (3.4-3.8)
- 63 IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY)
& RECORD: PH _____
- 64 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- 65 RECORD: PH 5.5 (6.2-6.4) & IF NECESSARY, ADJ
TO PH 6.2-6.4 & RECORD: PH 6.2 ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
SIPHON N-7-D INTO SV
- 66 DO NOT STOP AGITATOR

27-D

7-D

16

B

START

3:PM

11:00 P

FINISH

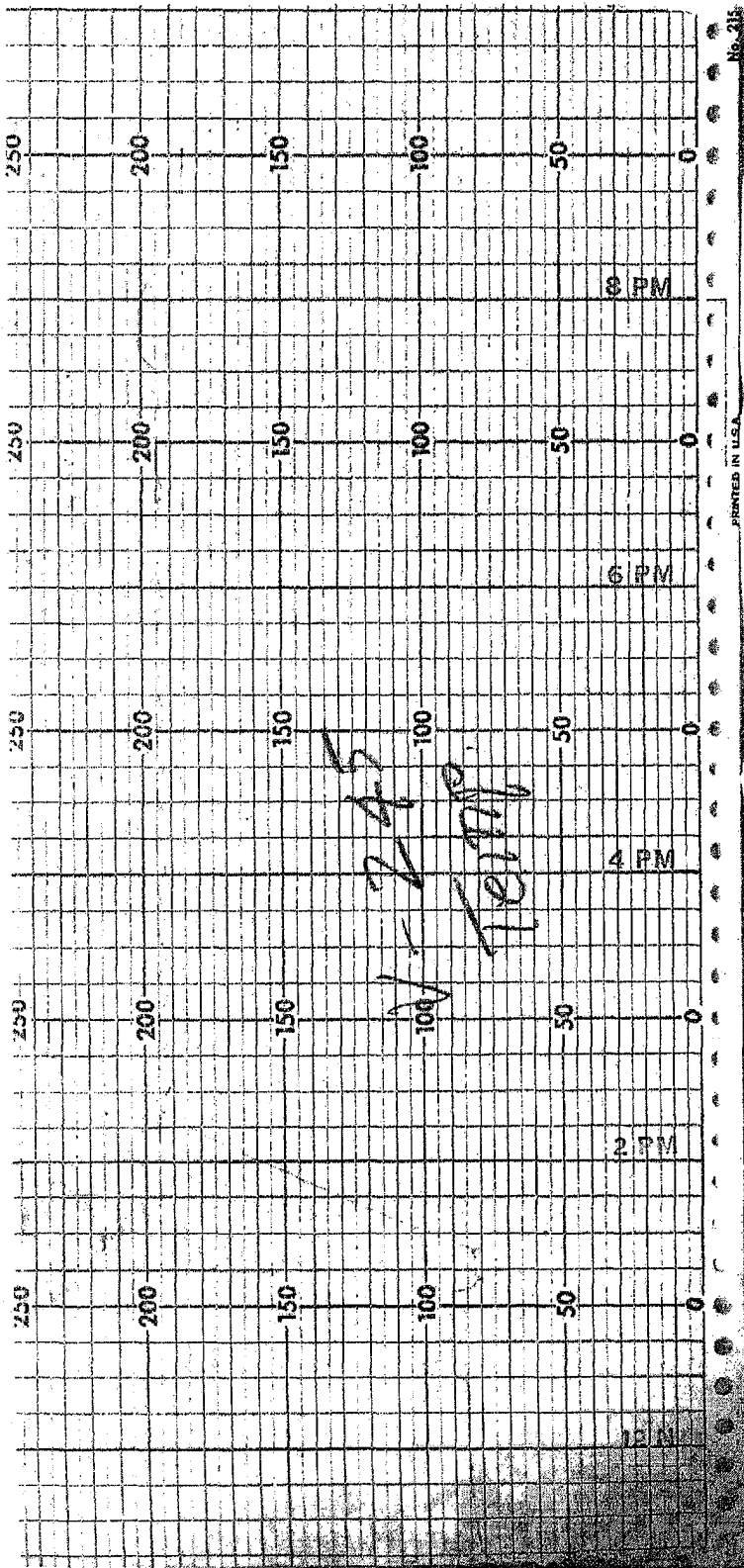
11:PM

5:10AM

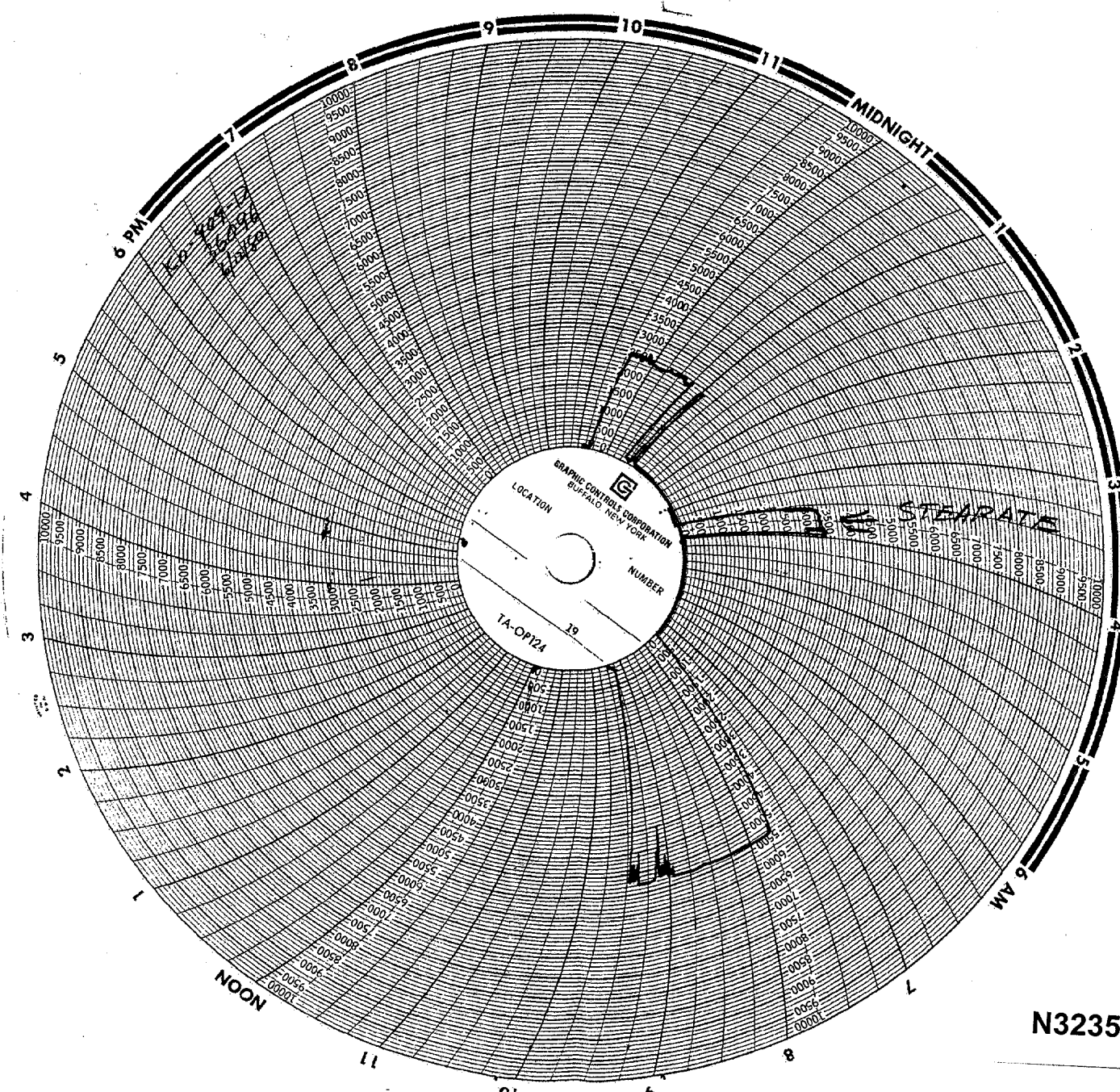
OPER

54150

235-323



N32353.01



N32353.02

V-245

ste-n