

EST'D WGT 1032 LBS

STANDARD HRS. 10.8 TIME 11 AM

OK
KF
TYPED BY: FWP 4/28/80

EQ	CODE	PQ	LOT	LBS
01	YC016B	93	35864	550
01	YC016B	93	34186	300
01	YC016B	93	35904	3350

Homog #2

PUNCHED & CHECKED

TOTAL EST'D WGT 5232

JUN 1 1980

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACC LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MINS. RECORD: START 8:31 AM LOT 35864	84X50 YC16B		420
1	FIN 11 AM	550		
		300		
		35904		
	4 ADJUST TO 75" (1275 G)	3350		
	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. " & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	10 RUN 10" (514 G) WATER INTO V-208 & START			
SV	AGITATOR & INSTALL TEMP CHART			
	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 10:00P TOTAL MINUTES 120			
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	2545	32-D	2545
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.082 (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 12.5 & 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%			
	SIPHON N-7-D INTO SV & RECORD: PH 11.2	16	7-D	8
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 182°F & RECORD: 194°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N32354

V-245

121 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO
343 V-343
& 122 METER IN FROM V-386 M. 37-10.85 GAL, 35.9 GAL
386 123 STIR 15 MIN OR LONGER
5 124 RECORD: DENSITY 1.018 ML (1.018-1.020)

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.05
126 SET V-343 ACID PUMP AT 85 SETTING (255 MIN)
127 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)
128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE.

29 RECORD: START FINISH MINUTES
V-343 5:29 AM 9:35 AM 255
V-349 8:50 AM 210
TIME V-343 V-349 SV NORMAL
5:20 INCHES INCHES PH PH
AT 20 MIN 5:40 (49) 50 (20) 9.85 (9.3-10.0)
40 MIN 6:00 (45) 46+ (18) 9.85 (9.3-10.0)
1 HR 6:20 (41) 43 (16) 9.9 (9.3-10.0)
2 1/4 HR 7:35 (25) 27 (8) 9.8 (9.3-10.0)
3 1/2 HR 8:50 (9) 11 (0) 9.8 (9.3-10.0)
FINISH 9:35 (0) 0 7.2 (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%

305 30 RUN 38" (238 G) WATER INTO V-386 & HEAT TO
135-140°F
31 DUMP IN & STIR TO DISSOLVE 530 15-A 530

302 132 ADD 42" (514 G) WATER TO V-302
8 133 ADD & STIR 2 MIN 330 7-D 165

SV 134 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING.
9 135 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR.
* 136 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
RECORD: START 9:35 AM
137 RUN IN V-386 FROM S 31 & STIR 5 MIN
138 RECORD: PH 3.6 (3.4-3.8) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.4-3.8 & RECORD: PH
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
139 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5
MIN
140 RECORD: PH 6.4 (6.2-6.4) & IF NECESSARY ADJ TO
PH 6.2-6.4 & RECORD: PH ASSUME 77% 27-D
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 7-D
SIPHON N-7-D INTO SV
141 POUR IN STIR 15 MIN 50 978-A 50
142 STOP AGITATOR

START

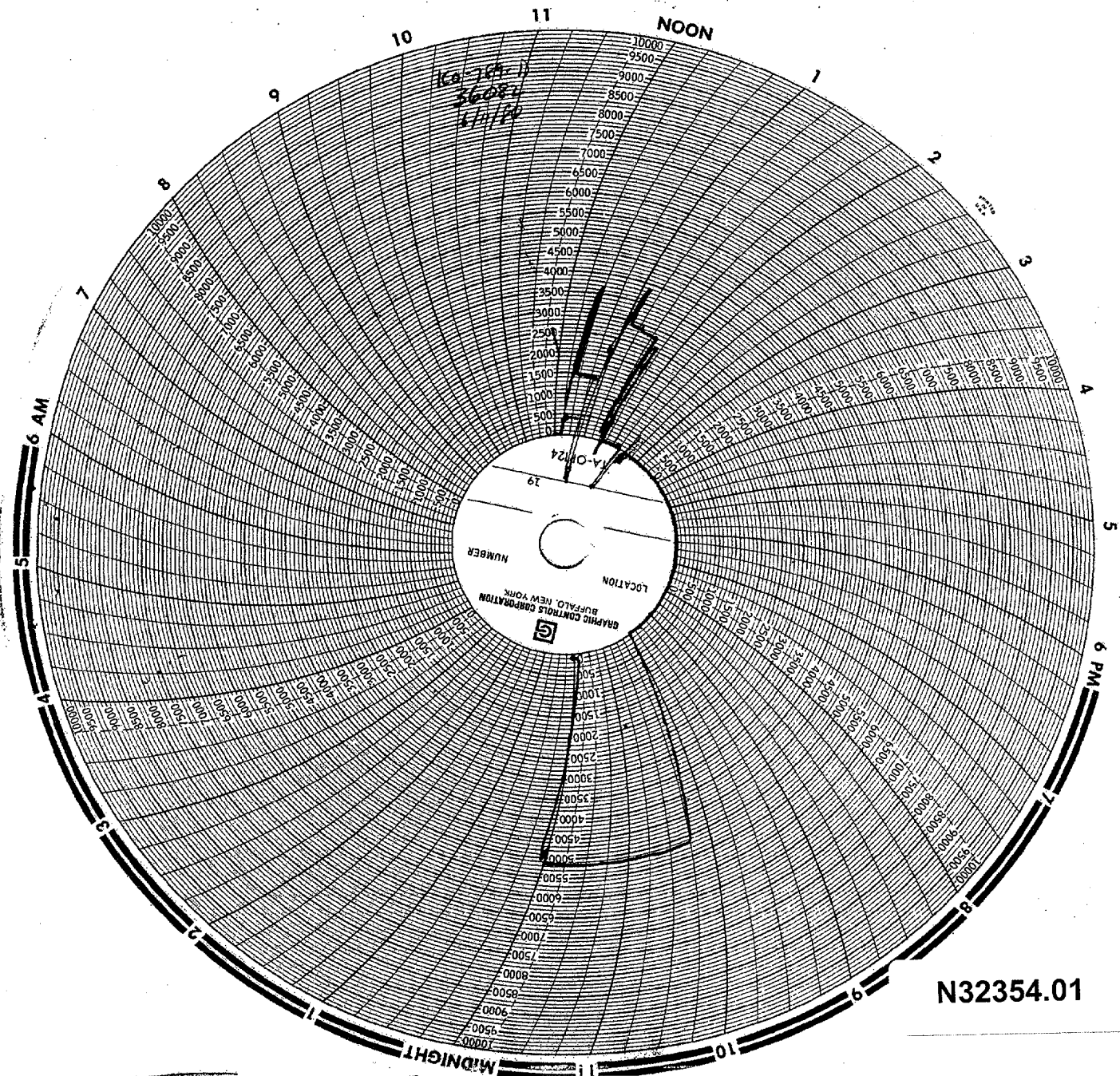
300 P
11:00 P

FINISH

11:00 P
7:00 A

OPERATOR

209-54
285-323



10.32354.01

JK-245