

CG 04 CODE KO-786-D PKG 5084* () KO-786-D (F) FWP 10/04/82
 OCT 25 1982 L2H33 (EST WGT) COMTYP JOBNAME: 04KO786DMP
 (DATE) (LOT) TIME: 7:00 A.M. STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC-16	94	J1314	100	100.00	2	50	100	100
	01	YC-10	93	J2H57	2000	100.00	40	50	2000	2000
	01	YC-10	93	K2J13	2000	100.00	40	50	2000	2000
	01	YC-10	93			100.00				

SUBSTANDARD BLEND-BACK FOR 8-40: CODE _____ LOT _____ PQ _____
 REG. NO. (10010) NON-BLEEDING

EQUIP MENT	NAME : "KROLO" ORANGE R	USE LBS	N CODE	ACCT LBS
211	"BEFORE USING SV, MAKE SURE THAT N-28-D (HYDRO-CHLORIC ACID) LINE, IF ANY IS BLANKED OFF".			
208	1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2 WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	270	32-D	270
	3 DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	84X50	YC10B	4300
	RECORD: START 1:30 PM LOT J2H57	8X50	YC16B	100
	FIN 2:40 PM J2H57	2200		
	J2H57	2000		
	J1314	100		
	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 1800-2200 PSI INTO V-208			
	6 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208			
	7 RECORD: V-208 VOL 56" & ADJUST TO 50" (1840G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 15" (771 G) WATER INTO V-216, START AGITATOR & INSTALL TEMP CHART			
208	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1:35 PM TOTAL MINUTES 16.5			
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			

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349	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	14 WEIGH INTO V-384 & PUMP TO V-349	2400	32-D	2400
3	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.080 G/ML (1.078-1.081)			

SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)			
4	19 RECORD: PH 11.1 & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH _____			
	HEAT TO 190-194°F IN 55-65 MIN & REC: 192°F			
	& RECORD 194°F			

IM

EQUIP

MENT PAGE 2 CG 04 KO-786-D

USE N- ACCT
LBS CODE LBS

U-246

343 21 WHILE HEATING SV, RUN 51" (1400 G) WATER INTO
& 22 V-343
386 22 METER IN (SULFURIC ACID 60%) FROM V-386
5 23 *M 27, 11070#/GAL, 32.1 GAL*
24 STIR 15 MIN OR LONGER
24 RECORD: DENSITY *1.019* G/ML (1.018-1.020)

125 WHEN S 20 HEATING COMPLETE; RECORD: PH *10.2*
126 SET V-343 ACID PUMP AT 72 SETTING (225 MIN)
127 SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)
128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE

6 129 RECORD: START FINISH MINUTES
V-343 *5:00* *10:00* *280*
V-349 *5:00* *8:30* *190*
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN *5:40* (47) *50* (20) *30* *10.0* (9.3-10.0)
40 MIN *6:00* (43) *40* (17) *16* *10.0* (9.3-10.0)
1 HR *6:20* (38) *46* (15) *14* *10.1* (9.3-10.0)
2 HR *7:20* (24) *47* (7) *8* *10.1* (9.3-10.0)
3 HR *8:20* (10) *35* (0) *142* *10.6* (9.3-10.0)
FINISH *9:05* (0) *44* *-* *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

385 30 ADD 67" (514 G) WATER TO V-385

7 31 ADD & STIR 2 MIN

150

7-D

75

SV 32 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING

8 33 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR

34 TURN OFF STEAM

35 RUN IN LIQUID ALUM USING BADGER METER

36 FLUSH ALUM LINE WITH WATER.

37 RECORD: PH *3.4* (3.3-3.7) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.3-3.7 & RECORD: PH _____

NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
BADGER METER. STIR 5 MIN AFTER EACH
ADDITION. ASSUME 50%

38 RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN

39 RECORD: PH *6.3* (4.0-4.2) & IF NECESSARY ADJ TO
PH 4.0-4.2. RECORD: PH *4.2* ASSUME 77%

DILUTE N-7-D 10 TO 1 WITH WATER

ASSUME 50%

40 SIPHON N-7-D INTO SV

40 WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN
SUBSTANDARD TO BE BLENDED BACK.

RECORD: CODE _____, LOT _____, _____

41 STOP AGITATOR

START
3:00 PM

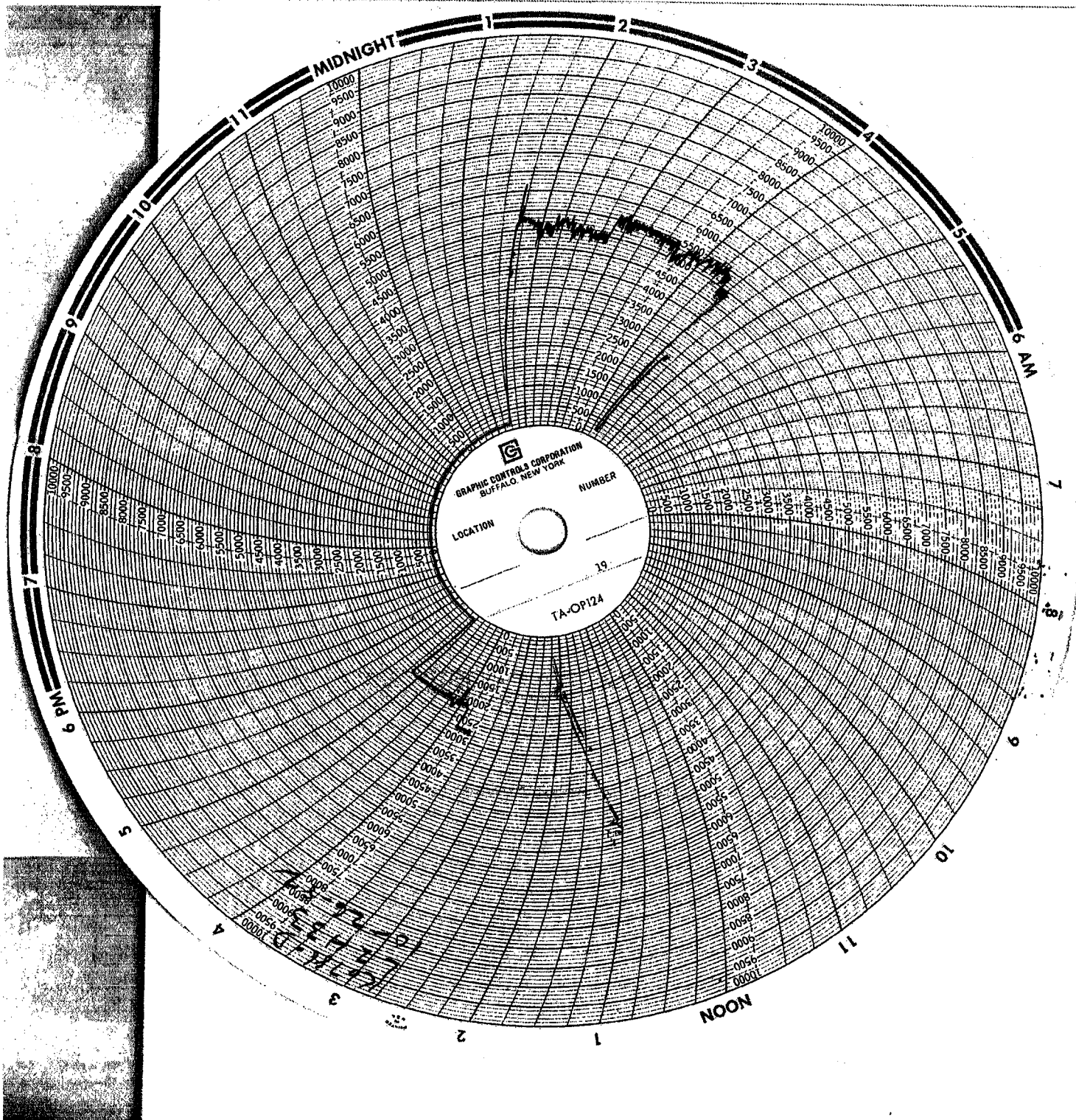
FINISH
11:00 PM

OPERATOR
282-409

700A

1100A

209



V-246