

CG 04 CODE KO-909-D PKG

PROCESSES

APPROVED BY

NOV 13 80 37868

() KO-909-D (C)

FWP 11/3/80

EST'D WGT 1596 LBS

() ()

() ()

() ()

STANDARD HRS.

TIME 11A

TYPED BY: FWP 11/3/80

PUNCHED & INDEXED

CG	CODE	PR	LOT	LBS
01	YC016B	93	37370	1400
01	YC016B	93	37337	2300
01	YC016B	93		

NOV 20 1980

USE FLAKE CANTH

CLEAN UP

AS YOU GO ALONG

TOTAL EST'D WGT 5276 5046

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NEODE	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.	480	983-D	480
1	RECORD: START 11:30 A.M. LOT 37370 FIN 1:15 P.M. 37337	1400	YC16B	3700
	ADJUST TO 75" (1275 G)	2300		
	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG. AT 2800-3200 PSI INTO V-208			
	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
	RECORD: V-208 VOL. " & ADJUST TO 54" (1890G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 10" (514 G) WATER INTO V-211, START AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1:45 P TOTAL MINUTES 180			
2	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	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
	WEIGH INTO V-384 & PUMP TO V-349	2000		2000
3	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	RECORD DENSITY: 1.029 G/ML (1.091-1.094) (1.077-1.079)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
4	RECORD: PH 10.4 & ADJ TO 11.1-11.3 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH 11.1	2	70.4	2
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT *F			
	& RECORD: *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34656

DUP050104800

343	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343			
386	22	METER IN FROM V-386 M. 68, 8.832 GAL 35.1 GAL		27-D	343
5	23	STIR 15 MIN OR LONGER			310
	24	RECORD: DENSITY 1.016 G/ML (1.010-1.020)			

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.8			
	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 8:45 P.M. 1:45 2:45			
		V-349 11:55 7:55			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 9:05 (46) 47 (17) 12 9.6 (9.3-10.0)			
		40 MIN 1:25 (41) 42 (15) 15 9.6 (9.3-10.0)			
		1 HR 9:45 (37) 38 (13) 13 9.6 (9.3-10.0)			
		2 HRS 10:45 (23) 24 (6) 6 9.5 (9.3-10.0)			
		3 HRS 11:45 (10) 12 (0) 1 9.4 (9.3-10.0)			
		FINISH 12:45 (0) 4 3.5 (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	SIFT IN		50	128-A 50

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%	286	721-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			
10	40	TORN ON STEAM			
	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			

USE
LBSN-
CODEUSE
LBS

- 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 2.4. (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 4.0 (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 70%
SIPHON N-7-D INTO SV
166 DO NOT STOP AGITATOR

12
9027-D
7209
90

Flocke

130 A700 A

126-120

3:30A

3:00P.M.

11:00P.M.

37-244

MOUR

C-02A

342

