CG 04 CODE KO-786-D PKG

PROCESS
( ) KO-786-D (P)

APPROVED BY
FWP 06/14/82

OK/FP

JUN 21 1982
(DATE)

F2K91
(LOT)

5084*
(EST WGT)

COMTYP JOB NAME: 04KO786DMQ
(CONTAINS RE-WORK)

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
	04	KO786D	98	84960-1	200	100	4	50	200	200
	01	YC-10	93	32K41	1600	100	32	50	1600	1600
	13	YE698D	98	E2G17	2000	100	40	50	2000	2000
	01	YE72LD	98	D2H85	500	100	10	50	500	500

WAREHOUSE REQUISITION NO. 10856 NON-BLEEDING

EQUIPMENT		NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2	WEIGH IN DRUM AND POUR IN	270	32-D	270
	3	DUMP IN AND STIR 5 MIN LOT	32X50	YC10B	1600
		RECORD: START 7 AM 32K41	4X50	KO786D	200
1		FIN 9:30 A E2G17	40 X 50	YE-698-D	2000
		D2H85	10 X 50	YE-72L-D	500
	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. 45" & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 15" (771 G) WATER INTO V-347 START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 10:46AM TOTAL MINUTES 185			
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		JUN 24 1982	
349 & 384	12	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120*F			
	14	WEIGH INTO V-384 & PUMP TO V-349	2400	32-D	2400
	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: 1.081 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			

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EQUIPMENT		PAGE 2 CG 04 KO-786-D	USE LBS	N-CODE	ACCT LBS
4	19	RECORD: PH 10.6 & 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 ____			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT ____*F & RECORD: ____*F			
	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
343 & 386	22	METER IN FROM V-386 M 19 10.719 #/GAL 33.1 GAL	____	27-D	355
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.018 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194*F DURING STRIKE			
SV 6	29	RECORD: START FINISH MINUTES V-343 4PM ____ ____ V-349 ____ ____ ____			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH AT 20 MIN 420 (47) (20) 9.5 (9.3-10.0) 40 MIN 440 (43) (17) 9.5 (9.3-10.0) 1 HR 500 (38) (15) 9.5 (9.3-10.0) 2 HR 600 (24) (7) 9.5 (9.3-10.0) 3 HR 700 (10) (0) 9.4 (9.3-10.0) FINISH 745 (0) 8.7 (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 7	30	ADD 67" (514 G) WATER TO V-385			
	31	ADD & STIR 2 MIN	150	7-D	75
SV 8	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	34	TURN OFF STEAM			
	35	RUN IN ALUM USING BADGER METER	600	115-A	300
	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%	____	115-A	____
	38	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	39	RECORD: PH 4.1 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. 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			
	40	STOP AGITATOR			

START	FINISH	OPERATOR
7 AM	3 P	120-301
3 P	8:30	202

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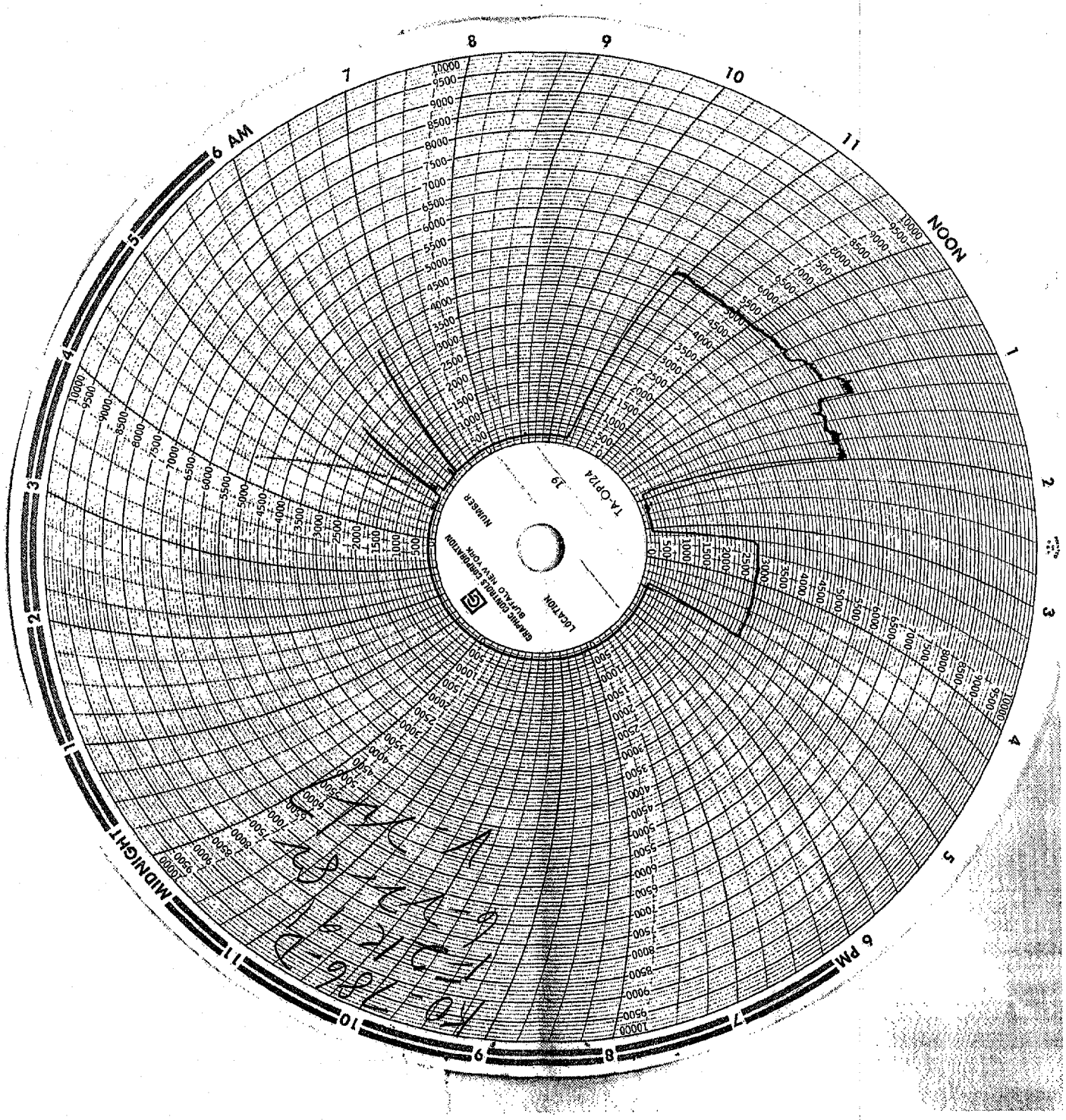

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