(MANUAL)
S.V. 246, ~~247~~ C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 04 CODE KO-906-D PKG

MAY -0-81- Σ1378

EST'D WGT 1377 LBS

STANDARD HRS. TIME _____ M

PROCESSES	APPROVED BY
) KO-906-D (C)	FWP 01/16/81
( ) ( )	
( ) ( )	
( ) ( )	

JOB NAME: 04KO-906-DMC

CG	CODE	PQ	LOT	LBS
01	YC010B	93	37757	200
01	YC010B	93	Σ10479	200
01	YC010B	93	D10997	1450
01	YC010B	98	D11192	350
01	YC10B	93	Σ1182	1550

TOTAL EST'D WGT 5077 REQ. NO.(10225) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60*(990 G) WATER IN V-211 & ADD ASSUME 50%	26	7-D	13
		SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM AND POUR IN	245	32-D	245
	3	DUMP IN AND STIR 5 MINS. LOT	~~74~~X50	YC10B	~~3700~~ 3750
		RECORD: START 115 PM 37757	200		
1		FIN 1 AM 31049	200		
		D10997	1450		
	4	ADJUST TO 75* (1275 G) D11192	350		
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU Σ1182	1550		
		HOMOG AT 1800-2200 PSI INTO V-208	3750		
	6	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN			
		OF HOT WATER AT 1800-2200 PSI INTO V -208			
	7	RECORD: V-208 VOL. 42 * & ADJUST TO 45*(1662G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV 2	9	RUN 15* (793 G) WATER INTO V-246 & START			
		AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 3:45 PM TOTAL MINUTES 120			
		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 & 384 3	12	WHILE HOMOG, RUN 5* (237 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	2165	32-D	2165
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16	ADJ V-349 TO 20" (946 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.079 #/ML (1.078-1.081)			
SV 4	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60*(3084 G)			
	19	RECORD: PH 10.7 & ADJ TO 10.4-10.8 USING N-7-D			
		AT 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 187*F			
		& RECORD: 194*F			

V-246

EQUIP		PAGE 2 CG 04 KO-906-D EST WGT 5077#	USE LBS	N-CODE	USE LBS
	24	WHILE HEATING SV, RUN 46* (1265 G) WATER INTO			
343		V-343			
&	32	METER IN FROM V-386 M 15-10.7Q/GAL, 29.9 GAL	_____	27-D	320
386	33	STIR 15 MIN OR LONGER			
5	34	RECORD: DENSITY 1.019/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	26	SET V-343 ACID PUMP AT 65 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 57 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
SV		AT 190-194*F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 6:45 10:50 A.M 250			
		V-349 9:50 A.M 185			

	TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
	6:45	49	20		
AT 20 MIN	7:05	(43) /	(18) /	9.5	(9.3-10.0)
40 MIN	7:25	(39) /	(16) /	9.5	(9.3-10.0)
1 HR	7:45	(35) 35	(13) 14	9.5	(9.3-10.0)
2 HRS	8:45	(22) 24	(7) 7	9.5	(9.3-10.0)
3 HRS	9:45	(10) 11	(0) 0	9.5	(9.3-10.0)
FINISH	10:30	(0) 0	0	7.1	(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~~	~~120-A~~	~~50~~
385	31	RUN 40* (308 G) WATER INTO V-385 & HEAT TO			
7		135-140*F			
	32	DUMP IN & STIR TO DISSOLVE FOR S-60	270	15-A	270
302	33	ADD 24* (295 G) WATER TO V-302			
8	34	ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50%	136	7-D	68
	35	DURING STRIKE PUMP INTO PT	464	160-A	464
PT	36	PUMP IN	52	155-A	52
9	37	PUMP IN	52	160-A	52
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			
	39	DURING STRIKE RUN 15* (268 G) WATER INTO V-356			
	40	TURN ON STEAM			
356	41	ADJ TO 21* (366 G) AT 81-82*C			
10	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 54			
	46	DO NOT SHUT OFF AGITATOR			

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U-276

EQUIP		PAGE 3 CG 04 KO-906-D EST WGT 5077#	USE LBS	N-CODE	USE LBS
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	HEAT TO 198-200*F IN 5-10 MIN			
	50	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
	51	OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP INLET			
	52	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
	53	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
	54	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200*F.			
	55	WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
	56	WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT WATER FROM HOT WATER MIXER			
	57	TURN OFF HOMOG & STEARATE PUMP			
	58	STIR 5 MIN AT 198-200*F			
	59	SHUT OFF STEAM			
	60	RUN IN V-385 FROM S-32 & STIR 5 MIN			
	61	RECORD: PH 3.6 (3.3-3.7)			
	62	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH_____.			
	63	RUN IN N-7-D FROM S-34IN 4-6 MIN & STIR 5 MIN			
	64	RECORD: PH 4.2 (4.0-4.2) & IF NECESSARY, ADJ TO PH 4.0-4.2 & RECORD: PH_____. ASSUME 78%	_____	27-D	_____
		(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	_____	7-D	_____
	65	SIPHON N-7-D INTO SV			
		DO NOT STOP AGITATOR			

START — FINISH — OPER,
1:00 AM 7:00 AM 235-244
7:00 AM — 1:20 PM — 381-223

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