CG 04 CODE KO-789-D PKG

OCT 27 80 37614

EST'D WGT 1032 LBS

STANDARD HRS. 10.8 TIME 7P M

PROCESSES
( ) KO-789-D (I)
( ) ( )
( ) ( )
( ) ( )
TYPED BY: FWP 9/18/80

APPROVED BY
FWP 9/18/80

PUNCHED & CHECKED

CG	CODE	PQ	LOT	LBS
01	YC016B	93	36122	2000
01	YC016B	93	36039	1200
01	YC016B	93	36344	1000

OCT 28 80

CLEAN UP AS YOU GO ALONG

TOTAL EST'D WGT 5232 REQ. NO.( ) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60"(990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM AND POUR IN	530	32-D	530
	3	DUMP IN AND STIR 5 MIN	84X50	YC16B	4200
		RECORD: START 5:PM. LOT 36122	2000		
1		FIN 6:30PM. 36039	1200		
		36344	1000		
	4	ADJUST TO 75" (1275 G)			
	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 HOT WATER AT 2800-3200 PSI INTO V-208			
	7	RECORD: V-208 VOL. 40 " & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV 2	9	RUN 10" (514 G) WATER INTO V-247 START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 530 TOTAL MINUTES 130			
	11	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	12	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 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	2545	32-D	2545
	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: 1085 G/ML (1.082-1.086)			
SV 4	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.4 & ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
		ASSUME 50%	15	724	15
		SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC: HT 192 *F & RECORD: 192 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

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EQUIP		PAGE 2 CG 04 KO-789-D EST WGT 5232# V-247	USE LBS	N- CODE	USE LBS
	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M____, 8% #/GAL, 43.5 GAL	_____	27-D	390
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.020 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	26	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)			
	27	SET V-349 SILICATE PUMP AT 54 SETTING (210 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 9:15A 1:45P 270			
		V-349 9:15A 12:50P 215			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 9:35A (49) 50 (20) 21 9.8 (9.3-10.0)			
		40 MIN 9:55A (45) 47 (18) 18+ 9.8 (9.3-10.0)			
		1 HR 10:15A (41) 42 (16) 16+ 9.8 (9.3-10.0)			
		2 1/4 HR 11:30A (25) 26 (8) 8+ 9.7 (9.3-10.0)			
		3 1/2 HR 12:45P (9) 11 (0) + 9.7 (9.3-10.0)			
		FINISH 1:30P (0) ___ 9.1 (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	_____
385	30	RUN 40" (308 G) WATER INTO V-385 & HEAT TO			
7		135-140*F			
	31	DUMP IN & STIR TO DISSOLVE	530	15-A	530
302	32	ADD 42" (514 G) WATER TO V-302	165		
8	33	ADD & STIR 2 MIN ✓	330	72V-D	165
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	36	STIR 30 MIN AT 190-194*F, THEN TURN OFF STEAM			
		RECORD: START 1:45P			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.0 (3.4-3.8) & IF NECESSARY ADJ			
		(DOWN ONLY) TO 3.4-3.8 & RECORD: PH____	_____	15-A	_____
		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			
	39	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN			
	40	RECORD: PH 6.2 (6.2-6.4) & IF NECESSARY ADJ TO			
		PH 6.2-6.4. RECORD: PH 6.2 ASSUME 77%	_____	27-D	_____
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	15	72V-D	15
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN ✓	50	978-A	50
	42	STOP AGITATOR			

START	FINISH	OPERATOR
3:00PM	11:00PM	32-214
7:00A	3:00 P	259-126
3:00PM	4:10 PM	237-244

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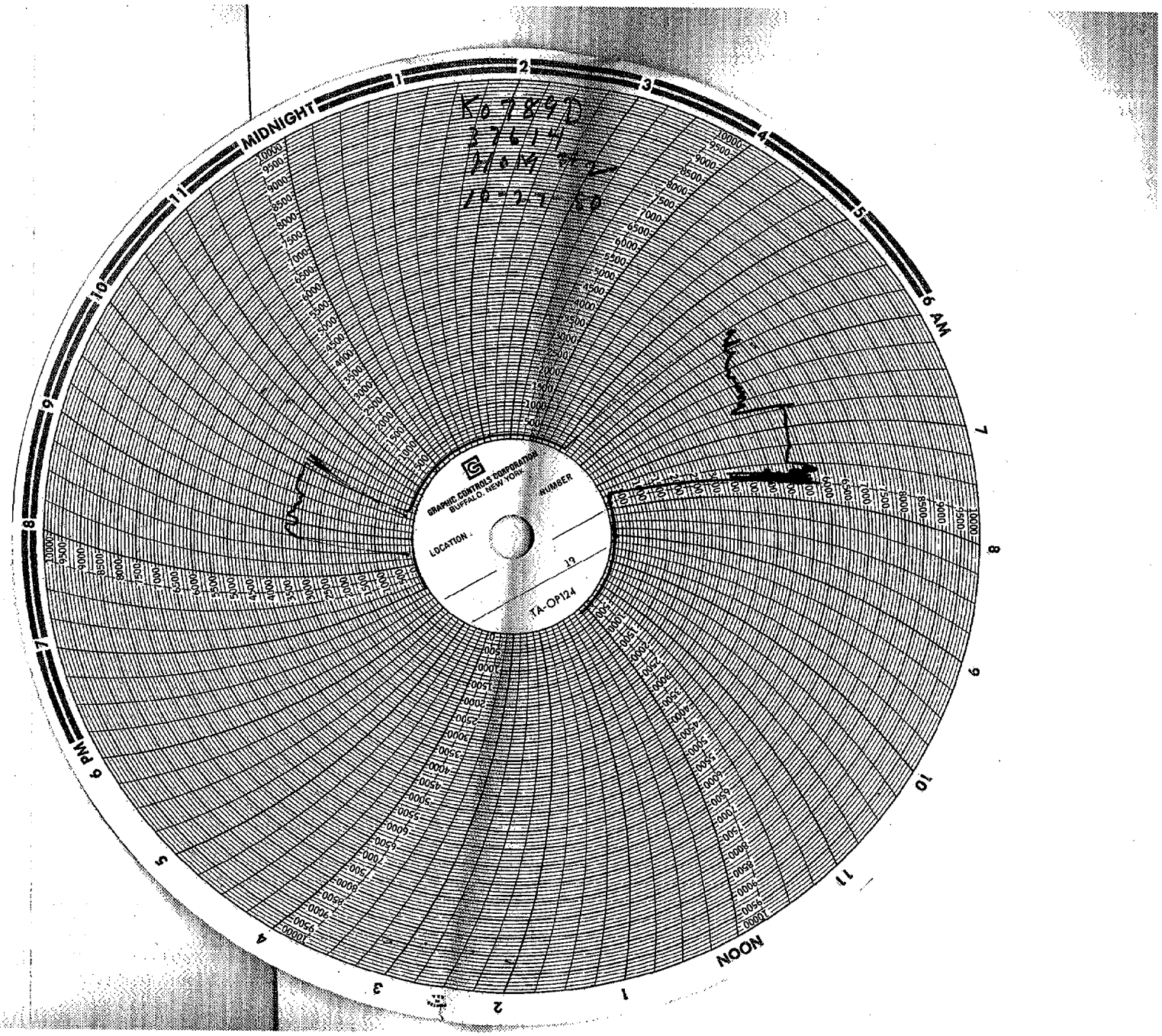

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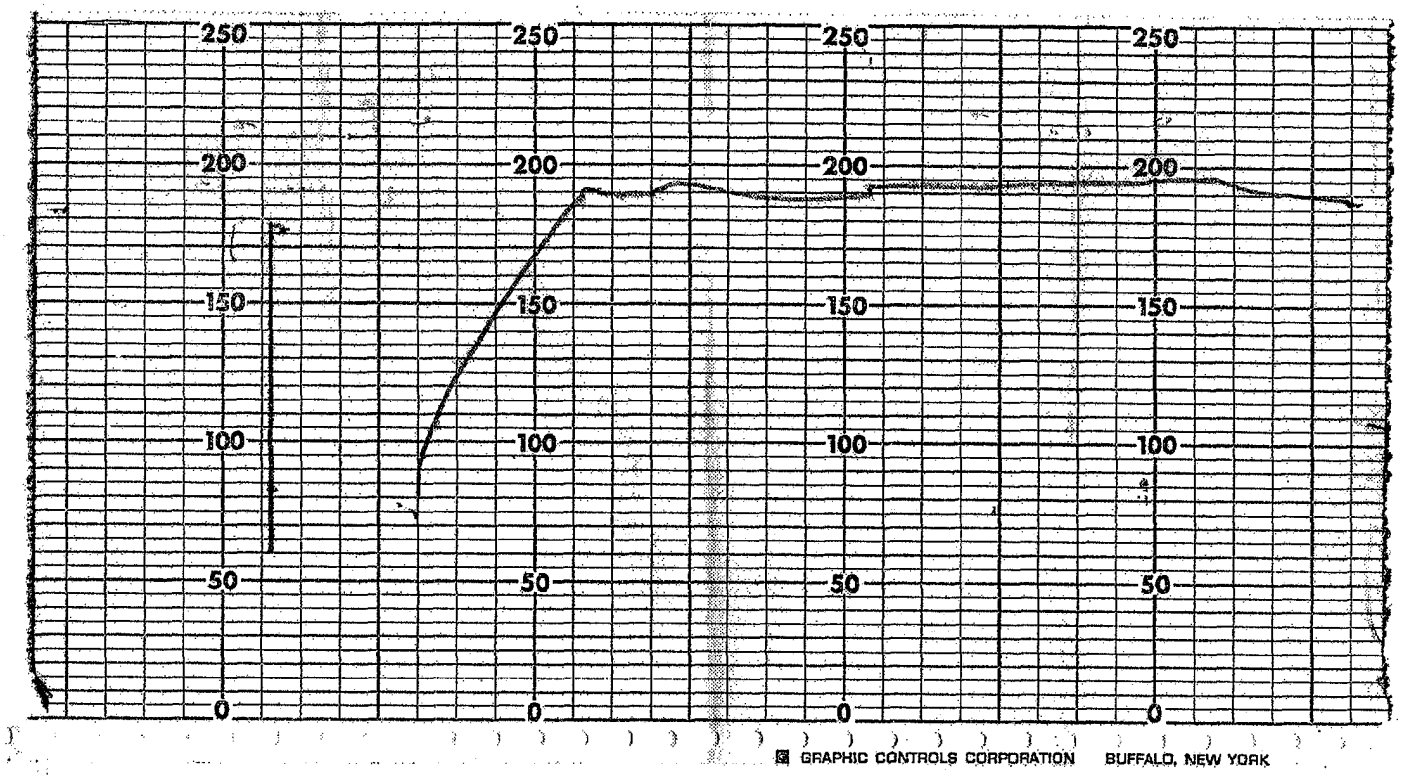

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