

CG. 04 CODE KO-909-D PKG

JUN 2 1982

F2H75

PROCESSES

APPROVED BY

() KO-909-D (C)

FWP 03/25/82

DATE

LOT NUMBER

STD. HRS.

TIME 3 P.M.

JOB NAME: 04KO909DMC

CG	CODE	PQ	LOT	LBS				
13	YC-16-B	93	E2E02	1150	01	YC-16-B	94	F1288 100
01	YC-16-B	93	D2K36	1200	01	YC-16-B	93	B2H74 100
01	YC-16-B	93	D2K35	1200				

JUN 8 1982

EST. WT. 5243* LBS.

REQ. NO. (10826)

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
208	2 WEIGH IN DRUM AND POUR IN	480	32-D	480
	3 DUMP IN AND STIR 5 MINS. LOT	75X50	YC16B	3750
	RECORD: START 11:25 PM E2E02	1150		
	FIN 12:25 PM D2K36	1200		
		D2K35		
	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 2800-3200 PSI INTO V-208			
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 48" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-246, START			
&	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 8:25 PM TOTAL MINUTES 11:50			
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			
349	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
&	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	14 WEIGH INTO V-384 & PUMP TO V-349	2500	32-D	2500
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.094 G/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
	19 RECORD: PH 10.5 & ADJ TO 11.1-11.3 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	22	7-D	11
	SIPHON N-7-D INTO SV & RECORD: PH 11.3			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT *F			
	& RECORD: *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-290

343 121 WHILE HEATING SV, RUN 49" (1348 G) WATER INTO
& V-343
386 122 METER IN FROM V-386 M. 1.7, 10318/GAL, 36.2 GAL
5 123 STIR 15 MIN OR LONGER
124 RECORD: DENSITY 1020 G/ML (1.018-1.020)

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.8
126 SET V-343 ACID PUMP AT 69 SETTING (225 MIN)
127 SET V-349 SILICATE PUMP AT 54 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 12:05 3:55 P 2:30
V-349 12:05 3:10 P 1:00
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 12:25 (46) 47 (17) 16 9.9 (9.3-10.0)
40 MIN 12:45 (41) 4 (15) 14 9.8 (9.3-10.0)
1 HR 1:05 (37) 4 (13) 4 9.8 (9.3-10.0)
2 HRS 2:05 (23) 4 (6) 4 9.8 (9.3-10.0)
3 HRS 3:05 (10) 11 (0) 4 9.7 (9.3-10.0)
FINISH 3:55 (0) 0 7.2 (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

302 31 ADD 60" (465 G) WATER TO V-385
32 ADD & STIR FOR 2 MIN FOR S 63 ASSUME 50% 296 7-D 148

33 DURING STRIKE CHECK LEVEL IN V-387.
387 34 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37
8 35 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING
THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE
36 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW
STEARATE MAKE-UP PROCEDURE.

37 RUN IN 27" (268 GAL). DO NOT MAKE UP THIS
SOLUTION MORE THAN 30 MINUTES IN ADVANCE.
DELAY BETWEEN END OF STEP 43 HEAT-UP AND
START OF STEP 53 HOMOGENIZATION SHOULD BE
LESS THAN 30 MINUTES.

388 38 TURN ON STEAM & AGITATOR

9 39 ADJUST TO 37" (366 GAL) AT 178-182°F

40 SET BADGER METER FOR 590#

44 PUMP IN FROM V-387 THRU UNDERSURFACE
DISTRIBUTORS AS FAST AS POSSIBLE

482 169-A 482
54 155-A 54
54 160-A 54

42 SHUT OFF PUMP

43 STIR 30 MIN AT 178-182°F FOR S 53

44 DO NOT SHUT OFF AGITATOR

SV 45 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING

10 46 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR

47 STIR 60 MIN AT 190-194°F

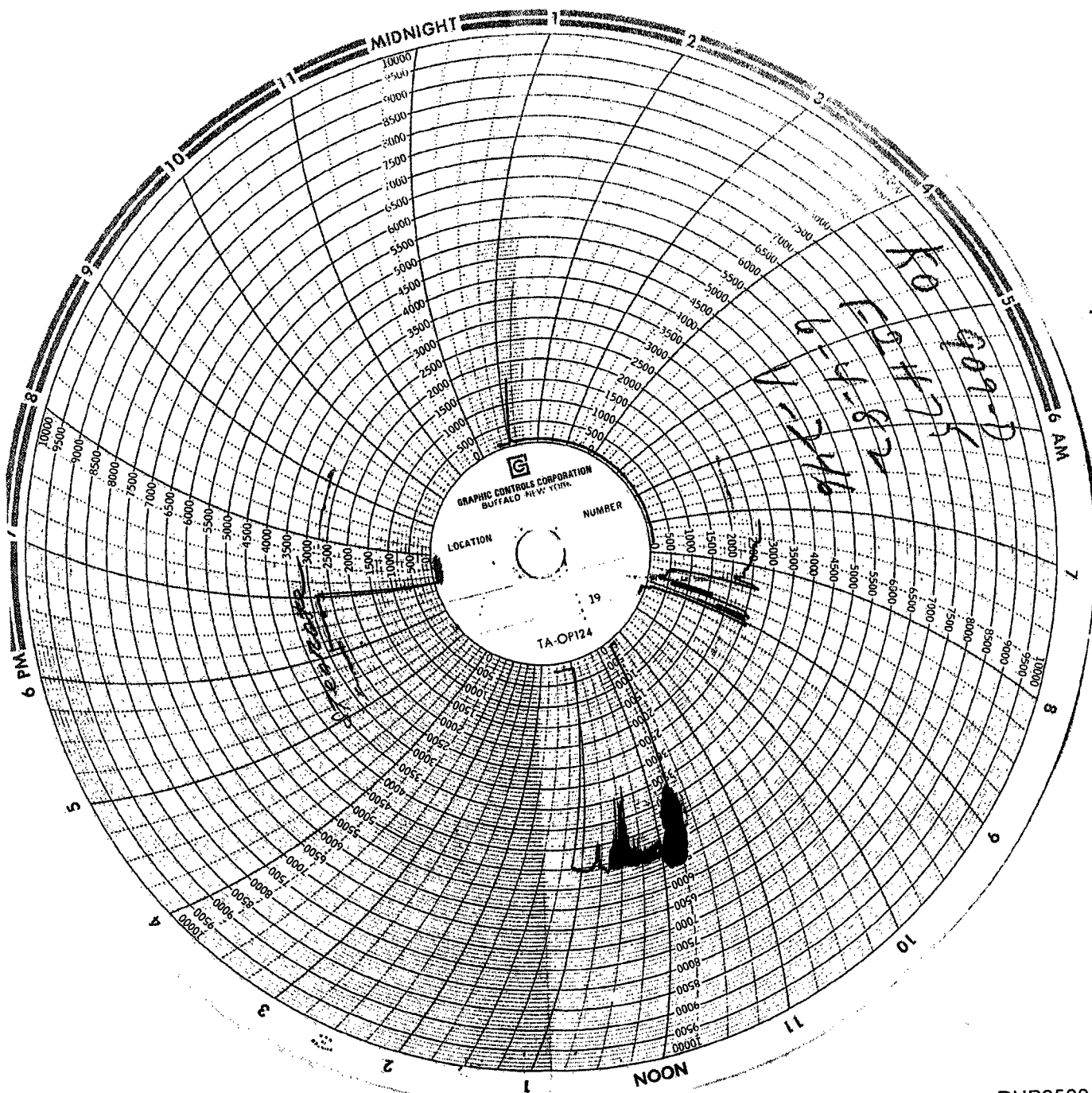
4:00 PM

EQUIP PAGE 3 CG 04 KO-909-D
 MENT, COMTYP JOB NAME: 04KO909DMC

USE N- ACCT
 LBS CODE LBS

SV	10	CONT	USE	N-	ACCT
			LBS	CODE	LBS
48	HEAT TO 198-200°F IN 5-10 MIN				
49	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP				
50	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET				
51	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER				
52	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER				
53	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.				
54	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP				
55	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER				
56	TURN OFF HOMOG & STEARATE PUMP				
57	STIR 5 MIN AT 198-200°F				
58	SHUT OFF STEAM				
59	RUN IN ALUM USING BADGER METER	950	115-D	475	
60	FLUSH ALUM LINE WITH WATER				
61	RECORD: PH <u>2.8</u> (3.4-3.8)				
62	IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH _____. NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN. AFTER EACH ADDITION. ASSUME 50%		115-D		
63	RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN				
64	RECORD: PH <u>4.4</u> (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH <u>6.2</u> ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	60	27-D 7-D	30	
65	SIPHON N-7-D INTO SV DO NOT STOP AGITATOR				

ST. FIN OPR
 3:00 PM 8:45 P 126-54



DUP050046960

