

04 CODE K0-789-D PKG.

JAN 19 33869

509-1432-LBS.

10.8

TIME

7 AM

01 YC-16-B 93 4 Lot 33476, 550#

01 YC-16-B 93 4 Lot 33474, 700#

01 YC-16-B 93 4 Lot 32521, 850#

Total Weight 5332# (Req 554)

NON-BLEEDING

PROCESSES		APPROVED BY	
() K0-789-D	(I)	EWK 09-21-76	
()	()	DCG 09-21-76	
()	()	MTW 10-02-76	
()	()	FWP 02-05-79	
TYPED BY			
emw020579			

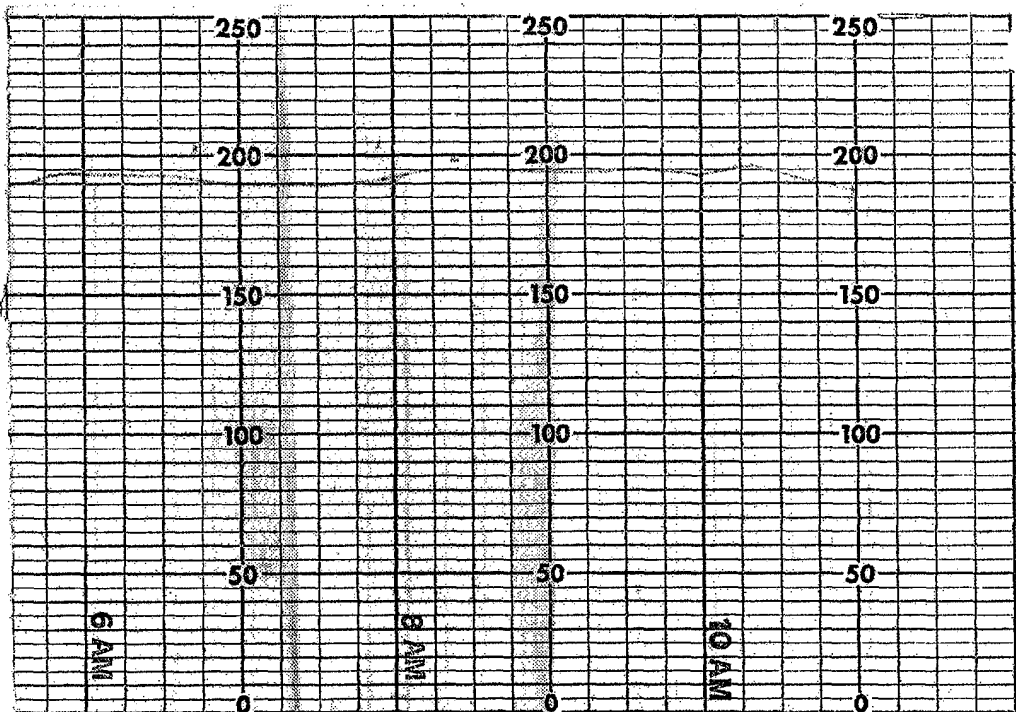
QTY	NAME:	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 60" (990 G) water into V-211			265
&	2 Weigh in drum & pour in	265-530	32-D	530
208	3 Dump in & stir 5 min	Lot 42 33476	YC-16-B	4200
1	Record: Start 2:30 PM	550		5100
	Fin 7:30 PM	33474		
		32521		
	4 Adj to 70" 1200 G	3800-3900		
	5 Pump V-211 thru Homog #2 at 4800-2200 psi into V-208			
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7 Record: V-208 Vol 43" & adj to 54" (1890 G)			
	8 Inspect Homog strainer & clean if necessary			
208	9 Run 10" (514 G) water into V-247 & start agitator & install temperature chart			
SV	10 Pump V-208 thru Homog at 4800-5200 psi into SV-			
2	Record: Time Start 12:15 P Total Min 150			
	NOTE: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	11 When V-208 MTY, run in 5" (240 G) water & pump thru Homog at 4800-5200 psi. Rinse in using Hot Water			
349	12 While Homog, run 6" (284 G) water into V-349			
&	13 Run + 1000# water into V-384 & heat to 110-120°F	1273		1370
384	14 Weigh into V-384 & pump to V-349	2930	32-D	2930
3	15 Run + 1000# water into V-384 & pump to V-349			
	16 Adj V-349 to 30" (1400 G) & stir 15 min or longer 22" (1040 G)			
	17 Record: 98° (1.044 (10.0 ± 0.2) (1.040 - 1.044)			
SV	18 When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19 Record: pH 10.6 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	8	7-D	4
	Siphon N-7-D into SV & Record: pH 11.3			
20	Heat to 190-194°F in 55-65 min & Record: HT 19.7°F			
	& Rec 19.7°F			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 70" (1920 G) water into V-343			
&	22 Meter in from V-386 M 1, 9.55#/Gal 20.4 Gal		27-D	440
386	23 Stir 15 min or longer			195
5	24 Record: 98° (1.009 (2.5 ± 0.1) (1.008 - 1.009)			

OK
Homog #2

AM

V-247

MPMENT	PAGE 2 CG 04 CODE K0-789-D (I) EST. WGT.	5332 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 25	When S 20 heating complete, Record: pH 10.1 (9.6-10.2)				
6 26	Set V-343 acid pump at 86 setting (± 255 minutes) 65				
27	Set V-349 silicate pump at 22 setting (± 210 minutes) 53				
28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike				
29	Record: Start 6:10 Min 3:25				
	V-343 4-15 830 325				
	V-349				
	Record: Time V-343 in V-349 in SV pH Normal pH				
	at 20 min 5:15 (68) 49 (28) 20 10.0 9.3-10.0				
	40 min 5:35 (68) 45 (28) 18 10.0 9.3-10.0				
	1 hr 5:55 (68) 41 (28) 16 9.9 9.3-10.0				
	2 1/2 hrs 7:10 (38) 25 (18) 8 7.7 9.3-10.0				
	3 1/2 hrs 8:25 (38) 9 1/2 (0) 6.7 9.3-10.0				
	Finish 9:10 (0) 2.8 7.5-8.5				
	NOTE: If pH drops below 9.3 in 1st hr, stop pumps & see Supervisor. If final pH is above 8.5, adj to 7.5-8.5 & Record: pH Assume 77%			27-D	
357 30	Run 33" (238 G) water into V-357 & heat to 135-140°F				265
7 31	Dump in & stir to dissolve		265 530	15-A	530
302 32	Add 42" (514 G) water to V-302				82
8 33	Add & stir 2 min Assume 50%		164 330	7-D	165
SV 34	When V-349 MTY, rinse in with minimum water then set pump at zero setting				
9 35	When V-343 MTY, rinse in with minimum water then turn off pump motor				
36	Stir 30 min at 190-194°F then turn off steam				
	Record: Start				
37	Run in V-357 from S 31 & stir 5 min				
38	Record: pH 3.8 (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 G 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			27-D	
	(Dilute 10 parts water to 1 part N-7-D)			7-D	
	Siphon N-7-D into SV				
41	Pour in & stir 15 min		12 25	978-A	12 25
42	Stop agitator				
	START FIN OPTR				
	7:00 AM 3:08 PM 2:35				
	7P 1050P 120-101				



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