CG 04 CODE KO-786-D PKG 5084* (EST WGT) 012/pl PROCESS ( ) KO-786-D (P) APPROVED BY: FWP 10/04/82

OCT 29 1982 (DATE) L2H37 (LOT) COMTYP JOBNAME: 04KO786DMP

TIME: __:00 __M STANDARD HRS. 10.5

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC-16	94	J1314	200	100.00	4	50	200	200
	01	YC-10	93	H2K58	2000	100.00	40	50	2000	2000
	01	YC-10	93	J2J04	2100	100.00	~~40~~ 42	50	2100	2100
	01	YC-10	93			100.00				

SUBSTANDARD BLEND-BACK FOR S-40: CODE _____, LOT _____, PQ ___, _____#

REQ. NO. 11015 NON-BLEEDING

EQUIPMENT		NAME : "KROLOR" ORANGE R	USE LBS	N CODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D (HYDRO-CHLORIC ACID) LINE, IF ANY IS BLANKED OFF".			
211 & 208	✓	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% (CAUSTIC SODA SOLN) & SET AGITATOR ON HIGH SPEED	30	7-D	15
	✓	WEIGH IN DRUM AND POUR IN (SODIUM SILICATE)	270	32-D	270
	✓	DUMP IN AND STIR 5 MIN (MOLYBDATE ORANGE)	8X50	YC10B	4100
		RECORD. START 8:30 PM LOT	4X50	YC16B	200
1		FIN 9:30 PM J1314	200		
		H2K58	2000		
		J2J04	2100		
	✓	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. 47 " & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 15" (771 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 7:45 AM TOTAL MINUTES 195			
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 & 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: 1078 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.6 & ADJ TO 10.4-10.8 USING N-7-D			
4		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 194 *F & RECORD: 194 *F			

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EQUIPMENT		PAGE 2 CG 04 KO-786-D V-246	USE LBS	N- CODE	ACCT LBS
	21	WHILE HEATING SV, RUN 51* (1400 G) WATER INTO			
343		V-343			
&	22	METER IN (SULFURIC ACID 60%) FROM V-386	_____	27-D	355
386		28, 11014#/GAL, 32.2 GAL			
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1019 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.85			
	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			
SV		AT 190-194*F DURING STRIKE			
6	29	RECORD: START FINISH MINUTES			
		V-343 12:50 PM 4:40 PM 230			
		V-349 12:50 PM 3:51 PM 181			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 1:10 (47) 47 (20) 20 9.3 (9.3-10.0)			
		40 MIN 1:30 (43) 42 (17) 17 9.35 (9.3-10.0)			
		1 HR 1:50 (38) 37 (15) 14 9.35 (9.3-10.0)			
		2 HR 2:50 (24) 25 (7) 8 9.5 (9.3-10.0)			
		3 HR 3:50 (10) 12 (0) 0 9.6 (9.3-10.0)			
		FINISH 4:35 PM 0) ___ 6.8 (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	ADD 67* (514 G) WATER TO V-385			
7	31	ADD & STIR 2 MIN	150	7-D	75
SV	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
8	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	34	TURN OFF STEAM			
	35	RUN IN LIQUID ALUM USING BADGER METER	600	115-D	300
	36	FLUSH ALUM LINE WITH WATER.	8		
	37	RECORD: PH 3.3 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH ___	4800		
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION.			
		ASSUME 50%	_____	115-D	_____
	38	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	39	RECORD: PH 4.0 (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	WHEN SCHEDULED ON TOP OF PAGE 1, DUMP IN SUBSTANDARD TO BE BLENDED BACK.			
		RECORD: CODE _____, LOT _____, _____#			
	41	STOP AGITATOR			

START	FINISH	OPERATOR
11:30 AM 1038	2:00 PM 3014	320
7.2	3.2	342
3:PM	5:29 PM	54

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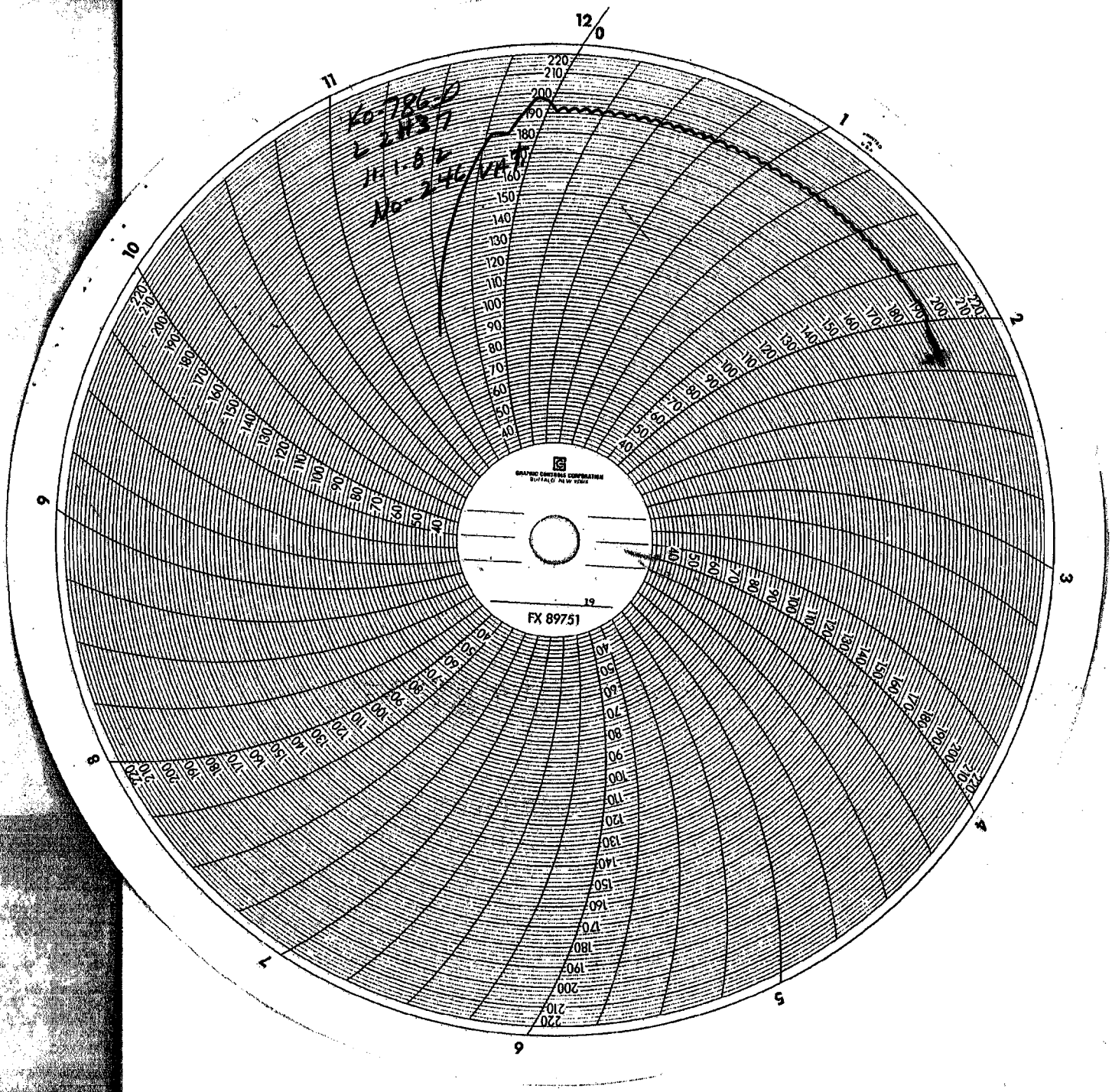

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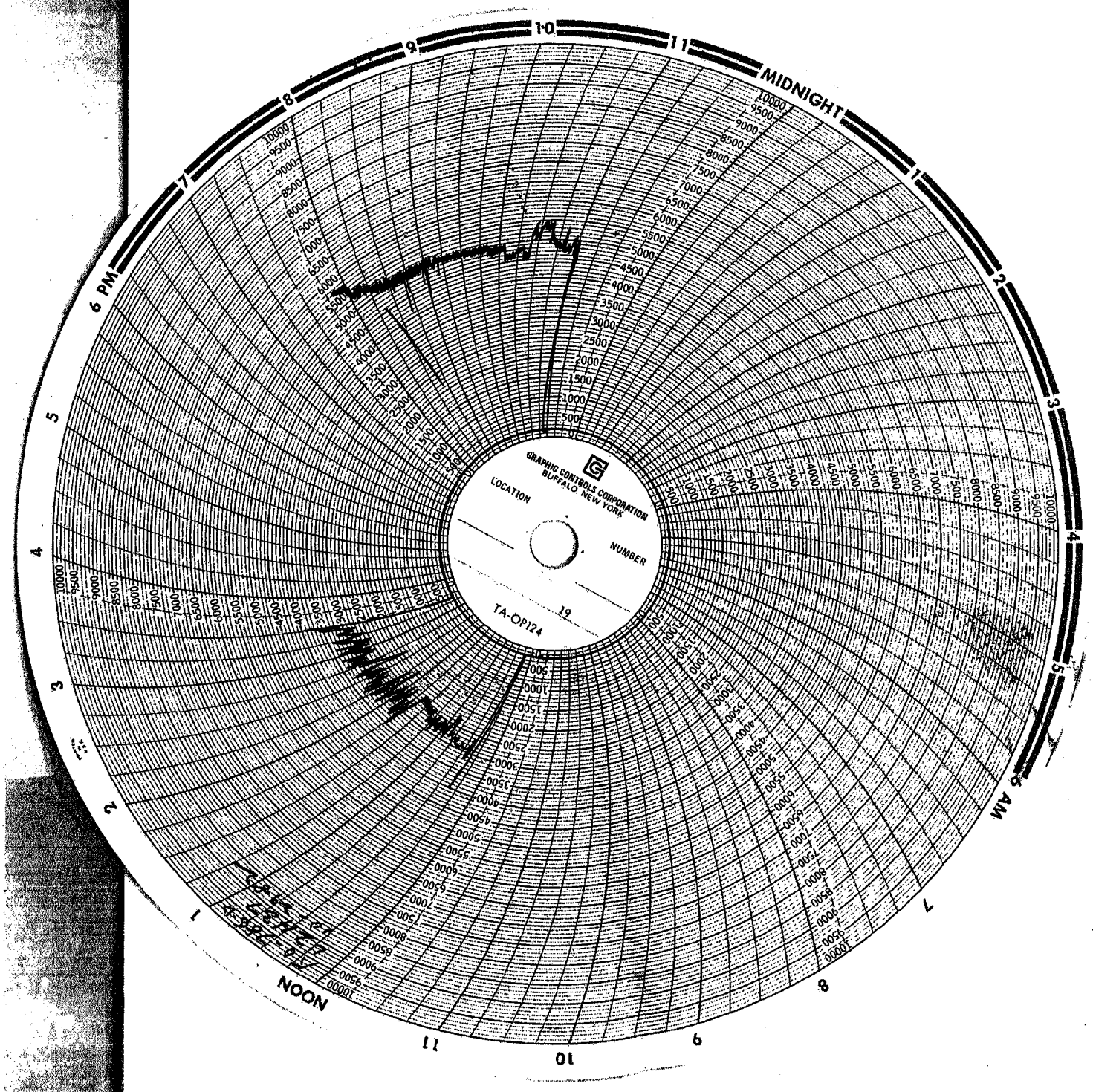

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