

CO 04 CODE K0-906-D PKG. 35743
EST. WGT. 1377 LBS.
STD. HRS. TIME 7A M
01 YC-10-B 93 4 35017 150#
01 YC-10-B 98 4 30133 150#
01 YC-10-B 93 4 35489 1350#

PROCESSSES
() K0-906-D (C) FWK 1/24/78
() () DCG 1/26/78
() () MW 1/26/78
TYPED BY
ri 3/2/78

APPROVED BY
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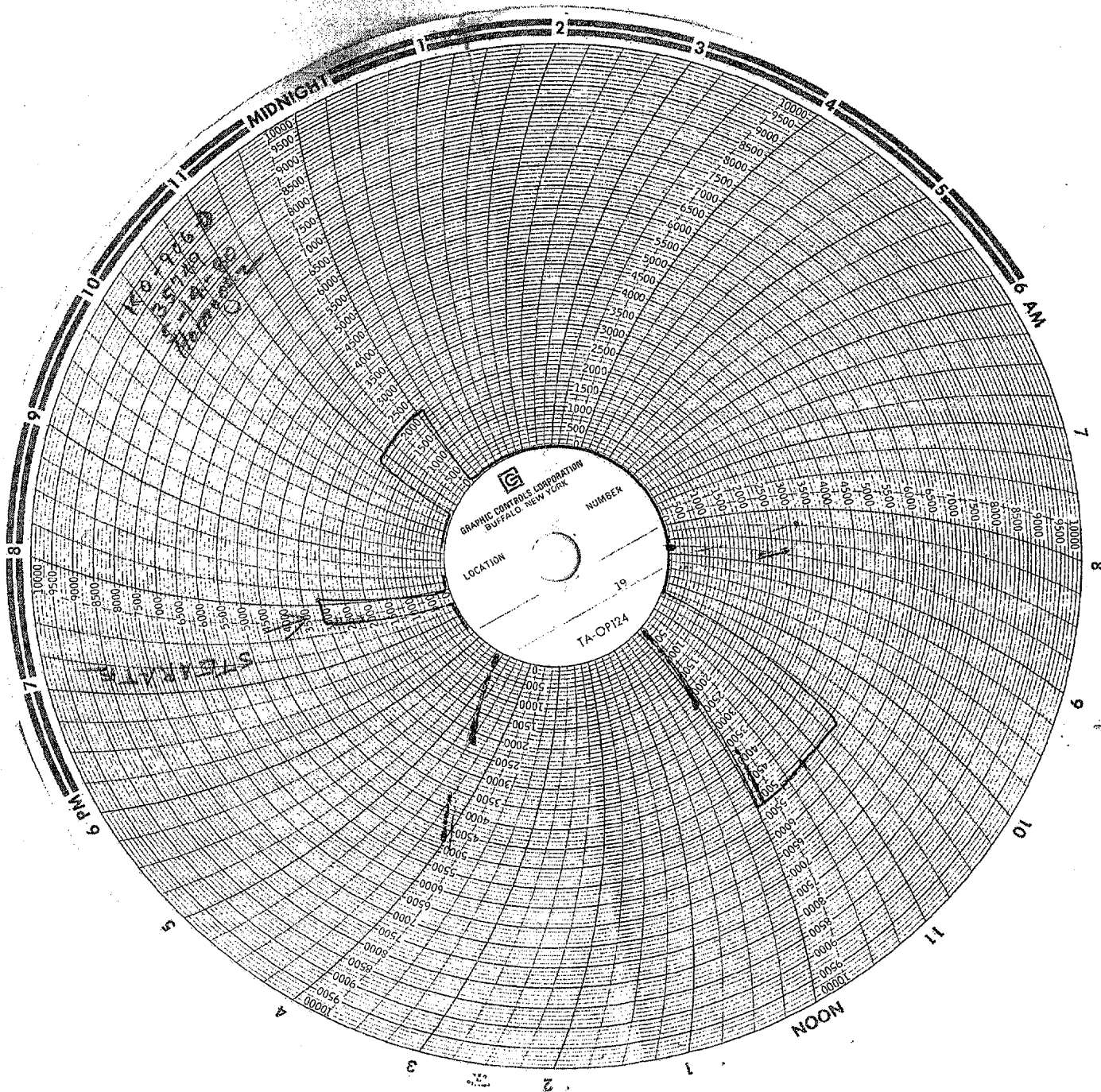
TOTAL WEIGHT 5077# (Req.)
Homog #2

QUIPMENT		NAME	USE LBS.	N CODE	ACCT. LBS.
211 208 1	8	1 Run 30" (505 G) water in V-211 and add <i>Run AGITATOR ON HIGH SPEED</i>	26	7-D	13
		2 Weigh in drum and pour in	245	32-D	245
		3 Dump in and stir 5 min	74 x 50	YC-10-B	3700
		Record: Start 1:30 PM			
		Finish 1:50 PM			
		4 Adjust to 64" (1082 G)			
		5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
		6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
		7 Record: V-208 Vol 40 " & adjust to 45" (1662 G)			
		8 Inspect Homog strainer and clean if necessary			
208 SV	8	9 Run 15" (793 G) water into V-245 & start agitator			
		10 Pump V-208 thru Homog at 4800-5200 psi into SV			
		11 Record: Time Start 10:44 Total Min 11:11			
		Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
		12 When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 384	8	13 While Homog, run 5" (237 G) water into V-349			
		14 Run 1000#water into V-384 and heat to 110-120°F			
		15 Weigh into V-384 and pump to V-349	2165	32-D	2165
		16 Run 1000#water into V-384 and pump to V-349			
		17 Adjust V-349 to 20" (946 G) and stir 15 min or longer			
SV	4	18 Record: ϕ_{Be} 1.080 (10.9 + 0.2) 1.078-1.081			
		19 When S12 Homog complete, adj to 59" (3033 G) in SV			
		20 Record: pH 10.85 & adj to 10.4-10.8 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D)		7-D	
		Siphon N-7-D into SV, stir 5 min & record: pH			
		21 Heat to 190-194°F in 55-65 min & Record: HT 187 Rec 194 OF			
343 386	8	Note: Strike must be started immediately on completion of heating			
		22 While heating SV, run 46" (1265 G) water into V-343			
		23 Meter in from V-386 M 33 10.50 #/Gal, 30.5 Gal		27-D	320
		24 Stir 15 min or longer			
		25 Record: ϕ_{Be} 1.019 (2.9 + 0.1) (1.018-1.019)			

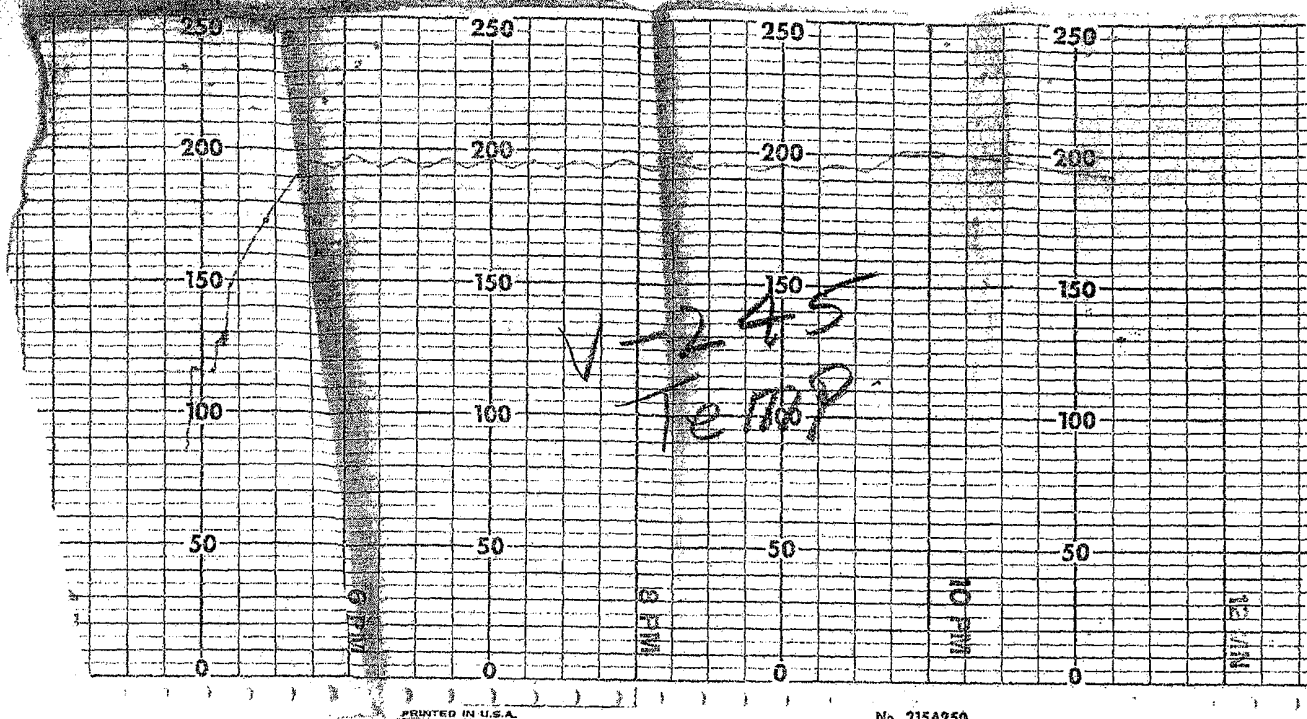
V-245

EQUIPMENT	PAGE 2	CG 04	CODE K049064D (C)	EST. WGT. 5077	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	26	When S20 heating complete, Record: pH 9.9 (9.6-10.2)						
	27	Set V-343 acid pump at 65 setting (± 225 min)						
	28	Set V-349 Silicate pump at 57 setting (± 180 min)						
	29	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike						
	30	Record: Start Finish Minutes						
		V-343 3:20 PM 7:25 P 295						
		V-349 6:30 P 190						
		Record:	Time	V-343	V-349	SV pH	Normal pH	
			3:20	Inches	Inches			
		at 20 min	3:40	(43) 44-	(18) +	9.7	9.3-10.0	
		40 min	4:00	(39) 40-	(16)	9.7	9.3-10.0	
		1 hr	4:20	(35) 36	(13) 14-	9.7	9.3-10.0	
		2 hrs	5:20	(22) 24	(7) 8	9.7	9.3-10.0	
		3 hrs	6:20	(10) 13	(0) 1	9.75	9.3-10.0	
		Finish	7:25	(0)		7.75	7.5-8.5	
		Note: (1) If pH not as specified notify supervisor & note in Log (2) If final pH is above 8.5, adj to 7.5-8.5 and						
		Record: pH				Assume 78%		
	31	Sift in 1 bag				✓ 50	27-D 128-A 65	50
356	7	Run 19" (137 G) water into V-356 & heat to 135-140°F				✓ 270	15-A	270
	33	Dump in & stir to dissolve for S61						
302	8	Run 24" (294 G) water into V-302						
	35	Add & stir 2 min for S64				Assume 50%	136	7-D 68
PT	9	During strike pump into PT				464	169-A	464
	37	Pump in				52	155-A	52
	38	Pump in				52	160-A	52
	39	Stir 10 min with lightning mixer for S43						
356	10	During strike, run 22" (268 G) water into V-356						
	41	Turn on steam						
	42	Adj to 30% (366 G) at 178-182°F 81-82°C						
	43	Pump PT, mixture from S39 thru undersurface Distributor AFAP						
	44	Rinse PT with hot water from hot water mixer & pump in						
	45	Shutoff pump 81-82°C						
	46	Stir 30 min at 178-182°F for S55						
	47	Do not shutoff agitator						
SV	11	When V-349 MTY, rinse in with minimum water then set pump to zero setting						
	49	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	50	Heat to 198-200°F in 5-10 min						
	51	Close water line & discharge valves at stearate pump						
	52	Open V-356 Discharge valves to stearate pump inlet						
	53	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer						
	54	While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & close valve to sewer						
	55	Immediately open stearate pump Discharge valve. Turn on pump & Homog V 356 to SV at 2900-3100 psi. Maintain SV at 198-200°F						
	56	While Homog V-356 to SV, shutoff water valve at Stearate pump ASAP						

EQUIPMENT		PAGE 3 CG 04 CODE KO-906-D (C) EST. WGT. 5077	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	57	When Homog complete; rinse in V-356 with hot water				
11		From hot water mixer				
Con't	58	When S57 complete, turn off Homog & stearate pump				
	59	Stir 5 min at 198-200°F				
	60	Shut off steam				
	61	Run in V-357 from S33 and stir 5 min				
	62	Record: pH 3.5 (3.3-3.7)				
	63	If necessary, adj pH to 3.3-3.7 (Downward only) and				
		Record: pH			15-A	
	64	Run in N-7-D from S35 in 4-6 min and stir 5 min				
	65	Record: pH 4.4 (4.0-4.2) and if necessary, adj to				
		pH 4.0-4.2 and Record: pH 4.2 Assume 78%		6	27-D	4
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%			7 D	
		Siphon N-7-D into SV				
	66	Do not stop agitator				
		START	FIN	OPTR		
		3:00P	11:00P	235		
		7:00A.M.	3:00P.M.	54-120		
		3:00P	9:00P	235		



245



DUP050457882

N32406.02