

246, (247)

C.V.

D.V.

C 04 CODE KO-789-D PKG.

JAN 21 33942

WGT 762 1132 LBS.

10.8 TIME

11 P M

01 YC-16-B 93 4 Lot 33478 150#

01 YC-16-B 93 4 Lot 33474 800#

01 YC-16-B 93 4 Lot 33580 2150#

PROCESSES		APPROVED BY	
() KO-789-D	(I)	EWK 09-21-76	
()	()	DCG 09-21-76	
()	()	MTW 10-02-76	
()	()	FWP 02-05-79	
TYPED BY			
EMW020579			

Total Weight 5332# (Req 0568)

NON-BLEEDING

LINE	NAME	USE LBS.	N CODE	ACCT. LBS.
211	Run 60" (990 G) water into V-211			390
208	Weigh in drum & pour in	390 530	32-D	620
1	Dump in & stir 5 min	84 x 50	YC-16-B	4200
	Record: Start 2:45 P M	33478		3100
	Fin 9:45 P M	33474		
	Adj to 70" (1200 G)	33580		
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	Record: V-208 Vol 4 & adj to 54" (1890 G)			
	Inspect Homog strainer & clean if necessary			
208	Run 10" (514 G) water into V-247 & start agitator & install temperature chart			
SV	Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start 8:30 A Total Min 145			
	NOTE: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	When V-208 MTY, run in 5" (240 G) water & pump thru Homog at 4800-5200 psi. Rinse in using Hot Water			
349	While Homog, run 6" (284 G) water into V-349			
8	Run ± 1000 # water into V-384 & heat to 110-1200F	1880		1880
384	Weigh into V-384 & pump to V-349	2930	32-D	2930
3	Run ± 1000 # water into V-384 & pump to V-349			
	Adj V-349 to 30" (1400 G) & stir 15 min or longer 22" (1040 G)			
	Record: 08 1.062 (1.061-1.064)			
SV	When S 10 Homog complete, adj SV to 45" (2300 G)			
4	Record: pH 10.5 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		7-D	10
	Siphon N-7-D into SV & Record: pH 11.2			
20	Heat to 190-1940F in 55-65 min & Record: HT 190 OF			
	& Rec 190 OF			
	NOTE: Strike must be started immediately on completion of heating			
343	While heating SV, run 70" (1920 G) water into V-343			
8	Meter in from V-386	30.5 Gal	27-D	440
386	Stir 15 min or longer			290
5	Record: 08 1.015 (2.5 ± 0.1) (1.013-1.015)			

V-247

PMENT	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 25 setting (± 255 minutes) 6.5				
27	Set V-349 silicate pump at 28 setting (± 210 minutes) 3.4				
28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike				
29	Record: Start 2:45 P M Fin 1:15 P M Min 2:10				
	V-343 2:45 P M V-349 6:30 P M 2:25				
	Record: Time V-343 V-349 SV Normal				
	at 20 min 3:05 P (68) 44 (28) 20 9.9 9.3-10.0				
	40 min 3:25 P (68) 45 46 (28) 18-19 9.8 9.3-10.0				
	1 hr 3:45 P (68) 41-42 (28) 16-16 9.8 9.3-10.0				
	2 1/2 hrs 3:00 P (28) 25-28 (28) 8-8 9.8 9.3-10.0				
	3 1/2 hrs 6:15 (28) 9-13 (0) 0 9.8 9.3-10.0				
	Finish 7:00 (0) 0 0 6.8 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				370
7 31	Dump in & stir to dissolve		370 530	15-A	530
302 32	Add 42" (514 G) water to V-302				
8 33	Add & stir 2 min Assume 50%		240 930	7-D	165
					120
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 1:15 P M				
37	Run in V-357 from S 31 & stir 5 min				
38	Record: pH 3.7 (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 6.8 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH Assume 77%		10	27-D	7
	Dilute 10 parts water to 1 part N-7-D) Assume 50%			7-D	
	Siphon N-7-D into SV				
41	Pour in & stir 15 min		37 25	978-A	37 25
42	Stop agitator				
	START FIN OPTR				
	11:00 am 7:00 am 3:00-1:40				
	7:00 A 3:10 P M 2:25				
	3:00 P M 9:45 P M 381.438				



