CG 04 CODE K0789D PKG 35956 PUNCHED & CHECKED PROCESSES APPROVED BY

EST'D WGT 1032 LBS ( ) K0789D (I) FWP 4/28/80

JUN - 5 1980 ( ) ( )

STANDARD HRS. 10.8 TIME 7A M ( ) ( )

TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	35786	450#
01	YC016B	93	35862	2000#
01	YC016B	93	34570	1750#

2G

JUN 3 - 1980

(2)

TOTAL EST'D WGT 5232 REQ. NO.( ) NON-BLEEDING

EQUIP		NAME : "KROLOR"ORANGE Y	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60"(990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM AND POUR IN	530	32-D	530
	3	DUMP IN AND STIR 5 MINS. LOT	84X50	YC16B	4200
1		RECORD: START 12 00 35786	450		
		FIN : 3 30 AM 35862	2000		
		34570	1750		
	4	ADJUST TO 75" (1275 G)			
	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._____" & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV 2	9	RUN 10" (514 G) WATER INTO V-211 & START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1230P TOTAL MINUTES 130			
	11	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384 3	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	2545	32-D	2545
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	16	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.086 G/ML (1.082-1.086)			
SV 4	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.4 & ADJ TO 11.1-11.3 USING N-7-D			
		DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	28	7-D	14
		SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC: HT 188 *F & RECORD: 194 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

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EQUIP		PAGE 2 . CG 04 KO-789-D EST WGT 5232# V-247	USE LBS	N-CODE	USE LBS
	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M37, 10.85#/GAL 359 GAL		27-D	390
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1020 GM/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	26	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)			
	27	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
SV		AT 190-194*F DURING STRIKE.			
	29	RECORD: START FINISH MINUTES			
		V-343 6:30 PM 11:40 290			
		V-349 6:30 PM 10:05 PM 215			
		TIME V-343 V-349 SV NORMAL			
		6:30 INCHES INCHES PH PH			
		AT 20 MIN 6:50 (49) ___ (20) ___ 9.8 (9.3-10.0)			
		40 MIN 7:10 (45) ___ (18) ___ 9.5 (9.3-10.0)			
		1 HR 7:30 (41) + (16) ___ 9.8 (9.3-10.0)			
		2 1/4 HR 8:45 (25) 28- (8) ___ 9.8 (9.3-10.0)			
		3 1/2 HR 10:00 (9) 12+ (0) + 9.7 (9.3-10.0)			
		FINISH 10:45 (0) ___ 7.0 (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	
356	30	RUN 31" (238 G) WATER INTO V-356 & HEAT TO			
7		135-140*F			
385	31	DUMP IN & STIR TO DISSOLVE	530	15-A	530
302	32	ADD 42" (514 G) WATER TO V-302			
8	33	ADD & STIR 2 MIN	330	7-D	165
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &			
		SET PUMP AT ZERO SETTING.			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &			
		TURN OFF PUMP MOTOR.			
	36	STIR 30 MIN AT 190-194*F, THEN TURN OFF STEAM			
		RECORD: START 11:10 PM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.6 (3.4-3.8) & IF NECESSARY ADJ			
		(DOWN ONLY) TO 3.4-3.8 & RECORD: PH___			
		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140 *F IN DRUM , USE 30 GAL 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___ ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN	50	978-A	50
	42	STOP AGITATOR			

START	FINISH	OPERATOR
7:00 AM	3:00 PM	209-301
3:00 PM	11:00 PM	235-320
11:00 PM	7:00 AM	342-341

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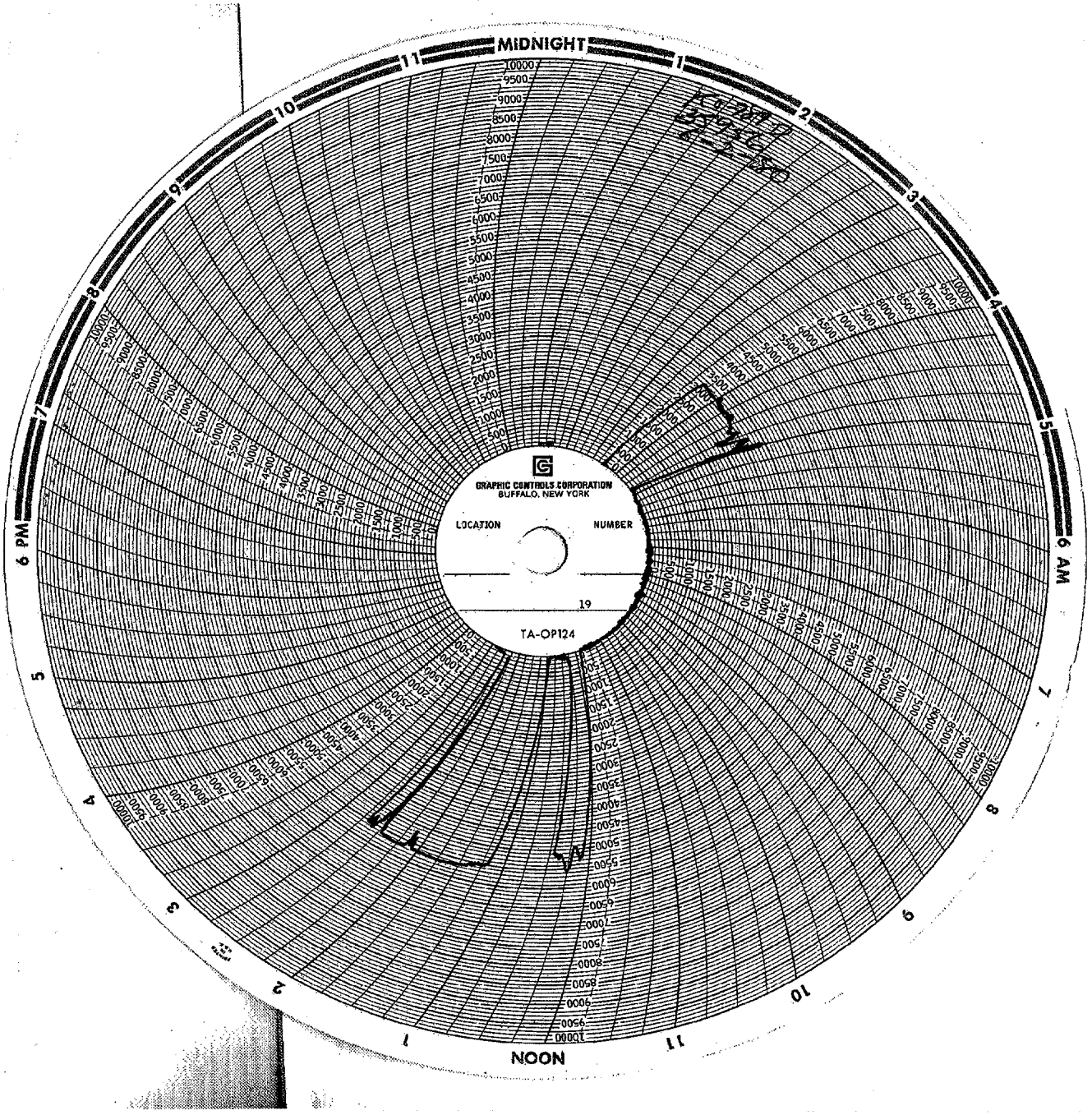

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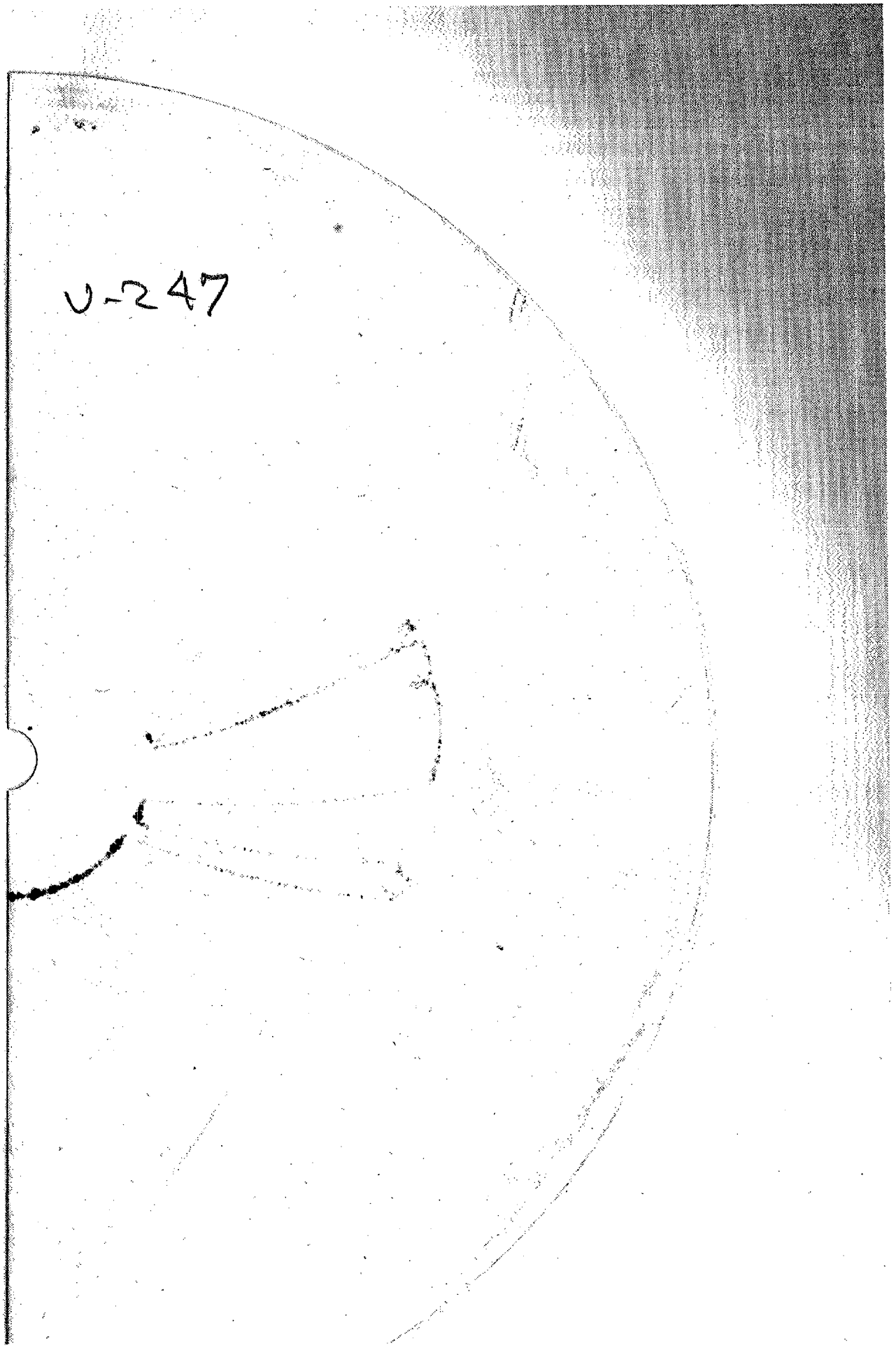

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