

NOV 4 1982

L2H91

5008* (EST WT)

TIME 7:40 A.M.

COMTYF JOB NAME: 04K0906DMC

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC-10	93	H2K58	3300	100.00	66	50	3300	3300
	01	YC-10	93	D2H24	450	100.00	9	50	450	450
	01	YC-10	93							

WAREHOUSE REQUEST NO. 1104 ✓

EQUIP MENT	NAME : 'KROLOR' ORANGE R	USE LBS	N- CODE	ACCT LBS
211 & 208	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF. 1 RUN 60" (990 G) WATER IN V-211, ADD CAUSTIC SODA SOLN. SET AGITATOR ON HIGH SPEED. ASSUME 50% 2 WEIGH IN DRUM AND POUR IN (SODIUM SILICATE) 3 DUMP IN AND STIR 5 MINS (MOLYBDATE ORANGE) RECORD: START 9:15 PM LOT #2K58 45X50 2250 FIN 10:30 PM 2K81 21X50 1050 D2H24 9X50 450 4 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 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 1800-2200 PSI INTO V-208 7 RECORD: V-208 VOL. 46 & ADJUST TO 45" (1662G) 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY	26 245 75X50 2250 1050 450	7-D 32-D YC10B	13 245 3750
208 & SV	9 RUN 15" (793 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 11:20 PM TOTAL MINUTES 90 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 5" (237 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 15 RUN 1000# WATER INTO V-384 & PUMP TO V-349 3 16 ADJ V-349 TO 20" (946 G) & STIR 15 MIN 17 RECORD DENSITY: 1.080G/ML (1.078-1.081)	2165	32-D	2165
SV & 4	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G) 19 RECORD: PH 10.8 & ADJ TO 10.4-10.8 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% 20 SIPHON N-7-D INTO SV & RECORD: PH 190 *F HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190 *F & RECORD: 190 *F NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING		7-D	

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EQUIP MENT	PAGE 2 CG 04 KO-906-D (C)	USE LBS	N- CODE	USE LBS
343	WHILE HEATING SV RUN 46" (1265G) WTR INTO V-343			
386	METER IN SULFURIC ACID 60% FROM V-386		27-D	320
5	M 28 11014 ± / GAL 29.0 GAL			
123	STIR 15 MIN OR LONGER			
124	RECORD: DENSITY 1.018 G/ML (1.018-1.020)			
125	WHEN S 20 HEATING COMPLETE, RECORD PH			
126	SET V-343 ACID PUMP AT 65 SETTING (225 MIN)			
127	SET V-349 SILICATE PUMP AT 57 SETTING (180 MIN)			
128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
SV	AT 190-194°F DURING STRIKE			
6	RECORD:			
	V-343 START 2:55 AM FINISH 6:08 AM MINUTES 270			
	V-349 START 3:55 AM FINISH 5:15 AM MINUTES 180			
	TIME V-343 V-349 SV NORMAL			
	INCHES INCHES PH PH			
	AT 20 MIN 3:15 (43) (18) 9:16 (9.3-10.0)			
	40 MIN 3:35 (39) (16) 9:15 (9.3-10.0)			
	1 HR 3:55 (35) (13) 9:14 (9.3-10.0)			
	2 HRS 4:15 (22) (7) 9:11 (9.3-10.0)			
	3 HRS 5:15 (10) (0) 9:12 (9.3-10.0)			
	FINISH 6:40 (0) 7:15 (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%			
30	SET IN (BEANG T&X IN)		27-D	55 120 11 55
385	ADD 38" (295 G) WATER TO V-385			
7	ADD & STIR FOR 2 MIN FOR S 62 ASSUME 50%	136	7-D	68
387	DURING STRIKE CHECK LEVEL IN V-387.			
8	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37			
388	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
389	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			
390	RUN IN 27" (268 GAL). DO NOT MAKE UP THIS SOLUTION MORE THAN 30 MINUTES IN ADVANCE. DELAY BETWEEN END OF STEP 43 HEAT-UP AND START OF STEP 52 HOMOGENIZATION SHOULD BE LESS THAN 30 MINUTES.			
391	TURN ON STEAM & AGITATOR			
392	ADJUST TO 37" (366 GAL) AT 178-182°F			
393	SET BADGER METER FOR 572±			
394	PUMP IN FROM V-387 THRU UNDERSRFE DISTRIBUTORS AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL STEARATE, EMCOL F-10-59)	468	169-A	468
395	SHUT OFF PUMP	52	155-A	52
396	STIR 30 MIN AT 178-182°F FOR S 52	52	160-A	52
397	DO NOT SHUT OFF AGITATOR			
SV	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING.			
10	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR.			

EQUIP MENT	PAGE 3 CG 04 KO-906-D (C)	USE LBS	N- CODE	USE LBS
	V-246			
47	HEAT TO 198-200°F IN 5-10 MIN			
SV 48	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
10				
CONT 49	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
50	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
51	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
52	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
53	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
54	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
55	TURN OFF HOMOG & STEARATE PUMP			
56	STIR 5 MIN AT 198-200°F			
57	SHUT OFF STEAM			
58	RUN IN LIQUID ALUM USING BADGER METER	540	115-D	270
59	FLUSH ALUM LINE WITH WATER			
60	RECORD: PH <u>3.4</u> (3.3-3.7)			
61	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH _____			
	NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION.			
62	RUN IN N-7-D FROM S32 IN 4-6 MIN & STIR 5 MIN		115-D	
63	RECORD: PH <u>4.1</u> (4.0-4.2) & IF NECESSARY, ADJ TO PH 4.0-4.2 & RECORD: PH _____			
	(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%		27-D	
	SIPHON N-7-D INTO SV		7-D	
64	DO NOT STOP AGITATOR			

START
3:PM
11:00PM
7:00 AM

FINISH
11:PM
7:00 AM
8:20 AM
OPER
54
409
37-342



