

S.V. 246 245 244 243 242 241 240 239 238 237 236 235 234 233 232 231 230 229 228 227 226 225 224 223 222 221 220 219 218 217 216 215 214 213 212 211 210 209 208 207 206 205 204 203 202 201 200 199 198 197 196 195 194 193 192 191 190 189 188 187 186 185 184 183 182 181 180 179 178 177 176 175 174 173 172 171 170 169 168 167 166 165 164 163 162 161 160 159 158 157 156 155 154 153 152 151 150 149 148 147 146 145 144 143 142 141 140 139 138 137 136 135 134 133 132 131 130 129 128 127 126 125 124 123 122 121 120 119 118 117 116 115 114 113 112 111 110 109 108 107 106 105 104 103 102 101 100 99 98 97 96 95 94 93 92 91 90 89 88 87 86 85 84 83 82 81 80 79 78 77 76 75 74 73 72 71 70 69 68 67 66 65 64 63 62 61 60 59 58 57 56 55 54 53 52 51 50 49 48 47 46 45 44 43 42 41 40 39 38 37 36 35 34 33 32 31 30 29 28 27 26 25 24 23 22 21 20 19 18 17 16 15 14 13 12 11 10 9 8 7 6 5 4 3 2 1

MAY 30 1980

CG 04 CODE KO-909-D PKG PROCESSES APPROVED BY
 EST'D WGT 1596 LBS MAY 27 35898 () KO-909-D (C) FWP 5/19/80
 STANDARD HRS. TIME 11A () () () ()
 TYPED BY: FWP 5/19/80

CG CODE PQ LOT LBS
 01 YC016B 93 35438 1600
 01 YC016B 93 34575 1150
 01 YC016B 93 34571 750
 01 YC016B 93 34573 200

Homog #2

TOTAL EST'D WGT 5296 REQ. NO. () NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED			
208	2 WEIGH IN DRUM AND POUR IN	480	32-D	480
	3 DUMP IN AND STIR 5 MINS. RECORD: START 7:30 PM FIN 10:20 PM	74X50	YC16B	3700
	4 ADJUST TO 75" (1275 G)	1600		
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208	750		
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2800-3200 PSI INTO V-208	200		
	7 RECORD: V-208 VOL. 50 " & ADJUST TO 54" (1890G)	1150		
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-208, START AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START 12:30 PM TOTAL MINUTES 1:50			
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	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F	2500	32-D	2500
	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 19" (899 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.094 G/ML (1.091-1.094)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G)			
4	19 RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	20 SIPHON N-7-D INTO SV & RECORD: PH 11.1 ASSUME 50%	70	7-D	10
	21 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 11.1 *F & RECORD 11.1 *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING			

N34598

43	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343			
46	22	METER IN FROM V-386 M 36 10.59 34.3		27-D	373
5	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.019 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1			
	26	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 9:40.4 24.0			
		V-349 8:45.0 18.5			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH			
		AT 20 MIN 6- (46) (17) 9.6 13-10.0			
		40 MIN 6:40 (41) (15) 9.3 9.3-10.0			
		1 HR 6:40 (37) (13) 9.9 (9.3-10.0)			
		2 HRS 7:40 (23) 2.5+ (6) + 9.9 (9.3-10.0)			
		3 HRS 8:40 (10) 1.3 (0) + 9.9 (9.3-10.0)			
		FINISH 9:40 0 - 7.6 (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	
	30	SIFT IN	50	128-A	50
	31	RUN 28" (216 G) WATER INTO V-385 & HEAT TO 135-140°F			
	32	DUMP IN & STIR TO DISSOLVE FOR S-61	477	15-A	477
	33	ADD 38" (465 G) WATER TO V-302			
	34	ADD & STIR FOR 2 MIN FOR S 64 ASSUME 50%	296	7-D	148
	35	DURING STRIKE PUMP INTO PT	482	169-A	482
PT	36	PUMP IN	54	155-A	54
	37	PUMP IN	54	160-A	54
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			
	39	DURING STRIKE RUN 15" (268 G) WATER INTO V-356			
	40	TURN ON STEAM			
5	41	ADJ TO 21" (366 G) AT 81-82°C			
	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE			
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN			
	44	SHUT OFF PUMP			
	45	STIR 30 MIN AT 81-82°C FOR S 55			
	46	DO NOT SHUT OFF AGITATOR			

EQUIP	PAGE 2	CG 04	KO-909-D	EST WGT 5296#	USE	N-	USE
					LBS	CODE	LB:
343	21	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343					
&	22	METER IN FROM V-386 M _____ #/GAL, _____ GAL				27-D	37
386	23	STIR 15 MIN OR LONGER					
5	24	RECORD: DENSITY _____ G/ML (1.018-1.020)					
SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH _____					
	26	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)					
	27	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)					
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE					
	29	RECORD: START FINISH MINUTES					
		V-343 _____					
		V-349 _____					
		TIME V-343 V-349 SV NORMAL					
		INCHES INCHES PH PH					
		AT 20 MIN (46) (17) (9.3-10.0)					
		40 MIN (41) (15) (9.3-10.0)					
		1 HR (37) (13) (9.3-10.0)					
		2 HRS (23) (6) (9.3-10.0)					
		3 HRS (10) (0) (9.3-10.0)					
		FINISH (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	
	30	SIFT IN			50	128-A	50
385	31	RUN 28" (216 G) WATER INTO V-385 & HEAT TO					
7		135-140°F					
	32	DUMP IN & STIR TO DISSOLVE FOR S-61			477	15-A	477
302	33	ADD 38" (465 G) WATER TO V-302					
8	34	ADD & STIR FOR 2 MIN FOR S 64 ASSUME 50%			296	7-D	148
	35	DURING STRIKE PUMP INTO PT			482	169-A	482
PT	36	PUMP IN			54	155-A	54
9	37	PUMP IN			54	160-A	54
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42					
	39	DURING STRIKE RUN 15" (268 G) WATER INTO V-356					
	40	TURN ON STEAM					
356	41	ADJ TO 21" (366 G) AT 81-82°C					
10	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE					
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN					
	44	SHUT OFF PUMP					
	45	STIR 30 MIN AT 81-82°C FOR S 55					
	46	DO NOT SHUT OFF AGITATOR					

EQUIP

PAGE 3 CG 04 KO-909-D EST WGT 5296#

USE
LBSN-
CODEUSE
LBS

V-245

- SV 147 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
- 11 148 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
- 149 STIR 60 MIN AT 190-194°F
- 150 HEAT TO 198-200°F IN 5-10 MIN
- 151 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP
- 152 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET
- 153 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER
- 154 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER
- 155 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
- 156 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
- 157 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER
- 158 TURN OFF HOMOG & STEARATE PUMP
- 159 STIR 5 MIN AT 198-200°F
- 160 SHUT OFF STEAM
- 161 RUN IN V-385 FROM S-32 & STIR 5 MIN
- 162 RECORD: PH 3.1 (3.4-3.8)
- 163 IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY)
& RECORD: PH
- 164 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- 165 RECORD: PH 6.9 (6.2-6.4) & IF NECESSARY, ADJ
TO PH 6.2-6.4 & RECORD: PH 6.3 ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
- 166 SIPHON N-7-D INTO SV
- 166 DO NOT STOP AGITATOR

10

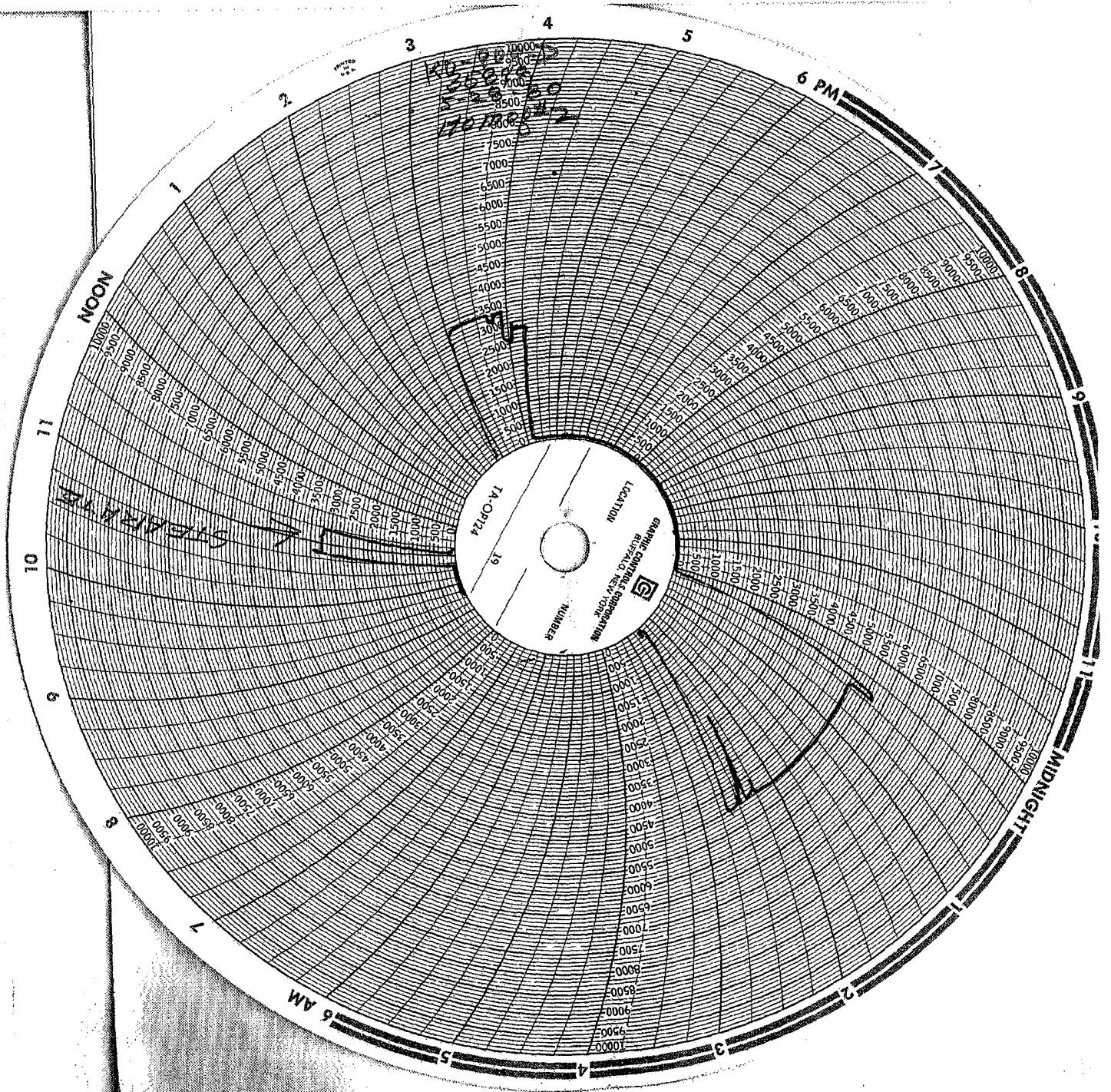
27-D
7-D

8

7:00 A

10:00 PM

235-37



V-245

