

CG 04 CODE KO-789-D PKG

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS MAY -0.81-21460

KO-789-D (I)

FWP 01/16/81

STANDARD HRS. 10.8 TIME ----- M

JOB NAME: 04KO789-DMI

CG	CODE	PG	LOT	LBS
01	YC016B	93	29518	200
01	YC016B	93	E1222	2100
01	YC016B	93	E1229	1400

YC-16 72335 80# (2 bags)
 YC-16 1231 700

TOTAL EST'D WGT ~~5202~~ 5232 REQ. NO. (10237)

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.			
1	2 WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN RECORD: START 10:30 PM FIN 12:30 AM	530 84X50 2X10 700 1400 2100	32-D YC16B 5C16B	530 4200 80
	3 ADJUST TO 75" (1275 G)	E1222		
	4 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	5 WHEN V-211 MTY. WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208			
	6 RECORD: V-208 VOL. 44" & ADJUST TO 54" (1890G)			
	7 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	8 RUN 10" (514 G) WATER INTO V-208. START AGITATOR & INSTALL TEMP CHART			
2	9 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 4:20 AM TOTAL MINUTES 120			
	10 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 6" (284 G) WATER INTO V-349			
3	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: 1.0826 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
4	19 RECORD: PH 10.6 & ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	20 SIPHON N-7-D INTO SV & RECORD: PH 11.1	16	7-D	8
	21 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 185°F & RECORD: 193°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-247

343	121	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
386	122	METER IN FROM V-386 M/L 1146 #/GAL, 350 GAL		27-D	390
5	123	STIR 15 MIN OR LONGER			
	124	RECORD: DENSITY 1.020 G/ML (1.018-1.020)			
	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	126	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)			
	127	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)			
SV	128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
	129	RECORD: START FINISH MINUTES			
		V-343 8:40 AM 1:00 P 26.0			
		V-349 8:40 AM 12:30 P 23.0			
		TIME V-343 V-349 SV NORMAL			
		8:40 INCHES 55 INCHES 22 PH PH			
		AT 20 MIN 9:00(49) 51 (20) 9:12 9.3-10.0			
		40 MIN 9:20(45) 47 (18) 9:28 9.3-10.0			
		1 HR 9:40(41) 43 (16) 9:52 9.3-10.0			
		2 1/4 HR 10:55(25) 27 (8) 9:46 9.3-10.0			
		3 1/2 HR 12:10 9:41 (0) 9:43 9.3-10.0			
		FINISH 12:50 7.24 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	
385	130	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	131	DUMP IN & STIR TO DISSOLVE	530	15-A	530
302	132	ADD 42" (514 G) WATER TO V-302			
8	133	ADD & STIR 2 MIN	330	7-D	165
SV	134	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
9	135	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	136	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM			
	137	RECORD: START 1:05 PM			
	138	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	139	RECORD: PH 3.4 (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 GAL WATER TO 50# N-15-A. STIR SV 5 MIN AFTER EACH ADDITION			
	140	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN			
	141	RECORD: PH 6.6 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.3 ASSUME 77%	6	27-D	4
	142	DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%		7-D	
	143	SIPHON N-7-D INTO SV			
	144	POUR IN STIR 15 MIN	50	978-A	50
	145	STOP AGITATOR			
		START 11:00 AM 7:20 A			
		FINISH 7:00 AM 2:50 PM			
		OPERATOR 54-409 225-244			