CG 04 CODE KO-786-D PKG PROCESSES APPROVED BY

DEC 17 80 38294

EST'D WGT 862 LBS ( ) KO-786-D (P) FWP 11/20/80

( ) ( )

STANDARD HRS. 10.5 TIME M ( ) ( )

( ) ( )

JOB NAME: 04KO786DMP

01

CG	CODE	PQ	LOT	LBS
01	YC010B	93	37277	3000
01	YC010B	93	36212	~~500~~ 450
01	YC010B	93	36557	~~600~~ 650

DEC 18 1980

Homog #2

TOTAL EST'D WGT 4962 REQ. NO.( ) NON-BLEEDING

EQUIP		NAME : "KROLOR" ORANGE R	USE LBS	NCODE	ACCT LBS
211 & 208	1	RUN 60"(990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15
	2	WEIGH IN DRUM AND POUR IN	280	983-D	280
	3	DUMP IN AND STIR 5 MIN LOT	82X50	YC10B	4100
		RECORD: START 3:A.M. 37277	3000		
1		FIN 4:30A.M. 36212	450		
		36557	650		
	4	ADJUST TO 75" (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208			
	6	WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208			
	7	RECORD:V-208 VOL. 51 " & ADJUST TO 50"(1840G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 15" (771 G) WATER INTO V-247 START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:30 P TOTAL MINUTES 140			
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 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	2450	983-D	2450
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17	RECORD DENSITY: 1.0797 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.8 & ADJ TO 10.4-10.8 USING N-7-D			
4		DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	____	7-D	____
		SIPHON N-7-D INTO SV & RECORD: PH ____			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT 192 *F & RECORD: 192 *F			

PUNCHED & CHECKED

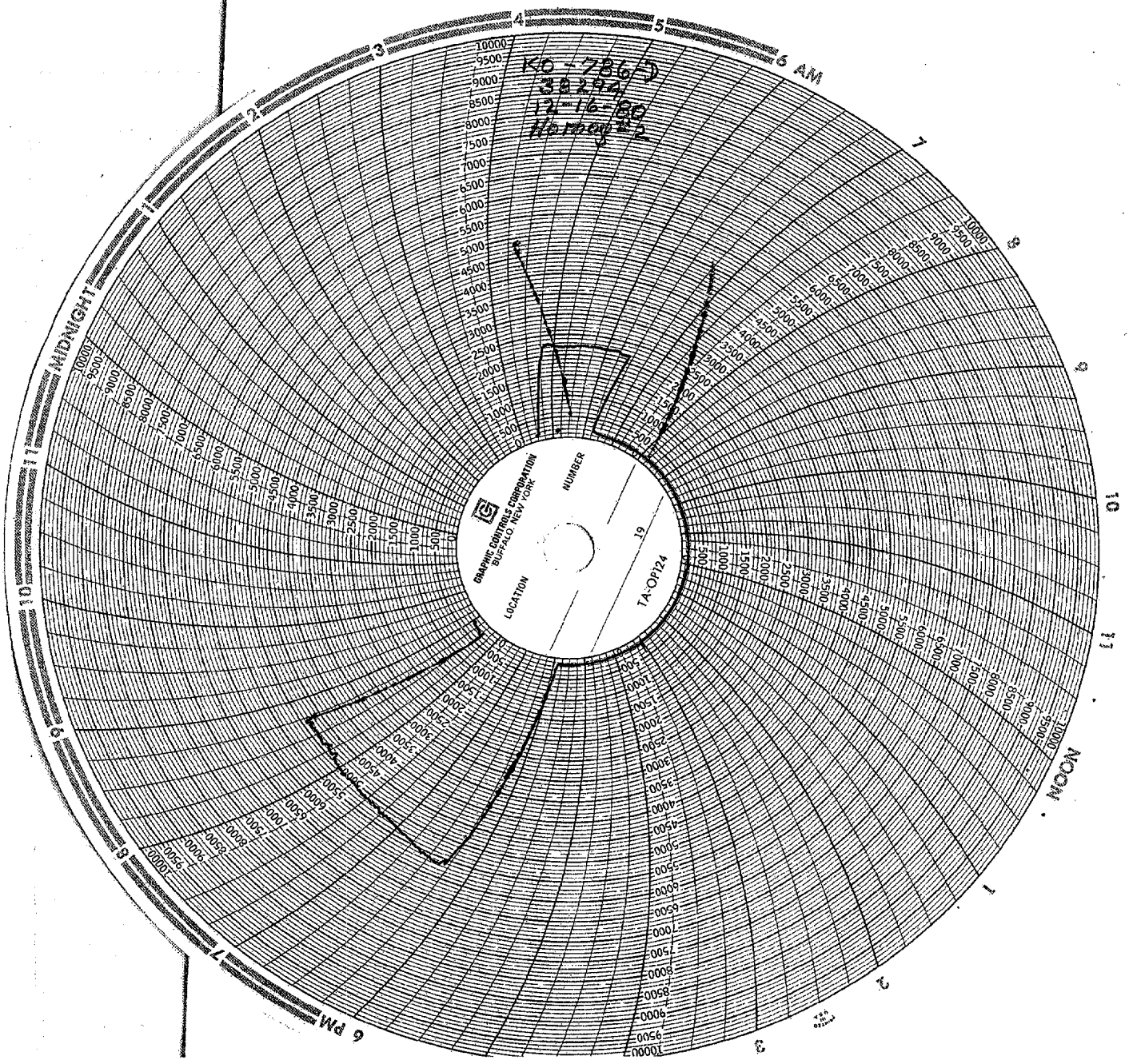
N34555

EQUIP		PAGE 2 CG 04 KO 100 D EST WGT 4/02# V-247	LBS	CODE	LBS
343 & 386 5	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
	22	METER IN FROM V-386 M____, 9.69 #/GAL, 36.6 GAL	_____	27-D	355
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.020 G/ML (1.018-1.020)			
SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0			
	26	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 66 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 10.00 P / 1:50A / 230 V-349 ____ / 1:05A / 185			
		TIME / V-343 INCHES / V-349 INCHES / SV PH / NORMAL PH AT 20 MIN 1020P (47)___ (20)___ 9.6 (9.3-10.0) 40 MIN 1040P (43)___ (17)___ 9.6 (9.3-10.0) 1 HR 1100P (38) + (15)___ 9.6 (9.3-10.0) 2 HR 1200A (24) 25 (7) + 9.6 (9.3-10.0) 3 HR 100A (10) 11 (0)___ 9.6 (9.3-10.0) FINISH 150A (0)___ 6.9 (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 7	30	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140*F			
	31	DUMP IN & STIR TO DISSOLVE	300	15-A	300
302 8	32	ADD 42" (514 G) WATER TO V-302			
	33	ADD & STIR 2 MIN	150	7-D	75
SV 9	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	36	TURN OFF STEAM			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH 3.3 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & 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			
	39	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	40	RECORD: PH 3.8 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.2 ASSUME 77%	_____	27-D	_____
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	24	7-D	12
		SIPHON N-7-D INTO SV			
	41	STOP AGITATOR			

START	FINISH	OPERATOR
4:30A	7:00A	235
300P	1100P	259/20
11:00P	3:00AM	235 - 37

Sample when silica all in

DUP050104405



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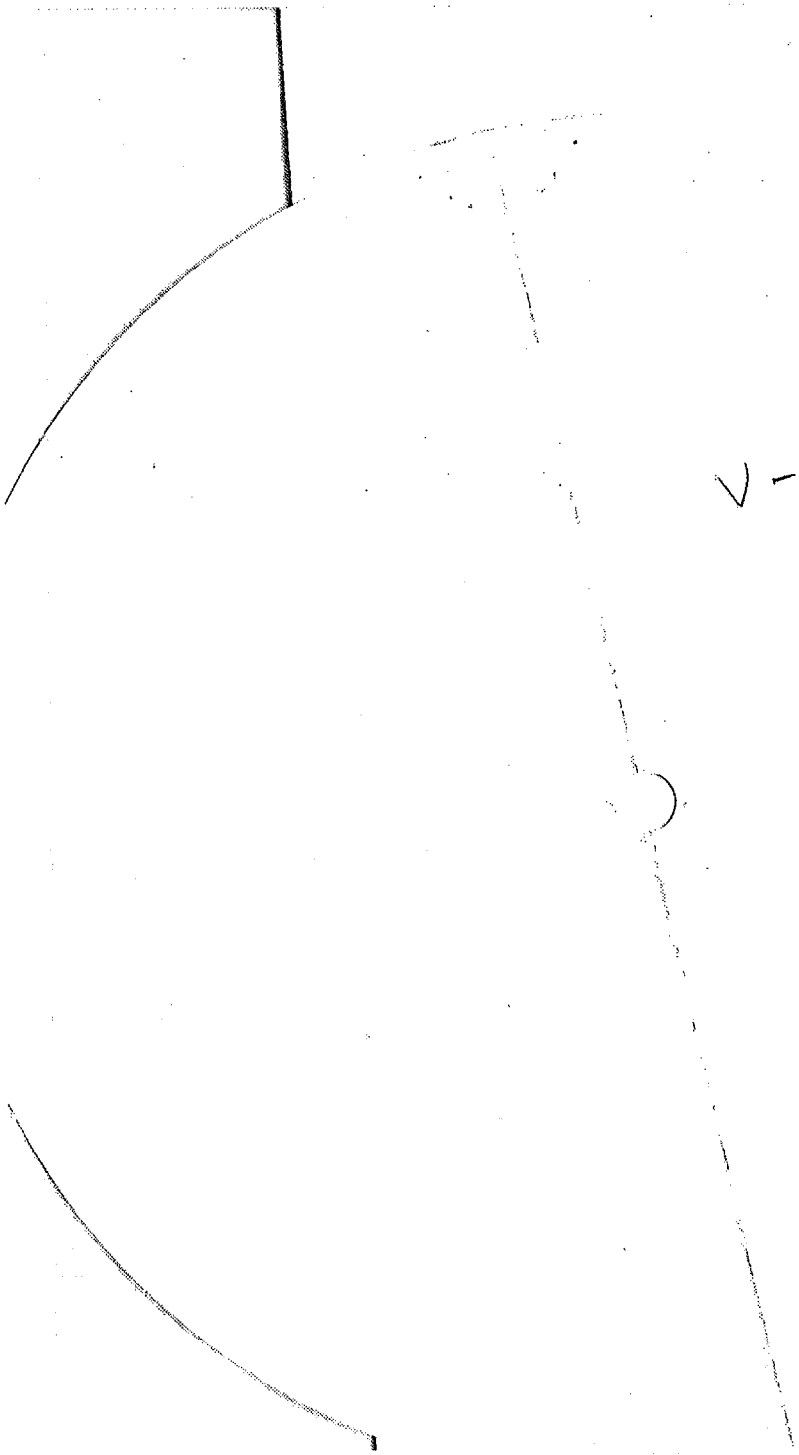
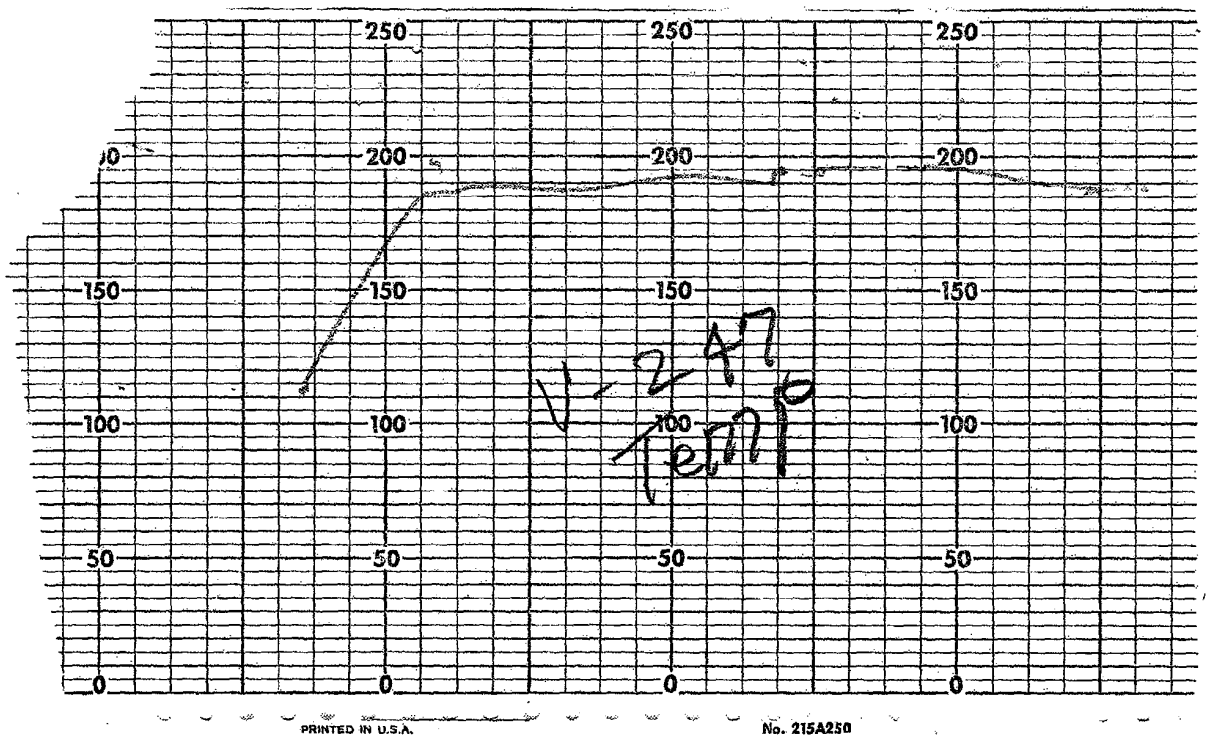

V-247



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