

CG 04 CODE KD-789-D PKG
 EST'D WGT 1032 LBS

PROCESSES APPROVED BY
 () KD-789-D (I) FWP 11/3/80

STANDARD HRS. 10.8 TIME 11 AM

TYPED BY: FWP 11/3/80

CG CODE PQ LOT LBS
 01 YC016B 93 371667 200
 01 YC016B 93 37335 3100
 01 YC016B 93 37337 900

4 BAGS TO DUMP

TOTAL EST'D WGT 5232

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
241 & 208	RUN 60" (990 G) WATER IN V-241. SET AGITATOR ON HIGH SPEED.			
1	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN RECORD: START <u>12:30 PM</u> <u>37337</u> FIN <u>3:30 PM</u> <u>37338</u> <u>37667</u>	530 84X50 <u>900</u> <u>3100</u> <u>200</u>	983-D YC16B	530 4200
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 HOT WATER AT 2800-3200 PSI INTO V-208			
7	RECORD: V-208 VOL. <u>90</u> " & ADJUST TO 54" (1890G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	RUN 10" (514 G) WATER INTO V- <u>247</u> , START AGITATOR & INSTALL TEMP CHART			
2	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>2:30 A</u> TOTAL MINUTES <u>140</u>			
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	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
3	WEIGH INTO V-384 & PUMP TO V-349 RUN 1000# WATER INTO V-384 & PUMP TO V-349 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN RECORD DENSITY: <u>1.084</u> G/ML (1.082-1.086)	2545	983-D	2545
SV	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
4	RECORD: PH <u>10.3</u> & ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	<u>28</u>	7-D	<u>14</u>
	SIPHON N-7-D INTO SV & RECORD: PH <u>11.2</u>			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>100</u> °F & RECORD: <u>110</u> °F NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34633

EQUIP

PAGE 2 CG 04 KO-789-D EST WGT 5232#

USE
LBSN-
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LBS

V-247

421 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO
343 V-343
& 422 METER IN FROM V-386 M 68, 883% / GAL 44.2 GAL
386 423 STIR 15 MIN OR LONGER
5 424 RECORD: DENSITY 1.012 G/ML (1.018-1.020)

425 WHEN S 20 HEATING COMPLETE, RECORD: PH 9.8
426 SET V-343 ACID PUMP AT 65 SETTING (255 MIN)
427 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)
428 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE
429 RECORD: START FINISH MINUTES
V-343 5:00 PM 2:55
V-349 12:15 2:50 PM 2:10
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 12:25 (49) 49 (20) 20 9.6 (9.3-10.0)
40 MIN 13:15 (45) 45 (18) 18 9.6 (9.3-10.0)
1 HR 1:25 (41) 41 (16) 16 9.6 (9.3-10.0)
2 1/4 HR 2:20 (25) 25 (8) 8 9.6 (9.3-10.0)
3 1/2 HR 3:30 (9) 9 (0) 0 9.6 (9.3-10.0)
FINISH 4:20 (0) 0 6.0 (7.5-8.5)
NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP
PUMPS & SEE SUPV. IF FINAL PH IS ABOVE
9.5, ADJ TO 7.5-8.5 & RECORD: PH
ASSUME 77%

385 430 RUN 40" (308 G) WATER INTO V-385 & HEAT TO
7 135-140°F
431 DUMP IN & STIR TO DISSOLVE 530 15-A 530

302 432 ADD 42" (514 G) WATER TO V-302
8 433 ADD & STIR 2 MIN 330 7-D 165

SV 434 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
9 435 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
436 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
RECORD: START 5:00 PM
437 RUN IN V-385 FROM S 31 & STIR 5 MIN
438 RECORD: PH 3.0 (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
439 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5
MIN
440 RECORD: PH 4.6 (6.2-6.4) & IF NECESSARY ADJ TO
PH 6.2-6.4. RECORD: PH 6.2 ASSUME 77%
DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 18 27-D
SIPHON N-7-D INTO SV 7-D 9
441 POUR IN STIR 15 MIN 50 978-A 50
442 STOP AGITATOR

START

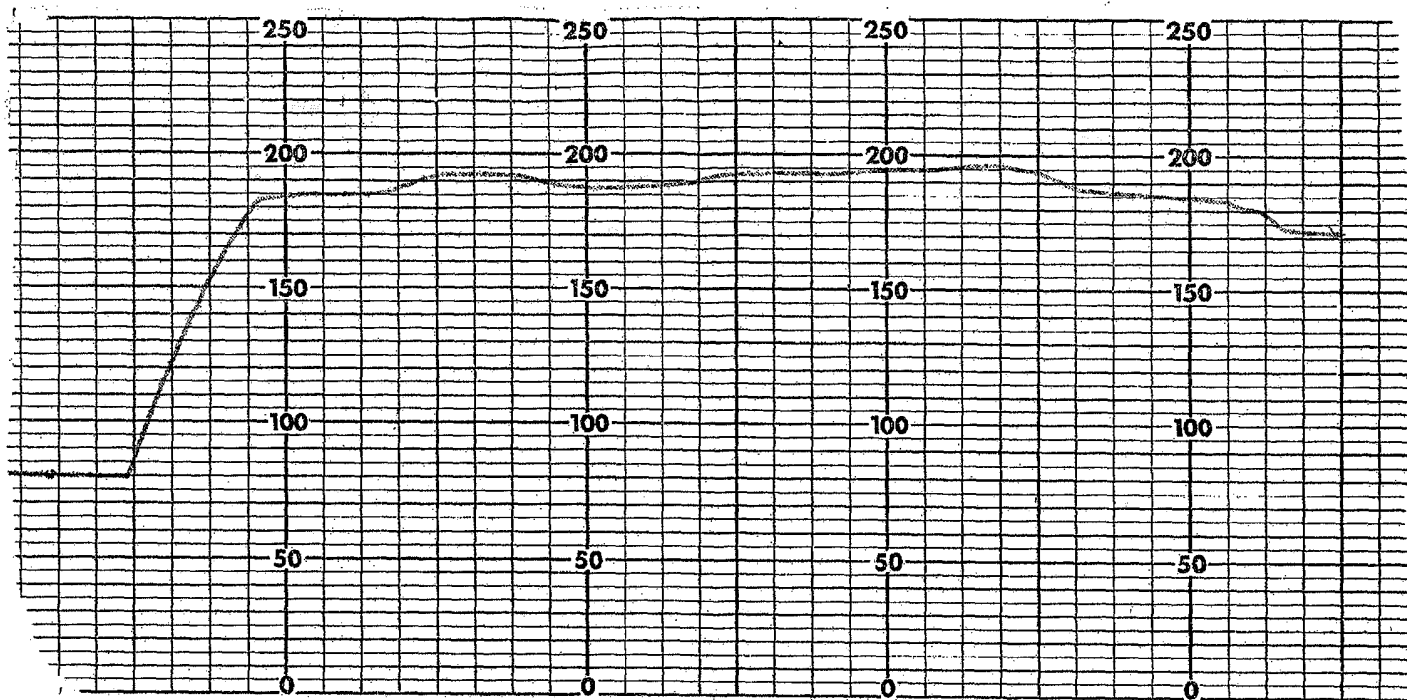
FINISH

OPERATOR

3:00 PM

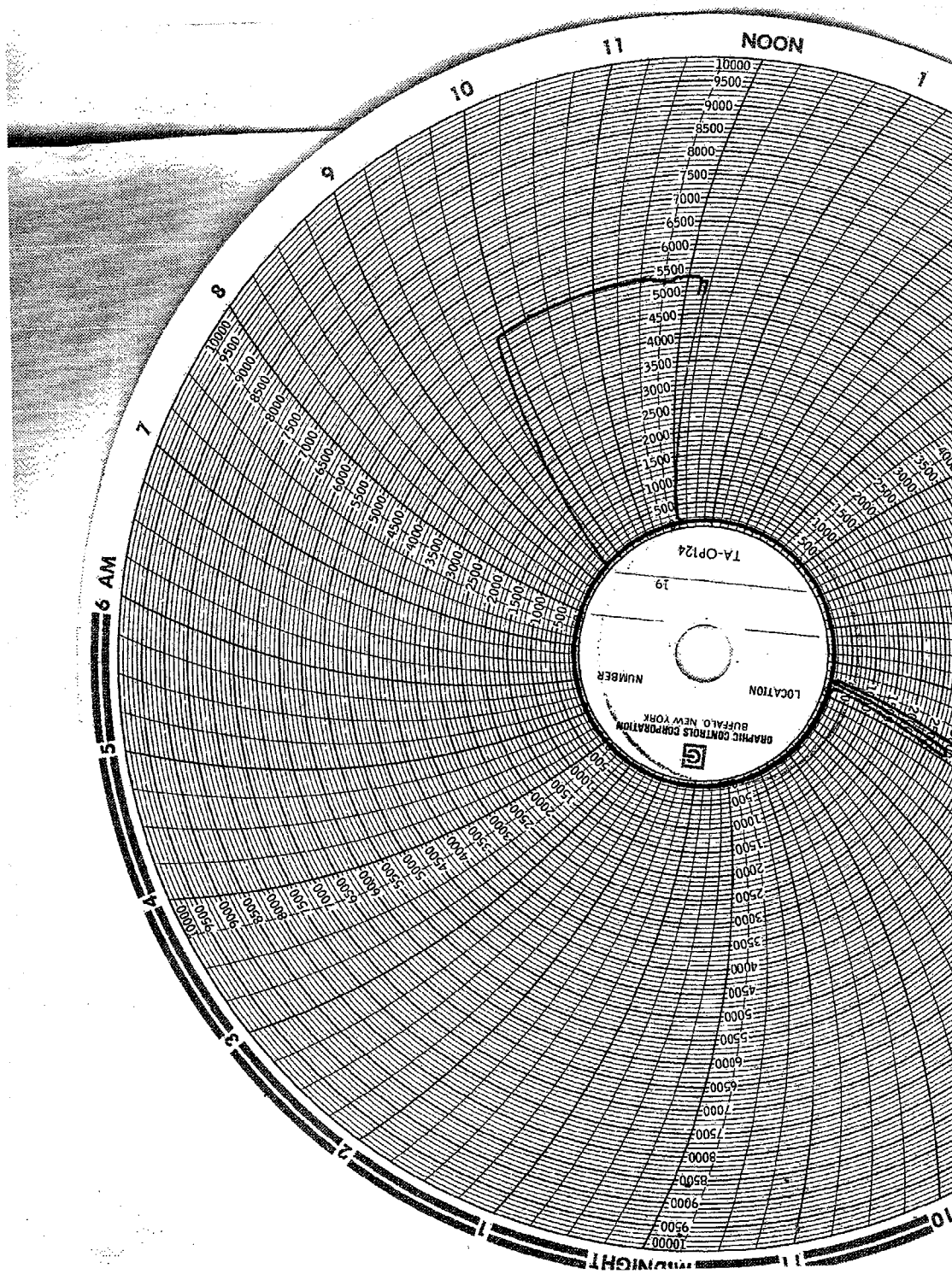
2:30 PM

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