CG 04 CODE KO-786-D PKG DEC 18 80 38321 PROCESSES APPROVED BY

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

STANDARD HRS. 10.5 TIME M ( ) ( ) ( ) ( ) ( ) ( ) OK/FP

JOB NAME: 04KO786DMP

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36258	3300
01	YC010B	93	37266	~~2500~~ 800
01	YC010B	93		

DEC 19 1980

PUNCHED & CHECKED DEC 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 2:05 AM 36258	3300		
1		FIN 3:45 AM 37266	800		
	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. 40 " & 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 11:15 Am TOTAL MINUTES 155			
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: 1.079 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.9 & 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 194 *F & RECORD: 194 *F			

N34557

DUP050104414

EQUIP		PAGE 2 CG 04 KU-788-D EST WGT 4762# V-247	USE LBS	R CODE	USE LBS
	21	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
343 & 386	22	METER IN FROM V-386 M 29 9.695/GAL 36.6 GAL		27-D	355
	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.019 G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
	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			
SV	29	RECORD: START FINISH MINUTES V-343 3.40 / V-349 3.7PM. 6.45PM 195 TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH AT 20 MIN 4:PM (47) + (20) + 9.5 (9.3-10.0) 40 MIN 4:20P (43) + (17) 17 9.5 (9.3-10.0) 1 HR 4:40P (38) 39 (15) 15 9.3 (9.3-10.0) 2 HR 5:40P (24) 25 (7) 8 9.5 (9.3-10.0) 3 HR 6:40P (10) 11 (0) ±5 9.6 (9.3-10.0) FINISH 7:25 (0) 7.2 (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	30	RUN 40" (308 G) WATER INTO V-385 & HEAT TO 135-140*F			
7	31	DUMP IN & STIR TO DISSOLVE	300	15-A	300
302	32	ADD 42" (514 G) WATER TO V-302			
8	33	ADD & STIR 2 MIN	150	7-D	75
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
9	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 3.7 (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 4.0 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH ___ ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
	41	STOP AGITATOR			

START	FINISH	OPERATOR
3:PM	7:50P	54-120

DUP050104415

S.V. ~~246~~, (247) C.V. D.V.

CG 04 CODE KO-786-D PKG

EST'D WGT 862 LBS DEC 23 80 38421

STANDARD HRS. 10.5 TIME M

PROCESSES
( ) KO-786-D (P)
( ) ( )
( ) ( )
( ) ( )
JOB NAME: 04KO786DMP

APPROVED BY
FWP 11/20/80

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36785	1750
01	YC010B	93	36789	1750
01	YC010B	93	~~3140~~ 36788	600

DEC 29 1980

1750
1750
3500
600
4100

12
5
600

PUNCHED & CHECKED
DEC 30 1980

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 2:30 P.M. 36789	1750		
1		FIN 4 Pm 36785	1750		
		36788 600	600		
	4	ADJUST TO 75" (1275 G)	4100		
	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. 48 " & 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 9:30 A TOTAL MINUTES 190			
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: 1.080 G/ML (1.078-1.081)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66"(3400 G)			
	19	RECORD: PH 10.7 & 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 ____*F & RECORD: ____*F			

(SKL)

DUP050104416

V-247

			LBS	CODE	LBS
343 & 386 5	21 22 23 24	WHILE HEATING SV, RUN 51* (1400 G) WATER INTO V-343 METER IN FROM V-386 M31,9642#/GAL 36.8 GAL STIR 15 MIN OR LONGER RECORD: DENSITY 1.018 G/ML (1.018-1.020)		27-D	355
SV	25 26 27 28 29	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9 SET V-343 ACID PUMP AT 72 SETTING (225 MIN) SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN) IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194*F DURING STRIKE RECORD: START FINISH MINUTES V-343 2:40 6:35 PM 235 V-349 2:10 PM. 5:15 PM 185 TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH AT 20 MIN 3:00 (47) 49 (20) — 9.5 (9.3-10.0) 40 MIN 3:30 (43) 43 (17) + 9.5 (9.3-10.0) 1 HR 3:40 (38) 40 (15) — 9.5 (9.3-10.0) 2 HR 4:40 (24) 26+ (7) + 9.5 (9.3-10.0) 3 HR 5:40 (10) 12 (0) + 9.5 (9.3-10.0) FINISH 6:35 (0) — 9.0 (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	
385 7	30 31	RUN 40* (308 G) WATER INTO V-385 & HEAT TO 135-140*F DUMP IN & STIR TO DISSOLVE	300	15-A	300
302 8	32 33	ADD 42* (514 G) WATER TO V-302 ADD & STIR 2 MIN	150	7-D	75
SV 9	34 35 36 37 38	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR TURN OFF STEAM RUN IN V-385 FROM S 31 & STIR 5 MIN RECORD: PH 3.4 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & 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		15-A	
	39 40	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN RECORD: PH 4.2 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH ___ ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%		7-D	
	41	SIPHON N-7-D INTO SV STOP AGITATOR			

START	FINISH	OPERATOR
2 AM	3 PM	SG
3:00P	7:30PM.	235

DUP050104417