

CG 04 CODE KD-789-D PKG
 EST'D WGT 1032 LBS
 STANDARD HRS. 10.8 TIME _____ M

PROCESSES
 () KD-789-D (1) FWP 11/20/86
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 JOB NAME: 04KD789-DMI

CG CODE PQ LOT LBS
 01 YC016B 93 37710 500
 01 YC016B 93 37673 3100
 01 YC016B 93 37619 500
 01 YC016B 93 72335 80

OK
 AP

will look yellow

TOTAL EST'D WGT 5232 5212 REQ. NO. () NON-BLEEDING

EQUIP	NAME	USE LBS	NCODE	ACCT LBS
211	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN	540	983-D	540
1	RECORD: START 9:30 AM FIN 11:45 AM	82X50 2x40	YC16B YC16B	4100 80
	ADJUST TO 75" (1275 G)			
	WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208			
	RECORD: V-208 VOL. 42" & ADJUST TO 54" (1890G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 10" (514 G) WATER INTO V-247. START AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV			
2	RECORD: TIME START 12:45 PM TOTAL MINUTES 190			
	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	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	WEIGH INTO V-384 & PUMP TO V-349	2600	983-D	2600
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	RECORD DENSITY: 1.0856 / ML (1.082-1.086)			
SV	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	RECORD: PH 10.7 & ADJ TO 11.1-11.3 USING N-7-D			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH 14.1	24	7-D	12
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____ °F			
	& RECORD: 194 °F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34618

V-247

343 121 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343
 & 122 METER IN FROM V-386 M.23, 9.677#/GAL 40.3 GAL 27-D 390
 386 123 STIR 15 MIN OR LONGER
 5 124 RECORD: DENSITY 1.020 G/ML (1.018-1.020)

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1
 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 5:15 9:40 2:25
 V-349 5:20 8:50 2:15

TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
AT 20 MIN 5:35	(49) 5.0	(20) 2.1	9.9	(9.3-10.0)
40 MIN 5:55	(45) 4.7	(18) 4	9.85	(9.3-10.0)
1 HR 6:15	(41) 4.3	(16) 8	9.8	(9.3-10.0)
2 1/4 HR 7:00	(25) 2.6	(8) 8	9.5	(9.3-10.0)
3 1/2 HR 8:25	(9) 1.0	(0) 0	9.4	(9.3-10.0)
FINISH 9:30	(0) -	(0) -	2.1	(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 9:10
 138 RUN IN V-385 FROM S 31 & STIR 5 MIN
 139 RECORD: PH 3.1 (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 6.4 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH ASSUME 77% 27-D
 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	FINISH	OPERATOR
12:45 PM	3:15 PM	54
3:00 P	4:00 PM	144-235
11 PM	1 AM	223-232

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