

CG 04 CODE K0789D
JUN 13 36109
EST'D WGT 1032 LBS

PKG

JUN 13 1980

PROCESSES

() K0789D

(I)

APPROVED BY

FWP 4/28/80

STANDARD HRS. 10.8 TIME 11:AM

TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	35920	3250
01	YC016B	93	29930	650
01	YC016B	93	34186	300

(04 K0909D 32769 98 356#)

Note: Re-work at end of strike. (5-29)

TOTAL EST'D WGT 5232 5421

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE		ACCT
		LBS	NCODE	
1	RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
2	WEIGH IN DRUM AND POUR IN	530	32-D	530
3	DUMP IN AND STIR 5 MINS. LOT	84X50	YC16B	4200
	RECORD: START 8:AM 35920	3250		
	FIN 10:AM 29930	650		
		34186		
4	ADJUST TO 75" (1275 G)	200		
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 OF HOT WATER AT 2800-3200 PSI INTO V-208			
7	RECORD: V-208 VOL 4.2" & ADJUST TO 54" (1890G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
9	RUN 10" (514 G) WATER INTO V-245 & START			
10	AGITATOR & INSTALL TEMP CHART			
11	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 11:22AM TOTAL MINUTES 13.5			
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	WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
143	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F	2545	32-D	2545
384	WEIGH INTO V-384 & PUMP TO V-349			
115	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
117	RECORD DENSITY: 10.82 G/ML (1.082-1.086)			
118	WHEN 10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
119	RECORD: PH 10.4 & ADJ TO 11.1-11.3 USING N-7-D			
	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	24	7-D	12
	SIPHON N-7-D INTO SV & RECORD: PH 11.2			
120	HEAT TO 190-194°F IN 55-65 MIN & RECORD: HT 192°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N32358

V-245

21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343
22 METER IN FROM V-386 M 10.86 GAL 35.9 GAL 27-D 390
23 STIR 15 MIN OR LONGER
24 RECORD: DENSITY 1.018 GM/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
26 SET V-343 ACID PUMP AT 65 SETTING (255 MIN)
27 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)
28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE.

29 RECORD: START FINISH MINUTES
V-343 3:25 P.M. 8:00 P.M. 275
V-349 3:25 P.M. 11:00 P.M. 215
TIME V-343 V-349 SV NORMAL
INCHES INCHES PH PH
AT 20 MIN 3.45 (49) 4.9 (20) 20 9.9 (9.3-10.0)
40 MIN 4.05 (45) 4.5 (18) 18 9.9 (9.3-10.0)
1 HR 4.25 (41) 4.1 (16) 16 9.9 (9.3-10.0)
2 1/4 HR 5.40 (25) 2.5 (8) 9 9.9 (9.3-10.0)
3 1/2 HR 6.50 (9) 9 (0) 1.1 9.75 (9.3-10.0)
FINISH 11:00 (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

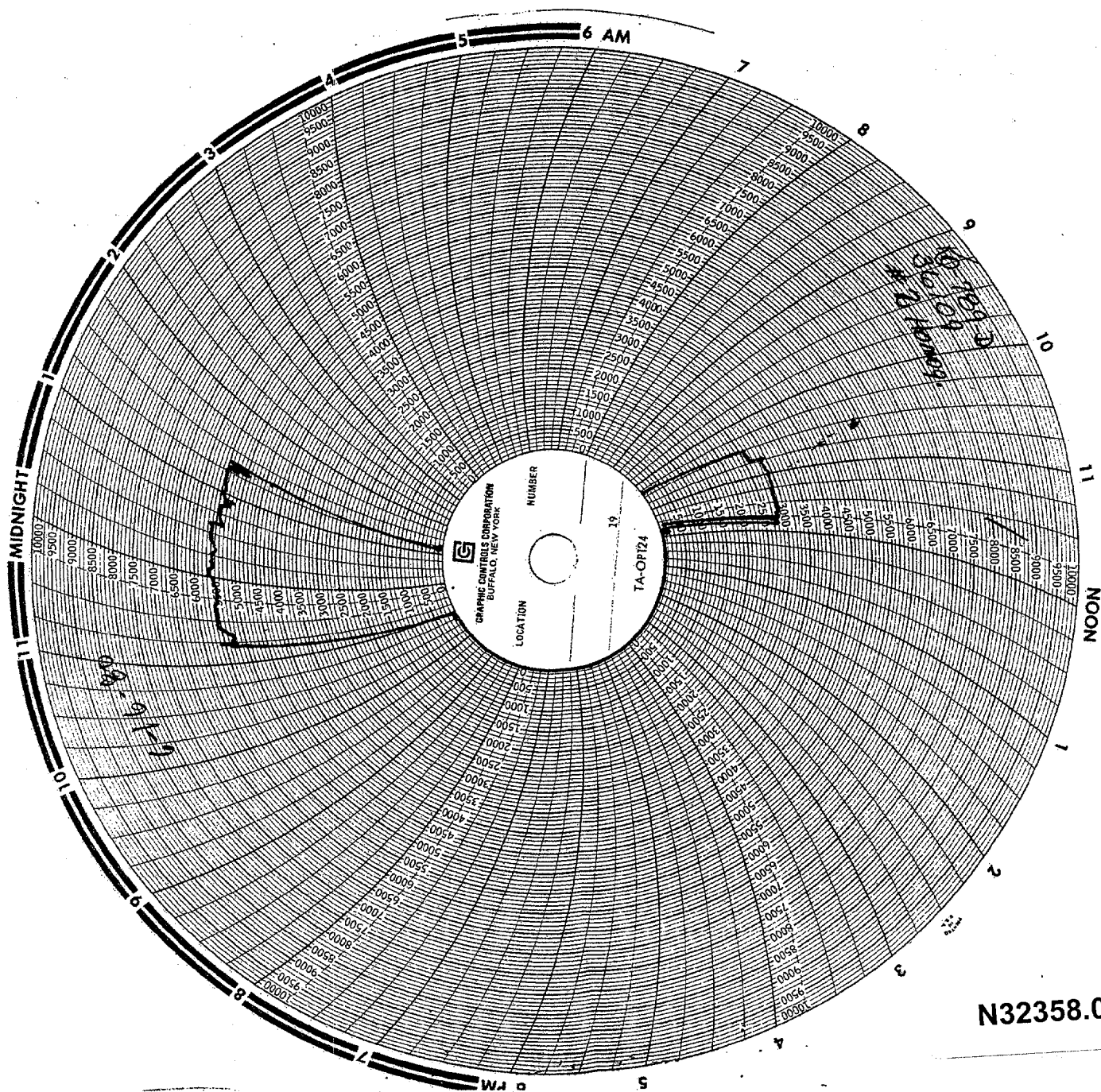
29A Dump in one drum KO-909-D, 32769 (DC=530%) 400 27-D 400
385 RUN 38" (238 G) WATER INTO V-343 & HEAT TO 135-140°F 385
31 BUMP IN & STIR TO DISSOLVE 530 15-A 530

32 ADD 92" (514 G) WATER TO V-302
33 ADD & STIR 2 MIN 330 7-D 165

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 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
37 RECORD: START 8:00 P.M.
38 RUN IN V-386 FROM S 31 & STIR 5 MIN
39 RECORD: PH 3.7 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH 3.7
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 10-12 MIN & STIR 5 MIN
40 RECORD: PH 6.3 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4 & RECORD: PH 6.3 ASSUME 77%
DELUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%
41 SYPHON N-7-D INTO SV
42 FOUR IN STIR 15 MIN
43 STOP AGITATOR

START FINISH OPERATOR
6-16-80 7:00 P.M. 3:00 P.M. 235-323
3:00 P.M. 10:00 P.M. 201-381



N32358.01

DUP050457690

V-245