DEC 19 80 38329

EST'D WGT 862 LBS

STANDARD HRS. 10.5 TIME M

( ) KO-786-D (P) FWP 11/20/80

JOB NAME: 04KO786DMP

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36261	3600
01	YC010B	93	37266	500 X
01	YC010B	93		

72
-29
43

DEC 22 1980

29 BAGS, Dumping MORE to go.

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 134m. 37266 (10x50)			
1		FIN 420PM 36261 (43x50)			
	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. 47 " & 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 1145 TOTAL MINUTES 150			
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 10.6 & 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			

PUNCHED & CHECKED DEC 3 1980

N34556

V-247

CKOUT			LBS	CODE	LBS
	24	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO			
343		V-343			
&	22	METER IN FROM V-386 M 30.77/GAL 36.7 GAL	_____	27-D	355
386	28	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 10.20 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			
SV		AT 190-194*F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 3:40 1:30PM 230			
		V-349 3:40PM 6:42PM 182			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 4:00 (47)___ (20)___ 9.5 (9.3-10.0)			
		40 MIN 4:20 (43)___ (17)___ 9.6 (9.3-10.0)			
		1 HR 4:40 (38)___ (15)___ 9.6 (9.3-10.0)			
		2 HR 5:40 (24)+ (7)+ 9.6 (9.3-10.0)			
		3 HR 6:40 (10)___ (0)= 9.7 (9.3-10.0)			
		FINISH 7:25 (0)___ 6.5 (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			
7		135-140*F			
	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 3.3 (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 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
11:00P 3:PM	7:00AM 10:00AM	335-327 54-307
_____	_____	_____

DUP050104410

MANUAL / S.V. 246 (247) C.V. MIXING INSTRUCTIONS - BATCH SIZE / D.V.

CG 04 CODE KO-786-D PKG DEC 19 80 38329 280 255 63⁵ OK

EST'D WGT 862 LBS

STANDARD HRS. 10.5 TIME M

PROCESSES
( ) KO-786-D (P)
( ) ( )
( ) ( )
( ) ( )

APPROVED BY FWP 11/20/80

JOB NAME: 04KO786DMP

CG	CODE	PQ	LOT	LBS
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01	YC010B	93	37266	500 X
01	YC010B	93		

22 − 19 = 3

DEC 22 1980

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	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 1145 TOTAL MINUTES 45			
2		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
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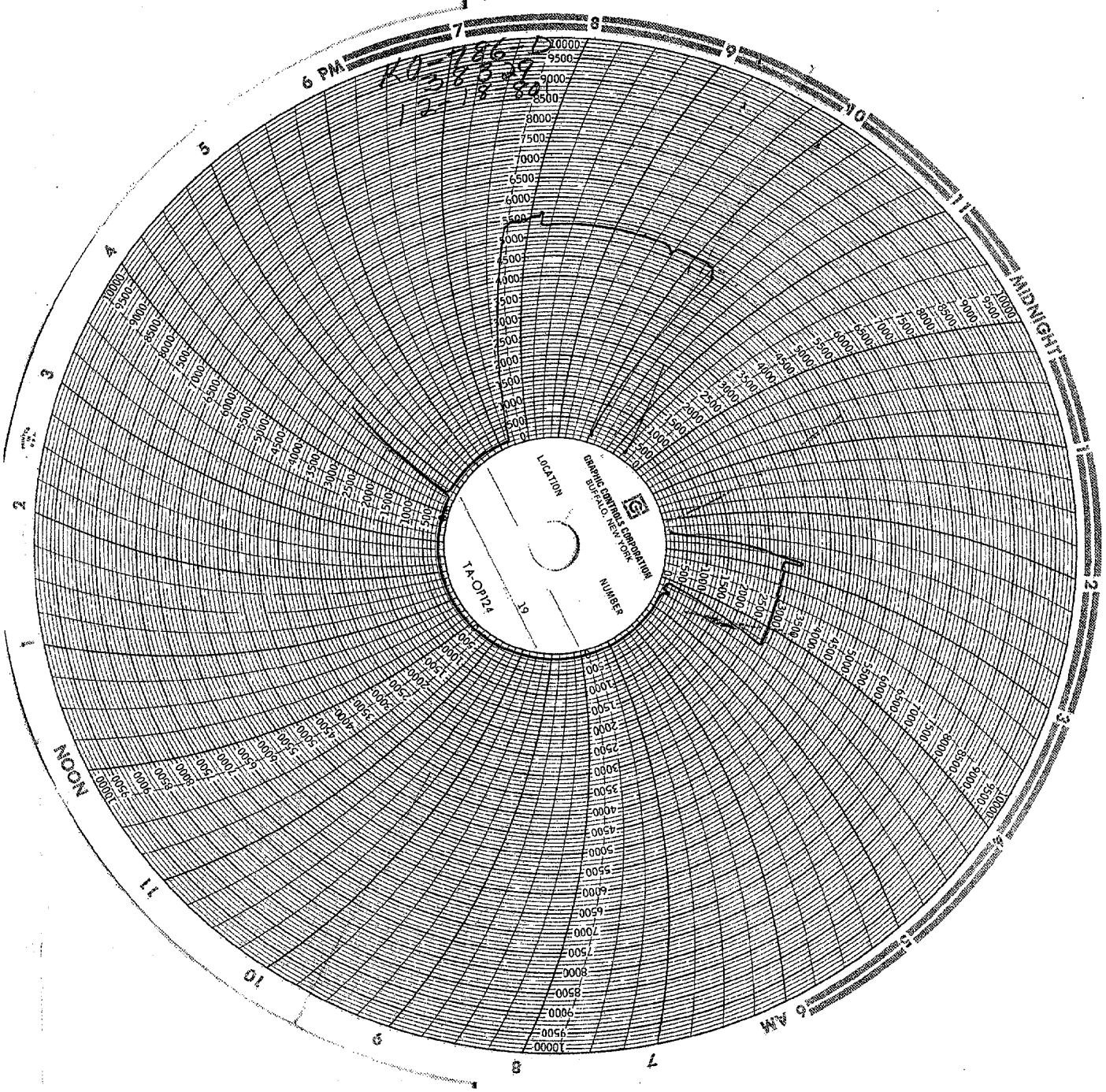
	19	RECORD: PH blue & ADJ TO 10.4-10.8 USING N-7-D			
4		DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	____	7-D	____
		SIPHON N-7-D INTO SV & RECORD: PH ____			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT ____*F & RECORD: ____*F			

PUNCHED & CHECKED DEC 2 1980

DUP050104411



DUP050104412

DUP050104413

