

CG 04 CODE K0786-D 38380

EST'D WGT 862 LBS

STANDARD HRS. 10.5 TIME 11:4 M

PROCESSING () K0-786-D (P) FWP 11/20/80

JOB NAME: 04K0786DMP

CG	CODE	PQ	LOT	LBS
01	YC010B	93	36786	3300
01	YC010B	93	36787	800
01	YC010B	93		

DEC 22 1980
none - up 12-19-80

(AM)

(2)

TOTAL EST'D WGT 4962

REQ. NO. ()

PUMPING

NON-BLEEDING

EQUIP	NAME	USE	LBS	NCODE	ACCT LBS
	NAME: "KROLOR" ORANGE R				
211	RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED	30	7-D	15	
208	WEIGH IN DRUM AND POUR IN DUMP IN AND STIR 5 MIN	280	983-D	280	
	RECORD: START <u>6:30 P</u> LOT <u>36786</u> FIN <u>8:00 P</u> <u>36787</u>	82X50	YC10B	4100	
	ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 1800-2200 PSI INTO V-208 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI INTO V-208 RECORD: V-208 VOL. <u>40</u> & ADJUST TO 50" (1840G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY				
208	RUN 15" (771 G) WATER INTO V-247, START AGITATOR & INSTALL TEMP CHART				
SV	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>5:45 PM</u> TOTAL MINUTES <u>180</u> 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				
&	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F				
384	WEIGH INTO V-384 & PUMP TO V-349	2450	983-D	2450	
	RUN 1000# WATER INTO V-384 & PUMP TO V-349				
3	ADJ V-349 TO 22" (1040 G) & STIR 15 MIN				
	RECORD DENSITY: <u>1.079 G/ML</u> (1.078-1.081)				
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)				
	RECORD: PH <u>10.8</u> & ADJ TO 10.4-10.8 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH <u>10.2</u>		7-D		
4	HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>192</u> *F & RECORD: <u>192</u> *F				

(M)

N34563

343	121	WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343			
& 386	122	METER IN FROM V-386 M.31, 2.612#/GAL, 368 GAL		27-D	355
5	123	STIR 15 MIN OR LONGER			
	124	RECORD: DENSITY 1.019 G/ML (1.018-1.020)			

SV	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 7.0			
	126	SET V-343 ACID PUMP AT 72 SETTING (225 MIN)			
	127	SET V-349 SILICATE PUMP AT 66 SETTING (180 MIN)			
	128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
	129	RECORD: START FINISH MINUTES			
		V-343 11:15 3:10 135			
		V-349 11:15 2:20 185			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN 11:35 (47) (20) 9.6 (9.3-10.0)			
		40 MIN 11:53 (43) (17) 9.6 (9.3-10.0)			
		1 HR 12:13 (38) (15) 9.6 (9.3-10.0)			
		2 HR 1:13 (24) (7) 9.6 (9.3-10.0)			
		3 HR 2:13 (10) (0) 9.6 (9.3-10.0)			
		FINISH 3:10 (0) 6.7 (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	300	15-A	300

302	132	ADD 42" (514 G) WATER TO V-302			
8	133	ADD & STIR 2 MIN	150	7-D	75

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	TURN OFF STEAM			
	137	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	138	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			
	139	RUN IN N-7-D FROM S 33 IN 4-6 MIN & STIR 5 MIN			
	140	RECORD: PH 3.7 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH 4.1		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%		7-D	12
		SIPHON N-7-D INTO SV			
	141	STOP AGITATOR			

START	FINISH	OPERATOR
11 PM	4 A	720

MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE KO-786 LOT 38208

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
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2490	1	T-174		
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2400	1	T-211		
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TOTAL NET WT. 4890 PKG. N-CODE _____

PROD. SPVR. _____

DATE _____

WHSE. OPER. _____

STUMP LUMP 4959

12/13/82