10/6/82 (DATE) K2J51 (LOT) 5179* (EST WGT) 11.1 Proy 8/18
( ) KO-789-D (I) FWP 07/28/82
COMTYP JOB NAME: 04K0789DMI
WAREHOUSE REQUEST NO. 10988

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	01	YC016B	98	E2E01	250	100.00	5	50	250	250
	01	YC016B	98	E2E04	250	100.00	5	50	250	250
	01	YC016B	93	J2K78	3100	100.00	62	50	3100	3100
	01	YC016B	93	J2K76	600	100.00	12	50	600	600
	01	YC016B	93			100.00		50		
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EQUIP		NAME : "KROLOR" ORANGE Y NON-BLEEDING	USE LBS	NCODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
211 & 208	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 MIN LOT	84X50	YC16B	4200
1		RECORD: START 2:30 AM			
		FIN 5:00 AM			
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	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 HOT WATER AT 2800-3200 PSI INTO V-208			
	7	RECORD: V-208 VOL 56 " & ADJUST TO 54"(1890G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & 2	9	RUN 10" (514 G) WATER INTO V-246, START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 6:50 AM TOTAL MINUTES 165			
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	2545	32-D	2545
	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 1.084 G/ML (1.082-1.086)			
SV	18	WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45"(2300 G)			
	19	RECORD: PH 10.1 & ADJ TO 11.1-11.3 USING N-7-D			
4		AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	26	7-D	13
		SIPHON N-7-D INTO SV & RECORD: PH 11.3			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC: HT 194 *F & RECORD: 194 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

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EQUIPMENT		PAGE 2 CG 04 KO-789-D V-246	USE LBS	N-CODE	ACCT LBS
	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
343 &	22	METER IN FROM V-386 M25 11.145/GAL 35.0 GAL	_____	27-D	390
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY 1.019 G/ML (1.018-1.020)			
		NOTE: THIS PROCESS CALLS FOR N-27-D ON SURFACE. BE SURE THAT HOSE IS NOT IN UNDERSURFACE STRIKE LINE.			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1			
	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			
SV 6	29	RECORD: START FINISH MINUTES V-343 10/10 _____ _____ V-349 1 PM _____ _____			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH AT 20 MIN 10:30 (49) 52 (20) 20 10.0 (9.3-10.0) 40 MIN 10:50 (45) 48 (18) 18 10.0 (9.3-10.0) 1 HR 11:10 (41) 45 (16) 16 10.0 (9.3-10.0) 2 1/4 HR 12:25 (25) 37 (8) 9 9.9 (9.3-10.0) 3 1/2 HR 1:40 (9) 16 (0) 1 9.9 (9.3-10.0) FINISH 2:25 (0) ___ 7.5 (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	ADD 67" (514 G) WATER TO V-385			
7	31	ADD & STIR 2 MIN 2D	330	7-D	165
SV	32	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
8	33	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	34	STIR 30 MIN AT 190-194*F, THEN TURN OFF STEAM RECORD: START 3:40			
	35	RUN IN ALUM USING BADGER METER	1060	115-A	530
	36	FLUSH ALM LINE WITH WATER			
	37	RECORD: PH 3.4 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH____ NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%	_____	115-A	_____
	38	RUN IN N-7-D FROM S31 IN 10-12 MIN & STIR 5 MIN			
	39	RECORD: PH 4.4 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH 6.3 ASSUME 77%	_____	27-D	_____
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	70	7-D	35
		SIPHON N-7-D INTO SV			
	40	POUR IN STIR 15 MIN	50	978-A	50
	41	STOP AGITATOR			

START	FINISH	OPERATOR
7:00 AM	3:00 PM	320
5:P.M.	11:P.M.	54-301
11:00 PM	2:30A	438-409

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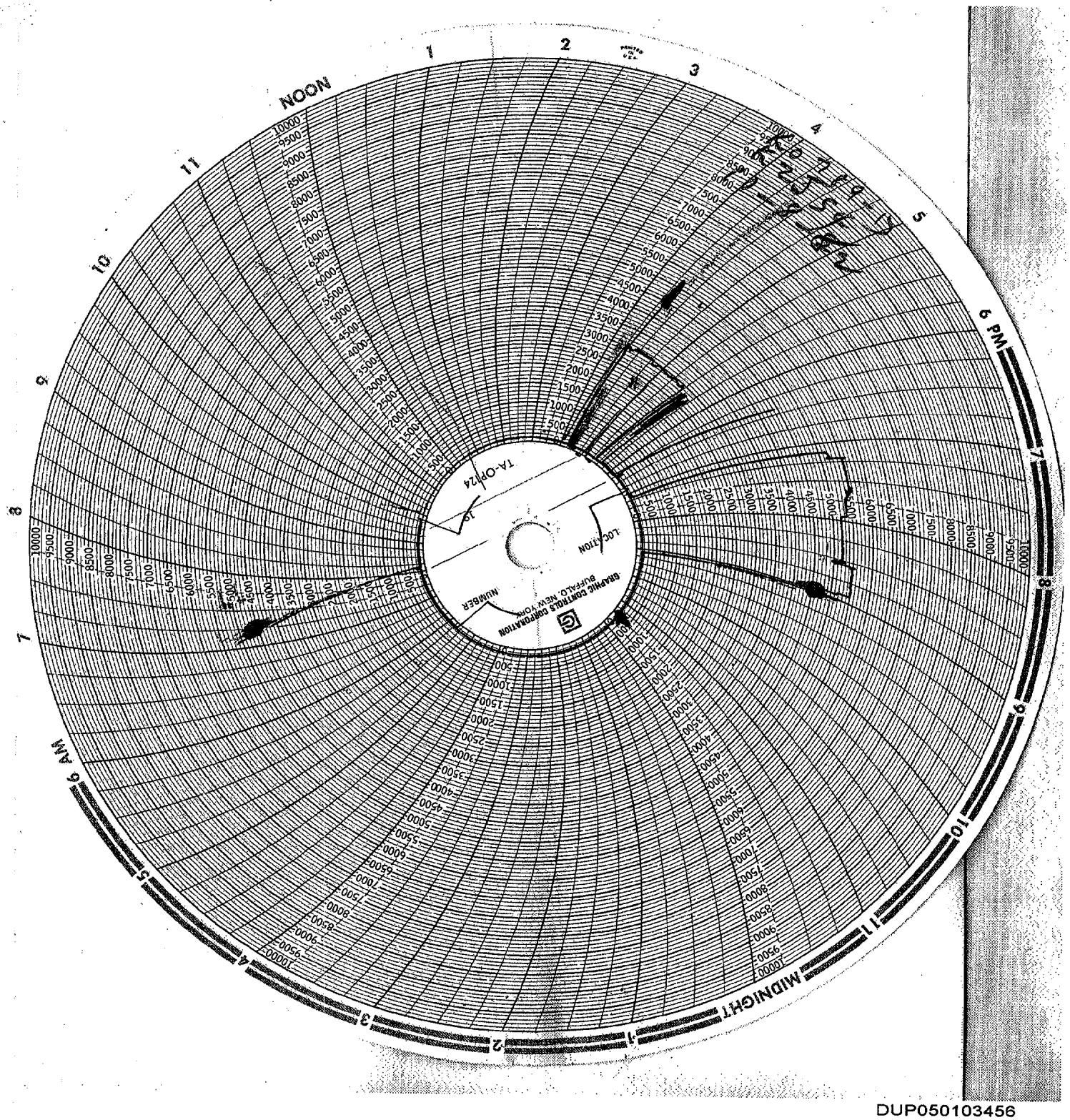

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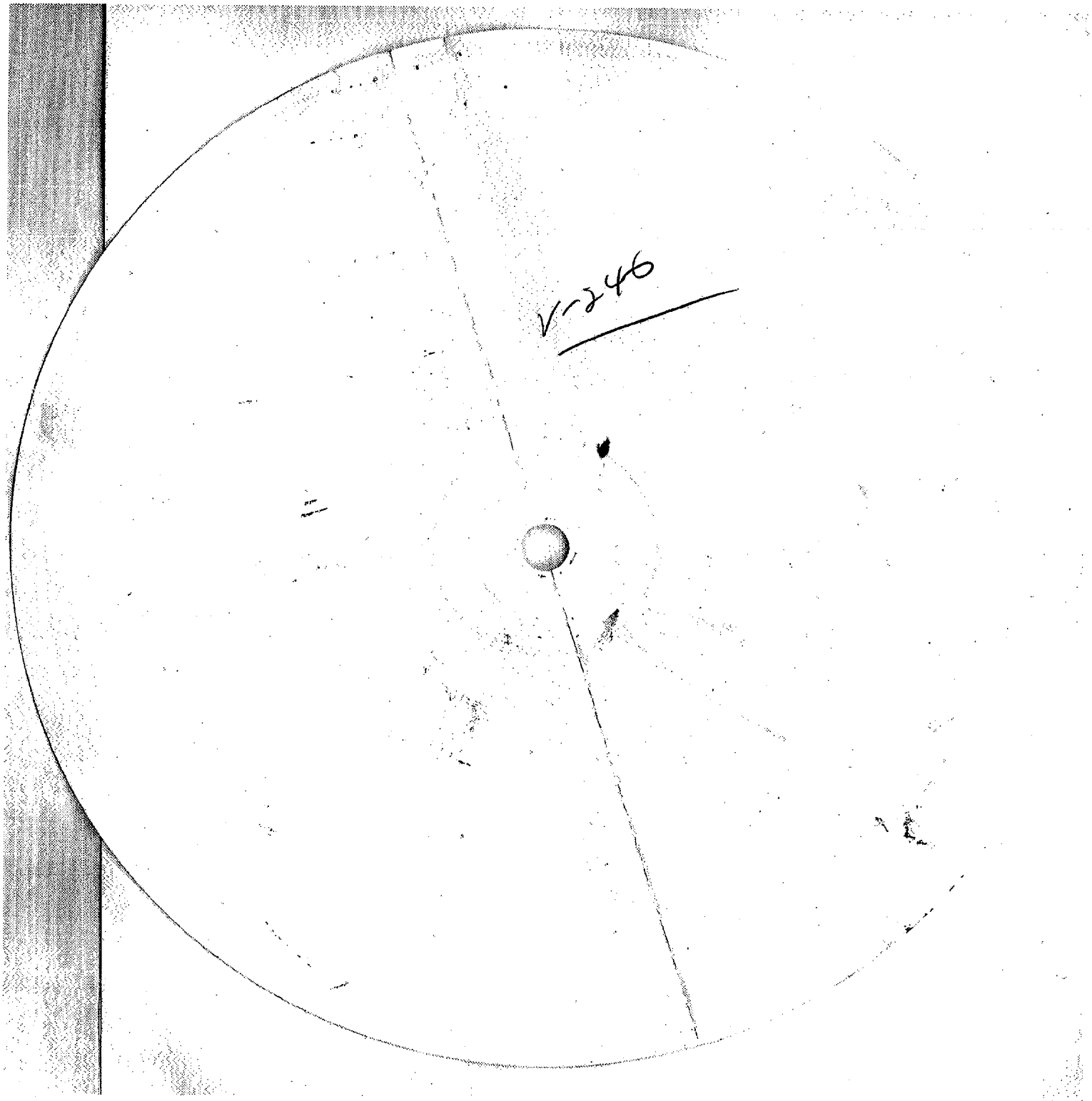
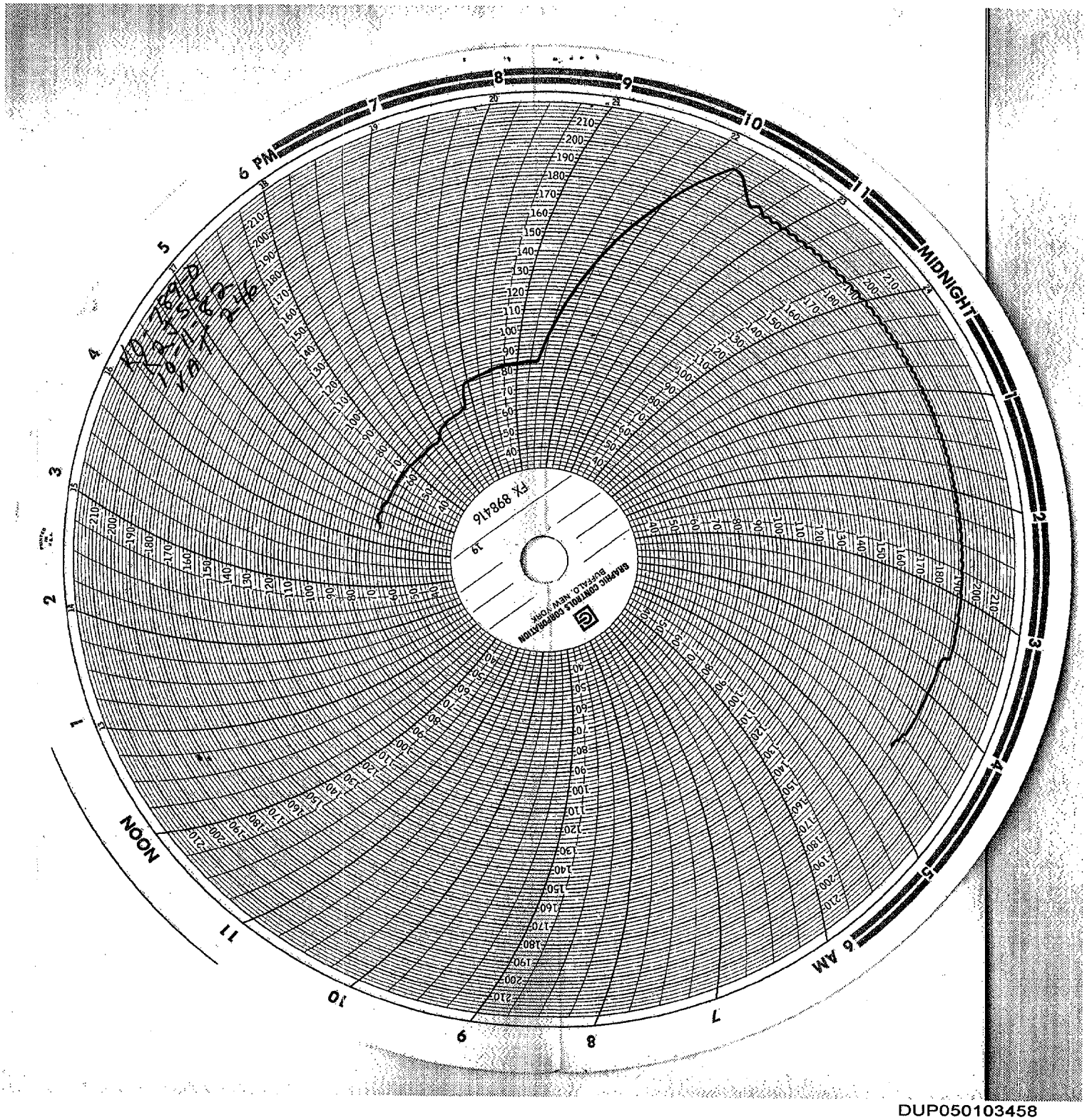

V-246



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