

EST'D WGT 862 LBS

DEC 15 80 38255

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

STANDARD HRS. 10.5 TIME

M

JOB NAME: 04K0786DMP

| CG | CODE   | PR | LOT   | LBS  |
|----|--------|----|-------|------|
| 01 | YC010B | 93 | 36736 | 3300 |
| 01 | YC010B | 93 | 36675 | 800  |
| 01 | YC010B | 93 |       |      |



DEC 15 1980

TOTAL EST'D WGT 4962

REQ. NO. ( )

NON-BLEEDING

| EQUIP     | NAME : "KROLOR" ORANGE R                                                                                                                                                                                                                                                                                                                                                                                                                 | USE<br>LBS                 | NCODE          | ACCT<br>LBS |
|-----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|----------------|-------------|
| 211 & 208 | 1 RUN 60" (990 G) WATER IN V-211 & ADD ASSUME 50%<br>& SET AGITATOR ON HIGH SPEED                                                                                                                                                                                                                                                                                                                                                        | 30                         | 7-D            | 15          |
| 1         | 2 WEIGH IN DRUM AND POUR IN<br>3 DUMP IN AND STIR 5 MIN<br>RECORD: START <u>3:51 PM</u><br>FIN <u>4:45 PM</u><br>4 ADJUST TO 75" (1275 G)<br>5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU<br>HOMOG AT 1800-2200 PSI INTO V-208<br>6 WHEN V-211 MT, WASH COLOR THRU HOMOG WITH MIN<br>HOT WATER AT 1800-2200 PSI INTO V-208<br>7 RECORD: V-208 VOL. <u>44</u> " & ADJUST TO 50" (1840 G)<br>8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY | 280<br>82X50<br>2,100<br>P | 983-D<br>YC10B | 280<br>4100 |
| 208 & SV  | 9 RUN 15" (771 G) WATER INTO V-247, START<br>AGITATOR & INSTALL TEMP CHART<br>10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.<br>RECORD: TIME START <u>7:45 PM</u> TOTAL MINUTES <u>190</u><br>2 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,<br>3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208<br>11 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP<br>THRU HOMOG AT 4800-5200 PSI INTO SV                                             |                            |                |             |
| 349 & 384 | 12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349<br>13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F<br>14 WEIGH INTO V-384 & PUMP TO V-349<br>15 RUN 1000# WATER INTO V-384 & PUMP TO V-349<br>3 16 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN<br>17 RECORD DENSITY: <u>1.081</u> G/ML (1.078-1.081)                                                                                                                                       | 2450                       | 983-D          | 2450        |
| SV        | 18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 66" (3400 G)<br>19 RECORD: PH <u>10.65</u> & ADJ TO 10.4-10.8 USING N-7-D<br>4 DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)<br>ASSUME 50%<br>SIPHON N-7-D INTO SV & RECORD: PH <u>10.65</u><br>20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT ____*F<br>& RECORD: ____*F                                                                                                                           |                            | 7-D            |             |



IN 34200

|     |           | LBS                                                                                                                          | CODE | LBS      |
|-----|-----------|------------------------------------------------------------------------------------------------------------------------------|------|----------|
| 343 | 21        | WHILE HEATING SV, RUN 51" (1400 G) WATER INTO V-343                                                                          |      |          |
| &   | 22        | METER IN FROM V-386                                                                                                          | 27-D | 355      |
| 386 | 23        | STIR 15 MIN OR LONGER                                                                                                        |      |          |
| 5   | 24        | RECORD: DENSITY 1.018 G/ML (1.018-1.020)                                                                                     |      |          |
| SV  | 25        | WHEN S 20 HEATING COMPLETE, RECORD: PH 9.25                                                                                  |      |          |
|     | 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 AT 190-194°F DURING STRIKE                                                   |      |          |
|     | 29        | RECORD: START FINISH MINUTES                                                                                                 |      |          |
|     |           | V-343 1:35 PM 4:05 190                                                                                                       |      |          |
|     |           | V-349                                                                                                                        |      |          |
|     |           | TIME V-343 V-349 SV NORMAL                                                                                                   |      |          |
|     |           | INCHES INCHES PH PH                                                                                                          |      |          |
|     | AT 20 MIN | 1:55 PM (47) (20) 9.4 (9.3-10.0)                                                                                             |      |          |
|     | 40 MIN    | 2:35 PM (43) (17) 9.4 (9.3-10.0)                                                                                             |      |          |
|     | 1 HR      | 2:35 PM (38) (15) 9.4 (9.3-10.0)                                                                                             |      |          |
|     | 2 HR      | 3:35 PM (24) (7) 9.4 (9.3-10.0)                                                                                              |      |          |
|     | 3 HR      | 4:35 PM (10) (0) 9.4 (9.3-10.0)                                                                                              |      |          |
|     | FINISH    | 5:10 PM (0) 9.4 (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 135-140°F                                                                         |      |          |
| 7   | 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 3.2 (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 4.2 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2. RECORD: PH                                                        | 27-D |          |
|     |           | DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 77%                                                                                   | 7-D  |          |
|     |           | SIPHON N-7-D INTO SV ASSUME 50%                                                                                              |      |          |
|     | 41        | STOP AGITATOR                                                                                                                |      |          |
|     |           | START FINISH OPERATOR                                                                                                        |      |          |
|     |           | 3 PM 7:10 PM 120 54                                                                                                          |      |          |