

STD. HRS. TIME 7 A.M. JOB NAME: 04K0909DMC

CG	CODE	PQ	LOT	LBS
01	YC-16-B	94	F1288	100
01	YC-16-B	93	J1260	2000
01	YC-16-B	93	62H74	500
01	YC-16-B	93	C2J23	1150

EST. WT. 5243* LBS. REQ. NO. (10827) NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	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 C2J23 1150 3 DUMP IN AND STIR 5 MINS. LOT 100 RECORD: START 3:15 F1288 2000 FIN 4:31 J1260 500 62H74	480 75X50	32-D YC16B	480 3750
	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 OF HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. 54" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	1 RUN 10" (514 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 1304 TOTAL MINUTES 120			
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	2500	32-D	2500
3	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
116	ADJ V-349 TO 19" (899 G) & STIR 15 MIN			
117	RECORD DENSITY: 1.0926/ML (1.091-1.094)			
SV 4	118 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 60" (3084 G) 119 RECORD: PH 10.3 & ADJ TO 11.1-11.3 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	30	7-D	15
120	SIPHON N-7-D INTO SV & RECORD: PH 11.2 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 123°F & RECORD: 194°F NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

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(122)

V-241

343	121	WHILE HEATING SV, RUN 49" (1348 G) WATER INTO V-343				
386	122	METER IN FROM V-386	M 17	14/GAL	362 GAL	27-D 373
5	123	STIR 15 MIN OR LONGER				
	124	RECORD: DENSITY 1.019 G/ML (1.018-1.020)				
	125	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.2				
	126	SET V-343 ACID PUMP AT 69 SETTING (225 MIN)				
	127	SET V-349 SILICATE PUMP AT 54 SETTING (180 MIN)				
SV	128	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE				
6	129	RECORD:	START	FINISH	MINUTES	
		V-343	7:30 AM	11:15 AM	225	
		V-349	7:30 AM	10:35	105	
		TIME V-343	V-349	SV	NORMAL	
		INCHES	INCHES	PH	PH	
		AT 20 MIN 7:50 AM	46) 46	(17) 17	10.0 (9.3-10.0)	
		40 MIN 8:10	(41) 41	(15) 15	10.0 (9.3-10.0)	
		1 HR 8:30	(37) 37	(13) 13	9.9 (9.3-10.0)	
		2 HRS 9:30	(23) 23	(6) 6	9.8 (9.3-10.0)	
		3 HRS 10:30	(10) 10	(0) 0	9.6 (9.3-10.0)	
		FINISH 11:15	(0) 0		8.0 (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
	130	SIFT IN				50 120-A 50
307	131	ADD 60" (465 G) WATER TO V-385				
	132	ADD & STIR FOR 2 MIN FOR S 63	ASSUME 50%	296	7-D	148
	133	DURING STRIKE CHECK LEVEL IN V-387.				
387	134	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37				
8	135	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE				
	136	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.				
	137	RUN IN 27" (268 GAL). DO NOT MAKE UP THIS SOLUTION MORE THAN 30 MINUTES IN ADVANCE. DELAY BETWEEN END OF STEP 43 HEAT-UP AND START OF STEP 53 HOMOGENIZATION SHOULD BE LESS THAN 30 MINUTES.				
388	138	TURN ON STEAM & AGITATOR				
9	139	ADJUST TO 37" (366 GAL) AT 178-182°F				
	140	SET BADGER METER FOR 590±				
	141	PUMP IN FROM V-387 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE		482	169-A	482
				54	155-A	54
				54	160-A	54
	142	SHUT OFF PUMP				
	143	STIR 30 MIN AT 178-182°F FOR S 53				
	144	DO NOT SHUT OFF AGITATOR				
SV	145	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING				
10	146	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR				
	147	STIR 60 MIN AT 190-194°F UP 12:15 NOON				

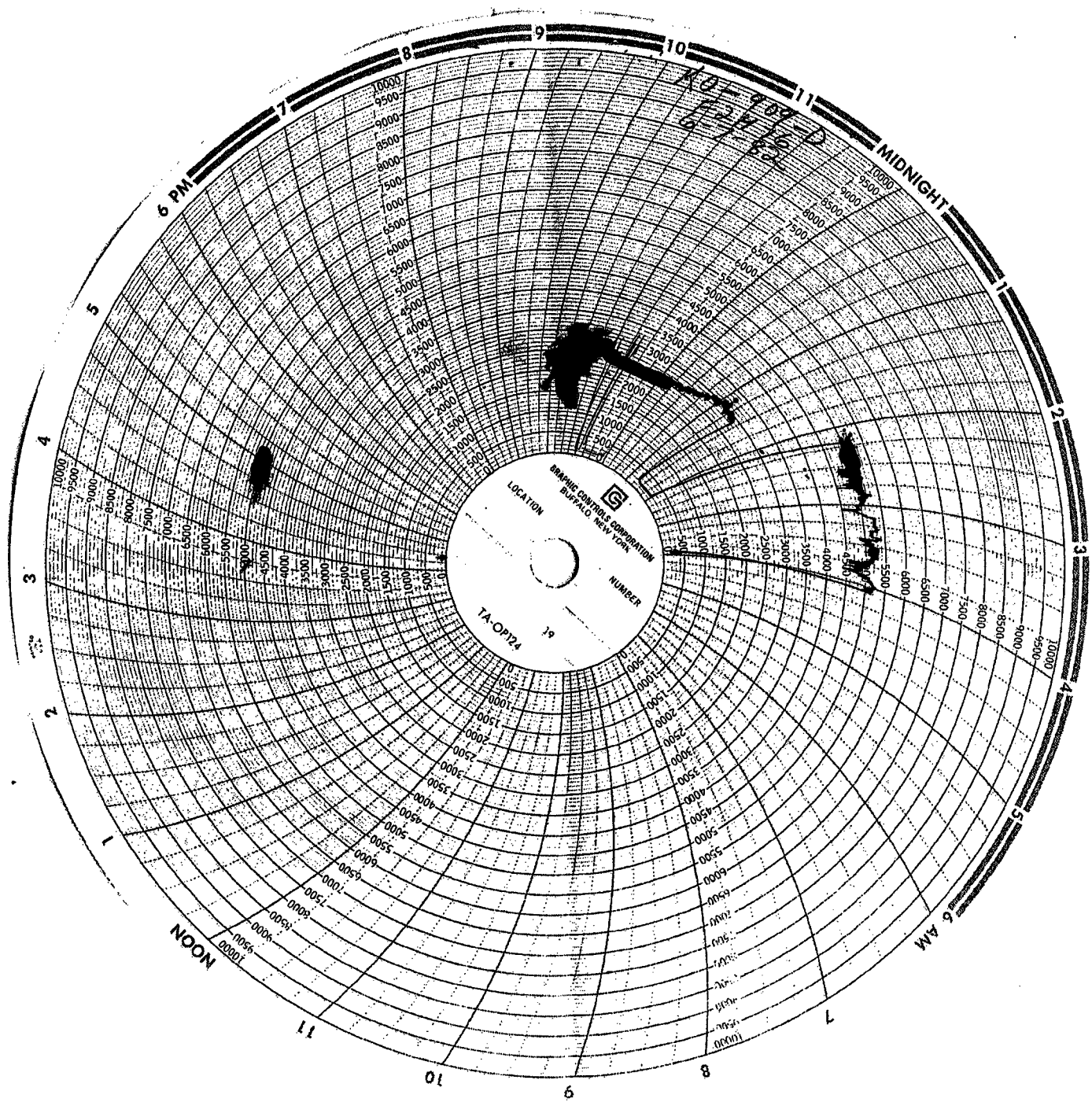
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SV	10	CONT	USE	N-	ACCT
			LBS	CODE	LBS
48		HEAT TO 198-200°F IN 5-10 MIN			
49		CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
50		OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
51		OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
52		WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
53		IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
54		WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
55		WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
56		TURN OFF HOMOG & STEARATE PUMP			
57		STIR 5 MIN AT 198-200°F			
58		SHUT OFF STEAM			
59		RUN IN ALUM USING BADGER METER	950	115-D	475
60		FLUSH ALUM LINE WITH WATER			
61		RECORD: PH <u>3.0</u> (3.4-3.8)			
62		IF NECESSARY, ADJ PH TO 3.4-3.8 (DOWNWARD ONLY) & RECORD: PH <u> </u> NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN. AFTER EACH ADDITION. ASSUME 50%		115-D	
63		RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
64		RECORD: PH <u>6.1</u> (6.2-6.4) & IF NECESSARY, ADJ TO PH 6.2-6.4 & RECORD: PH <u>6.3</u> ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	70	27-D 7-D	<u>35</u>
65		SIPHON N-7-D INTO SV			
66		DO NOT STOP AGITATOR			

START
 10:30 PM
 11 PM
 7:00 AM

FINISH
 11 PM
 7 AM
 2:45 PM

OPER
 54-126
 282-223
 320-342



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