

CG 04 CODE K0789D

PUNCHED & CHECKED

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS

MAY 27 1980

() K0789D

(I)

FWP 4/28/80

STANDARD HRS. 10.8

TIME

7P M

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TYPED BY: FWP 4/28/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93	35439	2950 #
01	YC016B	93	34575	1250 #
01	YC016B	93		

OK
FP

Homog #2

TOTAL EST'D WGT 5232

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MINS.	84X50	YC16B	4200
1	RECORD: START	2950		
	FIN	1250		
	4 ADJUST TO 75" (1275 G)			
	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. 44" & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-208 & START			
SV	AGITATOR & INSTALL TEMP CHART			
10	PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 8:44 TOTAL MINUTES 17.5			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
14	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP			
	THRU HOMOG AT 4800-5200 PSI INTO SV			
349	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
384	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: 1.086 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 10.7 & ADJ TO 11.1-11.3 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	20	7-D	10
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 188°F			
	& RECORD: 194°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34681

EQUIP	PAGE 2	CG 04	KO-789-D	EST WGT 52325	USE LBS	N- CODE	USE LBS
V-247							
343	✓	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343					
386	✓	METER IN FROM V-386	34	1.085	/GAL	36.0	390
5	✓	STIR 15 MIN OR LONGER					
5	✓	RECORD: DENSITY 1.020 ML (1.018-1.020)					
125	✓	WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0					
126	✓	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)					
127	✓	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)					
128	✓	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE.					
SV	✓	RECORD: START FINISH MINUTES					
		V-343 11:45 AM 6:20 2:75					
		V-349 5:25 AM 2:20					
		TIME V-343 V-349 SV NORMAL					
		1:45 INCHES INCHES PH PH					
		AT 20 MIN 2:05 (49) (20) 9.8 (9.3-10.0)					
		40 MIN 2:25 (45) (18) 9.8 (9.3-10.0)					
		1 HR 2:45 (41) (16) 9.8 (9.3-10.0)					
		2 1/4 HR 4:00 (25) 2:7+ (8) + 9.8 (9.3-10.0)					
		3 1/2 HR 5:15 (9) 12 (0) 1 9.8 (9.3-10.0)					
		FINISH 6:20 (0) 6:17 (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
356	✓	RUN 33" (238 G) WATER INTO V-356 & HEAT TO 135-140°F					
7	✓	DUMP IN & STIR TO DISSOLVE					530 15-A 530
302	✓	ADD 42" (514 G) WATER TO V-302					
8	✓	ADD & STIR 2 MIN					330 7-D 165
SV	✓	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING.					
9	✓	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR.					
✓	✓	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM					
✓	✓	RECORD: START 6:20 A					
✓	✓	RUN IN V-356 FROM S 31 & STIR 5 MIN					
✓	✓	RECORD: PH 3.0 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH					
		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					
✓	✓	RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN					
✓	✓	RECORD: PH 6.2 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4 & RECORD: PH					27-D
		DILUTE N-7-D 10 TO 1 WITH WATER					7-D
		SIPHON N-7-D INTO SV					
✓	✓	POUR IN STIR 15 MIN					50 1978-A 50
✓	✓	STOP AGITATOR					
		START FINISH OPERATOR					
		3:00 PM 11:00 PM 5:4-120					
		7:00 AM 7:00 AM 235-323					
		9:00 AM 223-201					