

OCT--1-80 37297

STANDARD HRS. 10.6 TIME

M

() KY-787-S (S) FWP 9/18/80
 () () (XOB-17: 3/4
 () () N-32-D & 240
 () () MIN STRIKE)
 TYPED BY: FWP 9/18/80

CG	CODE	PQ	LOT	LBS
14	YC002B	93		13099
14	YC002B	93		13095
14	YC002B	93		13091

2000
2000
200

Homog #4-1st Pass
" 0#4-2nd "

TOTAL EST'D WGT 5845

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	NCODE	ACCT LBS
203	1 RUN 60" (990 GAL) WATER INTO V-203 WITH AGITATOR			
	ON HIGH SPEED & ADD CAUSTIC	40	7-D	20
203	2 WEIGH SODIUM SILICATE INTO DRUM & POUR IN	420	32-D	420
	DUMP IN CHROME YELLOW & STIR 5 MIN	84X50	YC-2-B	4200
1	RECORD: START 11:00 AM	2000		
	FIN 12:00 AM	2000		
	ADJUST TO 75" (1275 GAL)	13091		
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	HOMOG AT 2400-2600 PSI INTO V-205 263			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	HOT WATER AT 2400-2600 PSI INTO V-205			
	7 RECORD: V-203 VOL. " & ADJUST TO 60" (2100 GAL)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	9 RUN 4" (200 GAL) WATER INTO V-246 START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 2:15 PM TOTAL MINUTES 110			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
11	WHEN V-205 MT, RUN IN 5" (240 GAL) WATER & PUMP			
	THRU HOMOG AT 4800-5200 PSI INTO SV			
349	12 WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	14 WEIGH INTO V-384 & PUMP TO V-349	2415	32-D	2415
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN			
	17 RECORD DENSITY: 1.103 G/ML (1.103-1.105) 48 V-246			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 48 (2420 GAL)			
	19 RECORD: PH 11.1 & ADJ TO 11.1-11.3 WITH CAUSTIC			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH 19.2			
20	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 19.2			
	& RECORD: 19.2			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	ON COMPLETION OF HEATING.			
343	21 WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO			
	V-343 & METER IN SULFURIC ACID FROM V-386			
	MK61-9.52 #/GAL, 37.0			
386	22 STIR 15 MIN OR LONGER			
5	23 RECORD: DENSITY 1.023 G/ML (1.023-1.025)		27-D	361

SV	24	WHEN S 20 HEATING COMPLETE, RECORD: PH <u>10.1</u>			
	25	SET V-343 ACID PUMP AT 49 SETTING (285 MIN)			
	26	SET V-349 SILICATE PUMP AT 38 SETTING (240 MIN)			
	27	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
	28	RECORD: START FINISH MINUTES			
		V-343 <u>8:45 P.M.</u> <u>1:33 A</u> <u>288</u>			
		V-349 <u>12:45 A</u> <u>242</u>			
		V-343 V-349 SV NORMAL			
		TIME INCHES <u>41</u> INCHES <u>17</u> PH PH			
		AT 20 MIN <u>9:00 P</u> (37) <u>33</u> (16) <u>16</u> <u>9.8</u> (9.3-10.0)			
		40 MIN <u>9:20 P</u> (34) <u>35</u> (14) <u>14</u> <u>9.8</u> (9.3-10.0)			
6		1 HR <u>9:40 P</u> (31) <u>32</u> (13) <u>13</u> <u>9.8</u> (9.3-10.0)			
		2 HR <u>10:00 P</u> (23) <u>23</u> (9) <u>9</u> <u>9.5</u> (9.3-10.0)			
		3 HR <u>11:40 P</u> (15) <u>15</u> (4) <u>5</u> <u>9.3</u> (9.3-10.0)			
		4 HR <u>12:45 P</u> (6) <u>6</u> (0) <u>5</u> <u>9.4</u> (9.3-10.0)			
		FINISH <u>1:30 P</u> (0) <u>---</u> <u>---</u> <u>7.9</u> (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 ASSUME 77%			27-D

330	29	RUN 35" (600 GAL) WATER INTO V-330 & HEAT TO 160-170°F			
7	30	ADD DRESINATE "X" IN 12-13 MIN	600	530-A	600 ✓
	31	STIR 5 MIN & RECORD: PH <u>10.2</u> (9.5-10.5)			
	32	STIR 20 MIN OR LONGER FOR S-45			

385	33	RUN 40" (308 GAL) WATER INTO V-385 & HEAT TO 135-140°F			
8	34	DUMP IN ALUM & STIR TO DISSOLVE FOR S-41	280	15-A	280

302	35	ADD 42" (513 GAL) WATER TO V-302			
9	36	ADD & STIR 2 MIN FOR S-43 ASSUME 50%	320	7-D	160

SV	37	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
10	38	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	39	TURN OFF STEAM			
	40	SIFT IN BLANC FIXE	200	128-A	200 ✓
	41	RUN IN V-385 FROM S 34 & STIR 5 MIN			
	42	RECORD: PH <u>9.7</u> (3.7-4.2)			
	43	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
	44	RECORD: PH <u>10.2</u> (9.0-9.5) & IF NECESSARY ADJ TO PH 9.0-9.5. RECORD: PH <u>9.5</u> ASSUME 77%	<u>14</u>	27-D	<u>11</u>
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
	45	RUN IN V-330 THRU 20 MESH SCREEN & STIR 20 MIN			

330	46	RUN 11" (216 GAL) WATER INTO V-330			
11	47	DUMP IN CALCIUM CHLORIDE & STIR 5 MIN FOR S-48	230	20-A	230 ✓

SV	48	RUN V-330 INTO SV IN 15-20 MIN			
12	49	STIR 15 MIN & RECORD: PH <u>9.5</u> (9.0-10.0)			
	50	DO NOT STOP AGITATOR			
		START FINISH OPERATOR			
		<u>12:30 P</u> <u>3:00 P</u> <u>2:35-32.3</u>			
		<u>3:00 P.M.</u> <u>11:00 P.M.</u> <u>381-342</u>			
		<u>11:00 P.M.</u> <u>7:00 P.M.</u> <u>34-120</u>			



