CODE RC-3-A PKG. _____

-0-81-[illegible]1381

EST. WGT. 1820 LBS.

STD. HRS. _____ TIME _____ M

PROCESSES		APPROVED BY
(C) RC-3-A	( )	BBK 03-11-77
( )	( )	DCG 05-20-77
( )	( )	MTW 06-06-77
( )	( )	
TYPED BY emw060877		

NON-BLEEDING

EQUIPMENT		NAME: MONASTRAL® RED B	USE LBS.	N CODE	ACCT. LBS.
Prep 1	1	Install Temp & Amp charts			
	2	Weigh ±600# of RC-1/RC-3 Borax Sludge for S 5			
	3	Dip liquid from sludge & add to classifier intake			
	4	Obtain ±200# chopped ice for S 13-B			
HF Mill 2	5	Shovel 600# of Borax Sludge (equivalent to ±300# 100% Borax) into HF Mill NOTE: Total Weight includes liquid removed in S 4			
	6	Add	18	834-B	0
	7	Start cooling water spray			
	8	Stir 3-5 min to uniformity			
	9	Stop agitator & dump in NOTE: Record Lot, #100%, & "As Is Lbs" in S 35	130	7500-A	0
	10	Stir 3-5 min to uniformity			
	11	Add in 5-10 min while agitating	300	972-A	0
	12	Immediately start milling cycle			
	13	Stir 4 hrs, maintaining 38-42 Amps & 110-130°F N-7500-A Lot [illegible] Milling Hours 4.0 A. After ½ Hr milling add N-972-A or trickle in water to maintain 38-42 Amps. Do not add N-972-A at less than 10 min intervals. Record additional N-972-A used in S 35 B. If necessary, add N-57-A to maintain 110-130°F C. If cake forms stop agitator, scrape mill wall to permit heat transfer D. Record necessary data in S's 19, 20, 35, & Pg 4			
Class 3	14	During S 13 stir, hook up lines from Dorr Classifier to V-10 NOTE: Feed valve must be closed			
	15	Obtain two 55 gal drums for S 27			
Shriv 4	16	Set up 20 plates each in No. 1 & No. 2 Shriver Thickeners			
HF Mill 5	17	Add 5-10 gal water to HF Mill. CAUTION: Too much water will cause charge to splash over edge of mill			
	18	Stop agitator & turn off cooling water			

13026 REV.

EQUIPMENT		PAGE 2 CG 16 CODE (C) RC-3-A EST. WGT. _____ LBS.	USE LBS.	N CODE	ACCT LBS.
Misc 6	19	Record:			

Chg No	Date Start	Time Start	Date Fin	Time Fin	Tot Milling Hrs
1	5-12-81	7:10 Pm	5-12-81	11:10 Pm	4 HRS
2	5-12-81	7:10 Pm	5-12-81	11:10 Pm	4 HRS.
3	5-12-81	1:00 AM	5-13-81	5:00 AM	4 HRS
4	5-13-81	1:00 PM	5-13-81	5:00 PM	4 HRS
5	5-12-81	5:30 P	5-13-81	9:30 P	4 HRS
6	5-12-81	5:30 P	5-13-81	9:30 P	4 HRS
7	5-13-81	4:00 AM	5-14-81	8:00 AM	4 HRS
8	5-13-81	4:00 AM	5-14-81	8:00 AM	4 HRS
9	5-14-81	10 - AM	5-14-81	2 PM	4 HRS
10	5-14-81	10 AM	5-14-81	2 PM	4 HRS
11	5-14-81	5:30 pm	5-14-81	9:30 P	4 HRS
12	5-14-81	5:30 pm	5-14-81	9:30 P	4 HRS
13					
14	5-14-81	12:30 AM	5-15-81	4:30 A	4 HRS

20 Record accuracy once per shift while milling

Date	Time	Chg No	Ammeter Amps	Recorder Amps	HT °F	Record °F
5-12-81	9 Pm	1-2	40 - 40	42 - 38	-	113-117
5/13/81	6:00 pm	7-8	38 40	39 40		116-119
5-14-81	1 Pm	9-10	40 - 40	41 41	-	128-118
5-14-81	9:30	11-12	40 - 40	40 - 40		114-119
5-15-81	3 AM	13-14	40 - 40	40 - 41		128-120

11 7	21	Add 10" (122 G) water to V-11			
	22	Heat to 140-150°F for S 24			
13/14 8	23	Pump 2 charges from HF Mills to V-13 or V-14			
	24	Wash out HF Mills, with heated water from V-11			
	25	Adj to 24" (408 G) at 140-150°F			
	26	Immediately cool to 75-80°F	6 x 330	57-A	0
	27	Record data on S 35 bottom of Page 3			
Class 9	28	Back wash lines from classifiers to V-13 or V-14			
	29	Place 55 gal drum under sludge discharge & start motor			
	30	Open inlet valve & run V-13 or V-14 thru classifier to V-10 at 2.5-3.0 GPM			
	31	When drum contains ±45 gal of sludge, change drum, weigh & Record in table on bottom of Page 3			
	32	When V-13 or V-14 is MT, close feed valve & backwash line to vat for ½ min			
	33	Open feed valve & drain vat to classifier. Do not wash in vat NOTE: 4 or fewer HF mill charges may be run from V-13 or V-14 without treatment or classification Record: Charge No.			
Misc 10	34	Repeat S's 1-23 until 14 charges are collected CAUTION: After 9th charge, watch volume in V-10			

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ENT		PAGE 3 CG 16 CODE (C) RC-3-A EST. WGT. LBS.										USE LBS.	N CODE	ACC LBS
	35	Charge out Raw Materials below												
		Chg No	Mill No	A-834 #	Rec Sludge #As Is	N-972 #100%	#	N-7500-A Lot	#100%	%	#As Is	N-57-A #	Optr No		
		1	1	18	600	300	300	7145	130	99.9	130	2310	44		
		2	2	18	600	300	300	7145	130	99.9	130		44		
		3	1	18	600	300	300	7147	130	999	130	2310	105	972-A	4200
		4	2	18	600	300	300	7147	130	999	130		105		
		5	1	18	600	300	300	7152	130	99.6	130	2310	27	834-B	252
		6	2	18	600	300	300	7152	130	99.6	130		27		
		7	1	18	600	300	300	7152	130	99.6	130	2310	166	7500-A	1620
		8	2	18	600	300	300	7152	130	99.6	130		166		
		9	1	18	600	300	300	7148	130	99.7	130	2310	348	57-A	16170
		10	2	18	600	300	300	7148	130	99.7	130		348		
		11	1	18	600	300	300	7109	130	99.2	130	2310	101		
		12	2	18	600	300	300	7109	130	99.2	130				
		13	1	18	600	300	300	7152	130	99.6	130	2310	322		
		14	2	18	600	300	300	7152	130	99.6	130				
		Tot		252		4200			1620			16170			

36 Enter Raw Material totals in Acc't Lbs column

10 37 Heat V-10 to 150-160°F

38 Pump V-10 to V-9 CAUTION: Do not overflow V-9

13 39 Start agitator

40 Adj to ±50" maintaining 150-160°F

41 Rinse in V-10 & V-10 lines

42 Circulate thru Shriver Thickeners to 50" (2220 G) at 150-160°F

43 Record: Start Date 5-16-81 Time 6:30 PM ol 52"

44 Circulate until effluent reaches 3000 ohms

45 Record: Finish Date 5-19-81 Time 4 PM Ohms 3000 pH 8.6 (8.4-9.0)
NOTE: After 16 hrs washing take ohm reading each four hrs & Record below on chart

46 Shut off water

47 Circulate thru Thickeners to 23" (1012 G)

48 Discharge into 55 gal drums

49 While filling drums, take a 1 qt jar sample. Deliver to CTL for D.C.

50 Run 10" (450 G) water into V-9

51 Heat to 158-162°F

52 Recirculate thru Shriver for 15 min or until effluent is clear

53 Stop agitator

START	FIN	OPTR
11 P.M.	7 A.M.	101

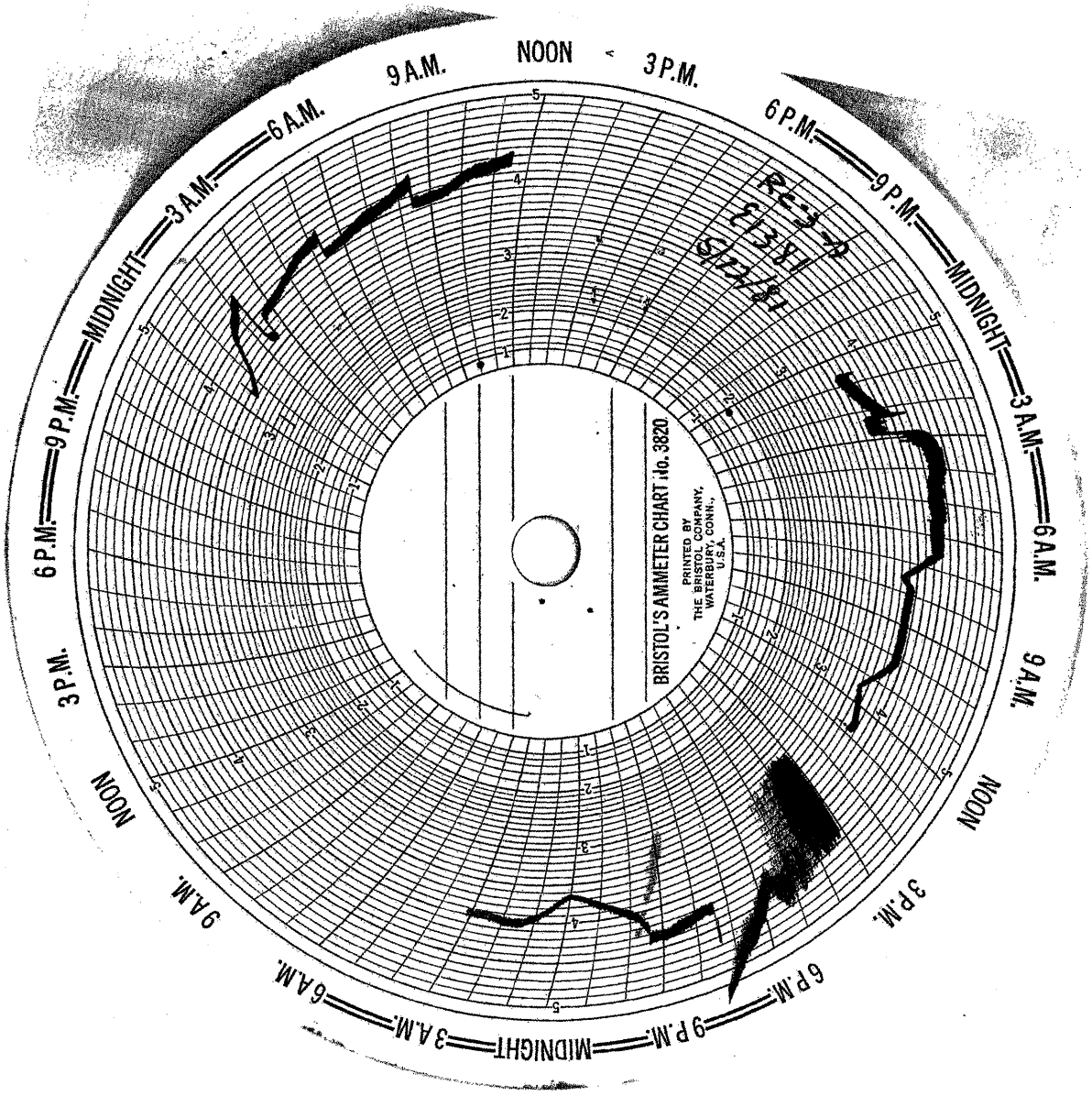
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QUIPMENT | PAGE 4 OF 16 CODE (C) RC-3-A EST. WGT. LBS. | USE LBS. | N CODE | ACCT LBS.

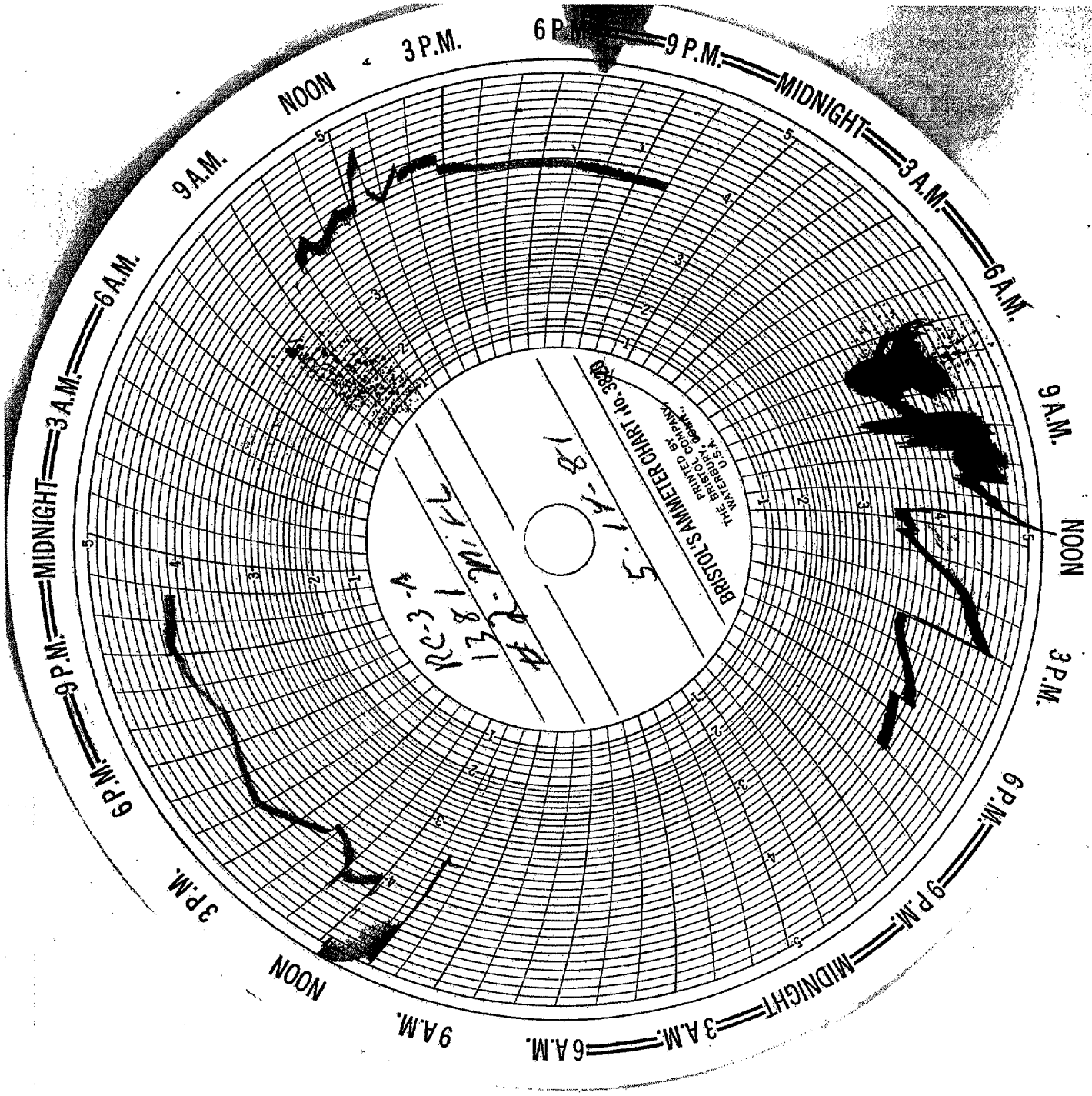
CHG NO	Vat	VOLUME Init	VOLUME Final	FINAL Temp	N-57 Used	SLUDGE Class	Chg No	Vat	VOLUME Init	VOLUME Final	FINAL Temp	N-57 Used	SLUDG Class
1 & 2													
3 & 4													
5 & 6													
7 & 8													
9 & 10													
11 & 12													
13 & 14													

TIME													
OHMS													
TIME													
OHMS													

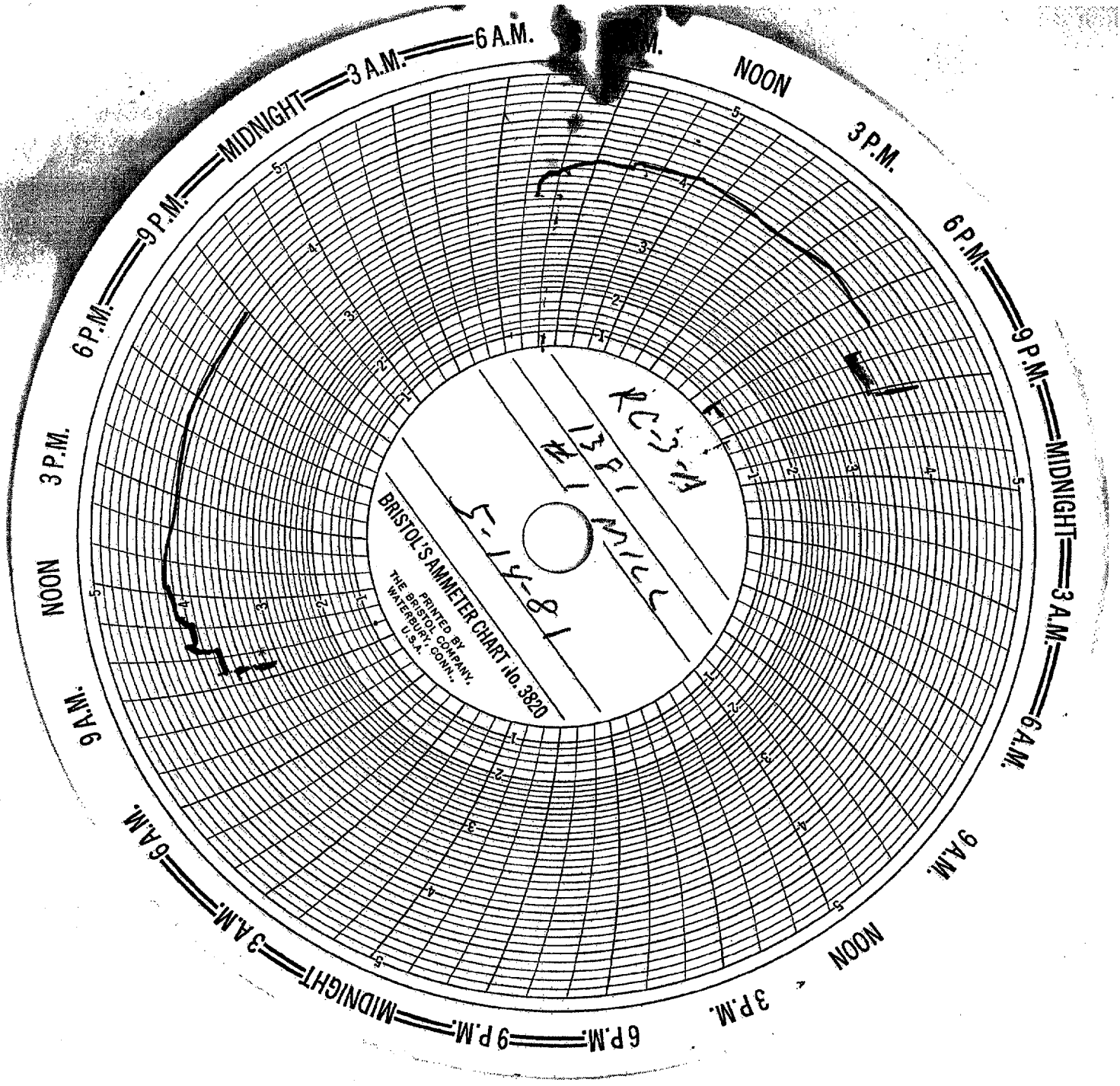
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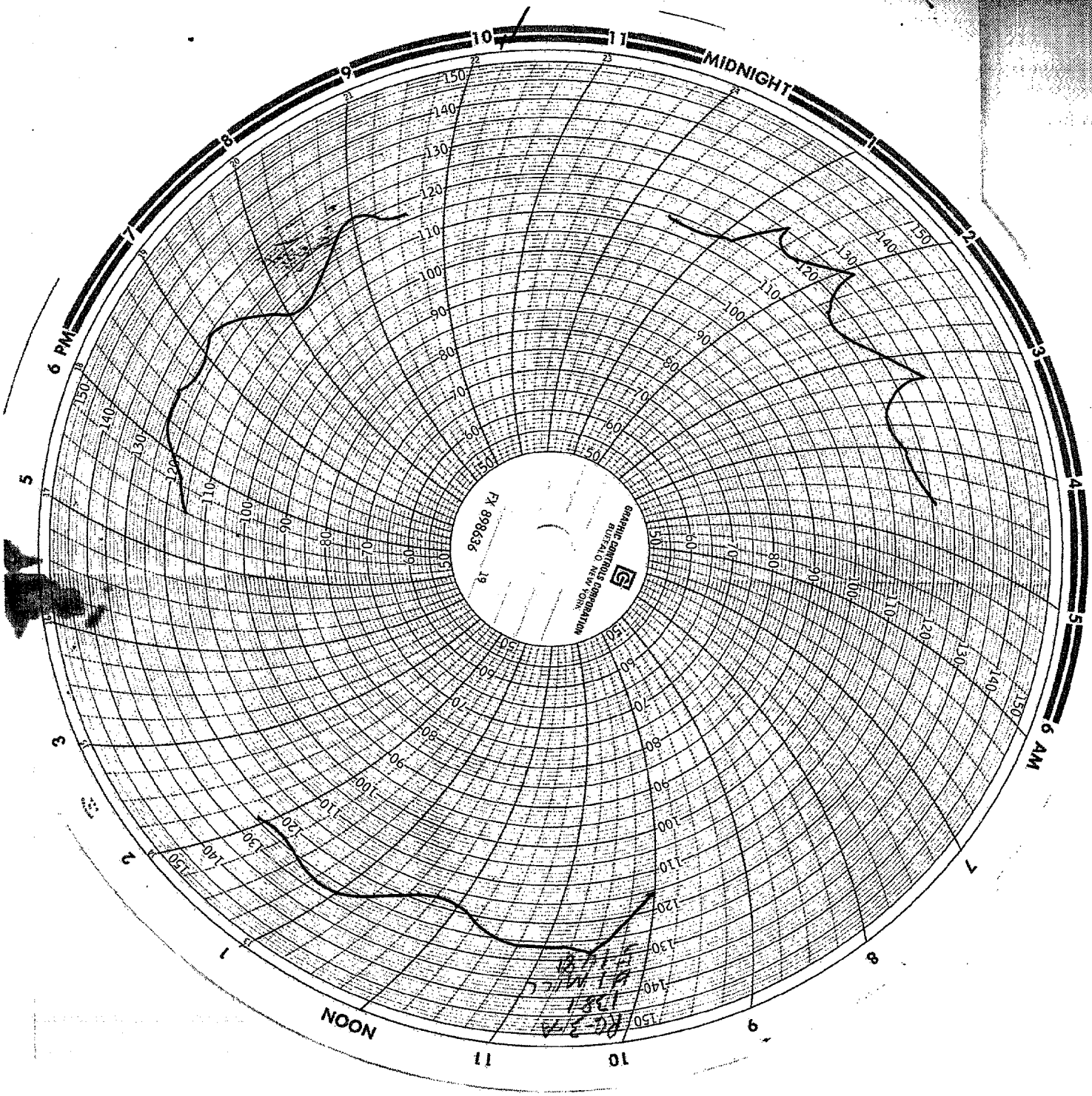


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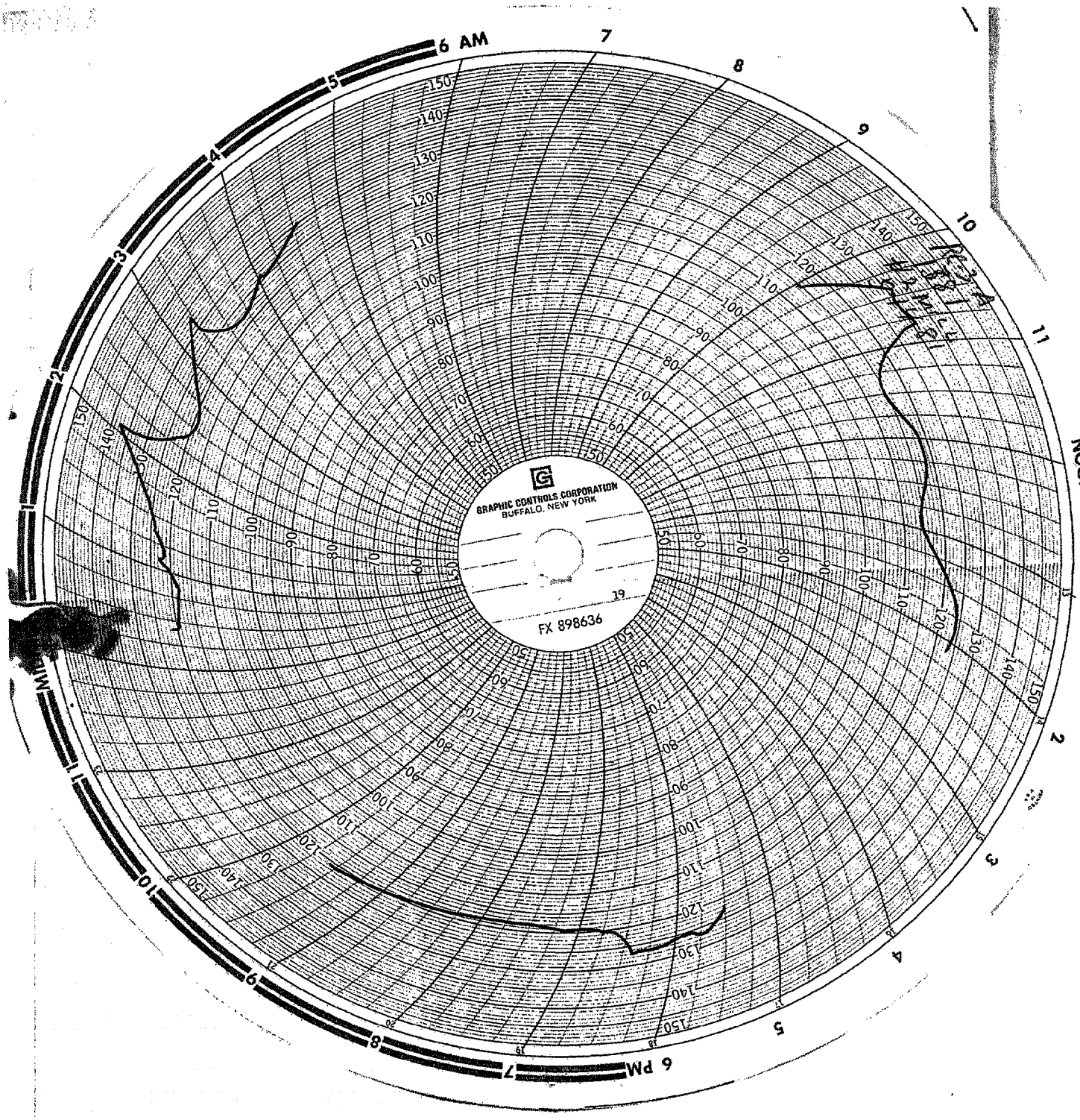


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6 A.M.
NOON
3 P.M.
6 P.M.
9 P.M.
MIDNIGHT
3 A.M.
6 A.M.
9

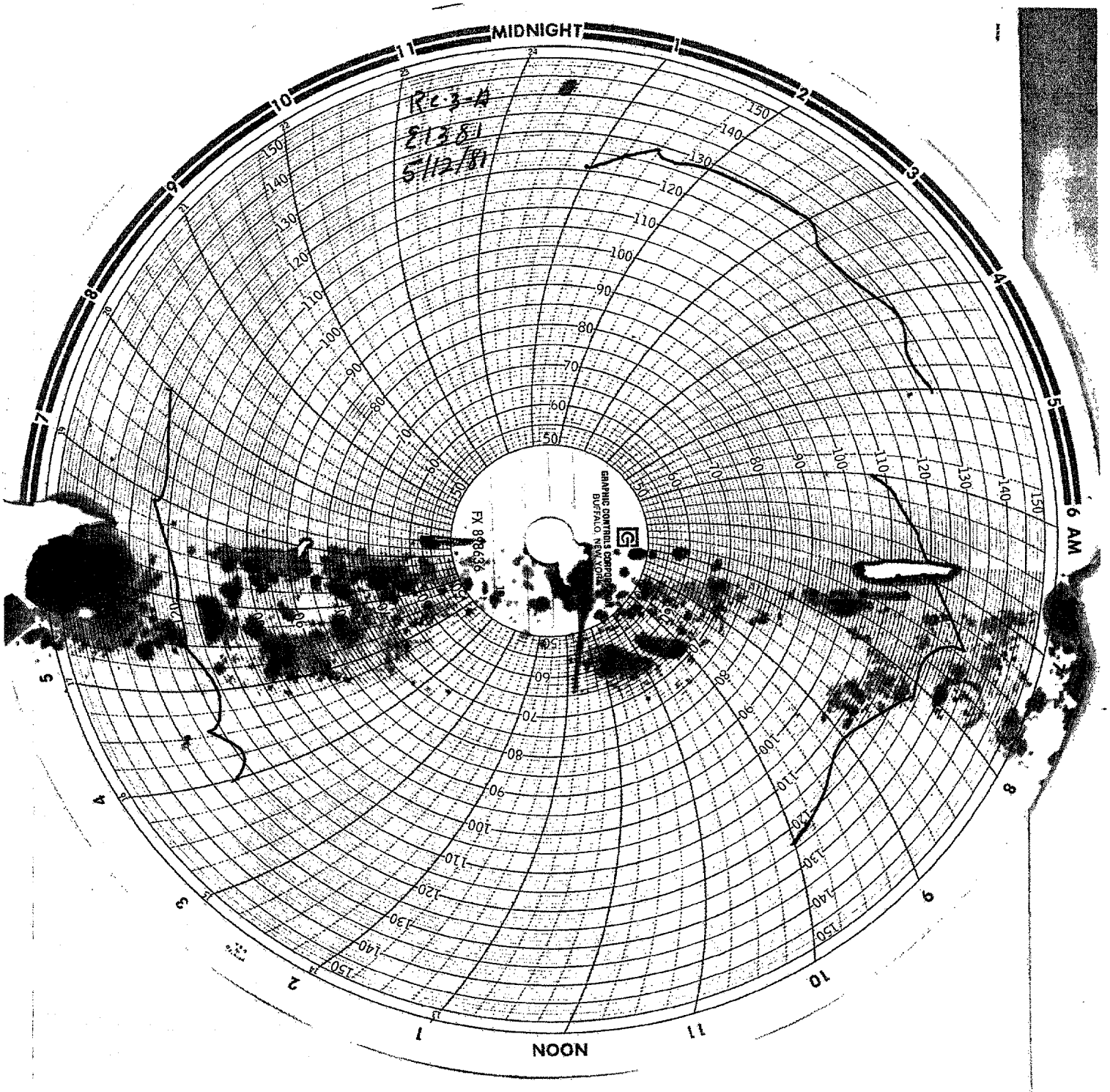


DUP050097020



DUP050097021

DUP050097022



DUP050097023

NAME: MONASTRAL® RED B — NON-BLEEDING

INSTRUCTIONS — -PRESSING- — RECORD

							PRESSLOAD	1ST	2ND	3RD	4TH	5TH
VAT							STARTED					
DATE							CAKES USED					
TIME							WATER ON					
RELEASED BY							HRS. WASHED					
PRESS							OHMS					
NO. OF CAKES							HRS. WASHED					
PRESS		AGITATION					OHMS					
WASH TO		OHMS					HRS. WASHED					
TEST AFTER		HOURS					OHMS					
LOAD							CAKE CONDITION					
							NO. CARS LOADED					

DO NOT PRESS.

EXPLAIN LOSSES

SAMPLES
DELIVER TO — SAMPLED BY — RELEASED BY

-DRYING-

HOURS	L.V.	H.V.
TEMP.	°F	°F

LUMP: - OK - WET - SALTS - CONTAMINAT

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES
DELIVER TO — NO. CARS PULLED — LUMP WGT.
SAMPLED BY — RELEASED BY

-GRINDING-

MILL	SCREEN	RPM
MAX. TEMP.	°F	

SCREEN — RPM
MAX. TEMP. °F

EXPLAIN LOSSES

SAMPLE AFTER / WITHOUT MIXING
SAMPLES
DELIVER TO C T L

DATE MIXED
SAMPLED BY — RELEASED BY

DUP050097024