

ANUAL)
V. 243, 244, (246), 247, 262

MAKING INSTRUCTIONS: BATCH UNIT

CG 03 CODE KY-787-D

37687

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

STANDARD HRS. 10.6 TIME _____ M

CG CODE PQ LOT LBS
14 YC002B 93 13171 2400
14 YC002B 93
14 YC002B 93

PUNCHED & CHECKED *1.70 Lower PH*
19

TOTAL EST'D WGT 3332

NOV - 7 1980

NON-BLEEDING

JIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	NCODE	ACCT LBS
1	RUN 60" (990 GAL) WATER INTO V-203. RUN AGITATOR ON HIGH SPEED.			
2	WEIGH SODIUM SILICATE INTO DRUM & POUR IN	240	983 52-D	240
3	DUMP IN CHROME YELLOW & STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START <u>8-4</u> FIN <u>9:30</u> <i>LOT-13171</i>	2400		
4	ADJUST TO 75" (1275 GAL) <i>PH 10.3</i>			
5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
6	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2400-2600 PSI INTO V-205			
7	RECORD: V-205 VOL. <u>58</u> " & ADJUST TO 60" (2100 GAL)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
9	RUN <u>2</u> " (200 GAL) WATER INTO V- <u>246</u> START AGITATOR & INSTALL TEMP CHART			
10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>400</u> TOTAL MINUTES <u>125</u>			
	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			
12	WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F		983 32-D	1380
14	WEIGH INTO V-384 & PUMP TO V-349	1380		
15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
16	ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN			
17	RECORD DENSITY: <u>1.060</u> G/ML (1.059-1.060) <i>Note PH 10.4-10.6</i>			
18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO <u>17</u> " (2420 GAL)			
19	RECORD: PH <u>9.9</u> & ADJ TO <u>19.4</u> WITH CAUSTIC AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	8	727D	8
20	SIPHON N-7-D INTO SV & RECORD: PH <u>10.3</u> HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>192</u> °F & RECORD: <u>192</u> °F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON ON COMPLETION OF HEATING			
21	WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343 & METER IN SULFURIC ACID FROM V-384			

IF	PAGE 2	CG 03	KY-787-D	EST WGT 3532#	USE LBS	N- CODE	USE LBS
			V-246				
24	WHEN S 20 HEATING COMPLETE, RECORD: PH <u>9.4</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>7:50 P</u>	<u>12:45</u>	<u>2:45</u>			
	V-349	<u>7:50 P</u>	<u>12:40</u>	<u>2:50</u>			
		V-343	V-349	SV	NORMAL		
		TIME INCHES	INCHES	PH	PH		
	AT 20 MIN	<u>8:10 P</u> (37)	(16)	<u>9.4</u>	(9.3-10.0)		
	40 MIN	<u>8:30 P</u> (34)	(14)	<u>9.4</u>	(9.3-10.0)		
	1 HR	<u>8:50 P</u> (31)	(13)	<u>9.4</u>	(9.3-10.0)		
	2 HR	<u>9:20 P</u> (23)	(9)	<u>9.3</u>	(9.3-10.0)		
	3 HR	<u>10:30 P</u> (15)	(4)	<u>9.3</u>	(9.3-10.0)		
	4 HR	<u>11:50 P</u> (6)	(0)	<u>9.2</u>	(9.3-10.0)		
	FINISH	<u>12:35 A</u> (0)		<u>6.0</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					27-D	
29	RUN 20" (392 GAL) WATER INTO V-330 & HEAT TO 80-100°F						
30	ADD DRESINATE "X" IN 7-8 MIN			350	530-A	350	
31	STIR 5 MIN & RECORD: PH <u>10.2</u> (9.5-10.5)						
32	STIR 20 MIN OR LONGER FOR S-45						
33	RUN 40" (308 GAL) WATER INTO V-385 & HEAT TO 135-140°F						
34	DUMP IN ALUM & STIR TO DISSOLVE FOR S-41			160	15-A	160	
35	ADD 30" (360 GAL) WATER TO V-302						
36	ADD & STIR 2 MIN FOR S-43	(D)	ASSUME 50%	<u>100901721-D</u>		90	
37	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING						
38	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR						
39	TURN OFF STEAM						
40	SIFT IN BLANC FIXE			✓ 100	128-A	100	
41	RUN IN V-385 FROM S 34 & STIR 5 MIN						
42	RECORD: PH <u>3.4</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>9.2</u> (9.0-9.5) & IF NECESSARY ADJ TO PH 9.0-9.5. RECORD: PH _____		ASSUME 77%		27-D		
	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						
46	RUN 10" (128 GAL) WATER INTO V-313						
47	DUMP IN CALCIUM CHLORIDE & STIR 5 MIN FOR S-48			✓ 135	20-A	135	
48	RUN V-313 INTO SV IN 15-20 MIN						
49	STIR 15 MIN & RECORD: PH _____ (9.0-10.0)						
50	STOP AGITATOR (DO NOT STOP AGITATOR IN V-262)						
	START	FINISH	OPERATOR				
	<u>3:00 P</u>	<u>11:00 P</u>	<u>2:59</u>				
	<u>11:00 AM</u>	<u>7:12 AM</u>	<u>3:20 PM</u>				

