

MAY -0.81-21169

() KY-908-D (E)

FWP 04/08/81

STANDARD HRS.

TIME _____ M

() ()

() ()

JOB NAME: 03KY908DME

CG	CODE	FR	LOT	LBS
14	YC003B	93	14026	2000
14	YC003B	93	14028	2000
14	YC003B	93	14028	2000
03	147810	98	14028	2000

Do Not use YC-3-B
LOTS 14001 thru 14004

TOTAL EST'D WGT 3549 3599

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	NCODE	ACCT LBS
203	1 ✓ RUN 60" (990 GAL) WATER INTO V-203			
	2 ✓ RUN AGITATOR ON HIGH SPEED			
205	2 ✓ WEIGH SODIUM SILICATE INTO DRUM & POUR IN	345	32-D	345
	3 ✓ DUMP IN CHROME YELLOW & STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START <u>3:27</u> LOT- <u>14026</u> = <u>2000</u>			
	FIN <u>6:42</u> <u>14028</u> = <u>2000</u>			
	4 ✓ ADJUST TO 75" (1275 GAL)			
	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. _____ & ADJUST TO 60" (2100 GAL)			
	8 ✓ INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 ✓ RUN 2" (200 GAL) WATER INTO V- <u>202</u> , START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 ✓ PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <u>8:54</u> TOTAL MINUTES <u>12</u>			
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	1215	32-D	1215
	15 ✓ RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ✓ ADJ V-349 TO 14" (662 GAL) & STIR 15 MIN			
	17 ✓ RECORD DENSITY <u>1.064</u> G/ML (1.063-1.065)			
SV	18 ✓ WHEN S-11 HOMOG COMPLETE, ADJ SV TO <u>22</u> " (2420 GAL)			
	19 ✓ RECORD: PH <u>10.0</u> & ADJ TO 11.0-11.2 WITH CAUSTIC			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%			
	20 ✓ SIPHON N-7-D INTO SV & RECORD: PH <u>11.1</u>	32	7-D	12
	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			
343	21 ✓ WHILE HEATING SV, RUN 31" (350 GAL) WATER INTO V-343			
	22 ✓ METER IN SULFURIC ACID FROM V-384			
	MK <u>14</u> <u>10922</u> #/GAL <u>16.5</u> GAL			
386	23 ✓ STIR 15 MIN OR LONGER		27-D	180
	24 ✓ RECORD: DENSITY <u>1.016</u> G/ML (1.014-1.018)			

V-262

SV	25	WHEN S-20 HEATING COMPLETE, RECORD: PH <u>10.0</u>			
	26	SET V-343 ACID PUMP AT 56 SETTING (180 MIN)			
	27	SET V-349 SILICATE PUMP AT 49 SETTING (145 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
		AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 <u>240P</u> <u>5:50P</u> <u>19.0</u>			
		V-349 <u>5:05P</u> <u>14.5</u>			
		V-343 V-349 SV NORMAL			
		TIME INCHES INCHES PH PH			
		AT 20 MIN <u>300P</u> (28) <u>30-</u> (12) <u>9.7</u> (9.3-10.0)			
		40 MIN <u>320P</u> (24) <u>25+</u> (10) <u>9.7</u> (9.3-10.0)			
		1 HR <u>340P</u> (21) <u>22</u> (8) <u>9.65</u> (9.3-10.0)			
		2 HR <u>440P</u> (10) <u>11-</u> (3) <u>9.55</u> (9.3-10.0)			
		FINISH <u>540P</u> (0) (0) <u>8.8</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 <u>8.3</u> ASSUME 77% <u>10</u>			
	30	SIFT IN	<u>50</u>	27-D <u>7</u>	128-A <u>50</u>
385	74	RUN 27" (210 G) WATER INTO V-385 & HEAT TO			
		135-140°F			
	72	DUMP IN & STIR TO DISSOLVE FOR S-60	415	15-A	415
302	33	ADD 24" (294 G) WATER TO V-302			
8	34	ADD & STIR FOR 2 MIN FOR S 62 ASSUME 50%	100	7-D	50
PT	25	DURING STRIKE PUMP INTO PT	312	169-A	312
	26	PUMP IN	36	155-A	36
9	37	PUMP IN	36	160-A	36
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			
	39	DURING STRIKE RUN 14" (244 G) WATER INTO V-356			
	40	TURN ON STEAM			
356	41	ADJ TO 18" (317 G) AT 81-82°C			
10	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE			
		DISTRIBUTORS AS FAST AS POSSIBLE			
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER			
		& PUMP IN			
	44	SHUT OFF PUMP			
	45	STIR 30 MIN AT 81-82°C FOR S 54			
	46	DO NOT SHUT OFF AGITATOR			

V-262

- SV 147 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 SET PUMP AT ZERO SETTING
- 11 148 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
- 149 HEAT TO 198-200°F IN 5-10 MIN
- 150 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
 PUMP
- 151 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
 INLET
- 152 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
 THRU HOMOG AT 2900-3100 PSI TO SEWER
- 153 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
 TO SV & CLOSE VALVE TO SEWER
- 154 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
 TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
 PSI. MAINTAIN SV AT 198-200°F.
- 155 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
 AT STEARATE PUMP ASAP
- 156 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
 WATER FROM HOT WATER MIXER
- 157 TURN OFF HOMOG & STEARATE PUMP
- 158 STIR 5 MIN AT 198-200°F
- 159 SHUT OFF STEAM
- 160 RUN IN V-385 FROM S-32 & STIR 5 MIN
 RECORD: PH 3.55 (3.3-3.7)
- 161 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)
 & RECORD: PH
- 162 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- 163 RECORD: PH 3.6 (4.2-4.4) & IF NECESSARY, ADJ
 TO PH 4.2-4.4 & RECORD: PH 4.2 ASSUME 78%
 (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
 SIPHON N-7-D INTO SV
- 164 DO NOT STOP AGITATOR

START

FINISH

OPERATOR

7:00 PM

3:00 PM

126-259

3:00 P

9:35 PM

235-244

STEP V-262 (20 RPM) V-243, 244, 246, 247

9

2"

4"

18

24"

47"

27-D

7-D

40

20