PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244, 280 (262) C.V. APR 25 1980 D.V.

CG 03 CODE KY-781-D PKG. ____

→ Apr 22 35476

EST. WGT. 786 LBS.

STD. HRS. 10.5 TIME 5 P M

PROCESSES		APPROVED BY
( ) KY-781-D	(M)	BBK 12-13-74
( )	( )	DCG 12-17-74
( )	( )	
( )	( )	
TYPED BY		
NSA 12-30-74		

(2) OK/KP

14 YC-3-B ~~98~~ 93 4 24729, 2000 #
14 YC-3-B ~~98~~ 93 4 24419, 500 #
14 YC-3-B ~~98~~ 93 4 24420, 150 #

Homog #4 — 1ST Pass

Total Wgt. 3436# (Req. ____ APR 23 1980)

NON-BLEEDING

EQUIPMENT		NAME: 60" (990G) "KROLOR" YELLOW-LIGHT (RUN AGITATOR ON HIGH SPEED)	USE LBS.	N CODE	ACCT. LBS.
203	1	Run ~~23" (360 G)~~ water in V-203 & add Assume 50%	30	7-D	15
&	2	Weigh in drum & pour in	355	32-D	355
205	3	Dump in & stir 5 min Lot	53X50	YC-3-B	2650
1		24729	2000		
		24419	500		
		75" (1275 G) 2400-2600 24420	150		
	4	Adj to ~~56" (950 G)~~ & Record: pH 10.7 (10.5-11.5)			
	5	Pump V-203 thru Homog ~~4B~~ at ~~1800-2200~~ psi into V-205			
	6	When V-203 MT wash color thru Homog at 1800-2200 psi using minimum water			
	7	Record: V-205 Vol 49 " & adj to 36" (1340 G)			
	8	Inspect Homog, strainer & clean if necessary			
		DURING HOMOG, RUN V-203 AGITATOR ON HIGH SPEED.			
SV	9	Run 2 " (200 G) water into V-262 install temp chart & start agitator			
&	10	Pump V-205 thru Homog at 4800-5200 psi into SV 262			
205		Record: Time Start 11:00 A Total Min 130			
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 G) water & pump thru Homog at 4800-5200 psi			
		Record density			
349	12	While Homog, run 6" (284 G) 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	2030	32-D	2030
3	15	Run ±1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 23" (1120 G) & stir for S 26			
		Record density 1.062 g/mL (1.062-1.064)			
SV	17	When S 11 Homog complete, Adj SV to ____ (2800 G) 28" V-262			
	18	Record: pH 10.1 & adj to 11.4-11.6 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	22	7-D	11
		Siphon into SV & Record: pH 11.5			
	19	Heat to 190-194°F in 40-45 min & Record: HT 190 F & Rec 190 °F			
		Note: Strike must be started immediately on completion of heating			
343	20	While heating SV, run 57" (1570 G) water into V-343			
&	21	Meter in from V-386 M 29 7.12#/Gal 32.7 Gal		27-D	300
386	22	Stir 15 min or longer for S 26			
5		Record density 1.012 g/mL (1.012-1.014)			
SV	23	When S 19 heating complete Record: pH 9.9 (9.6-10.2)			
6	24	Set V-343 acid pump at 80 setting (±225 min)			
	25	Set V-349 silicate pump at 67 setting (±180 min)			
	26	Immediately meter in V-343 + V-349 Maintain SV at 190-193°F during strike			

(Jbe)

K 13829 REV.

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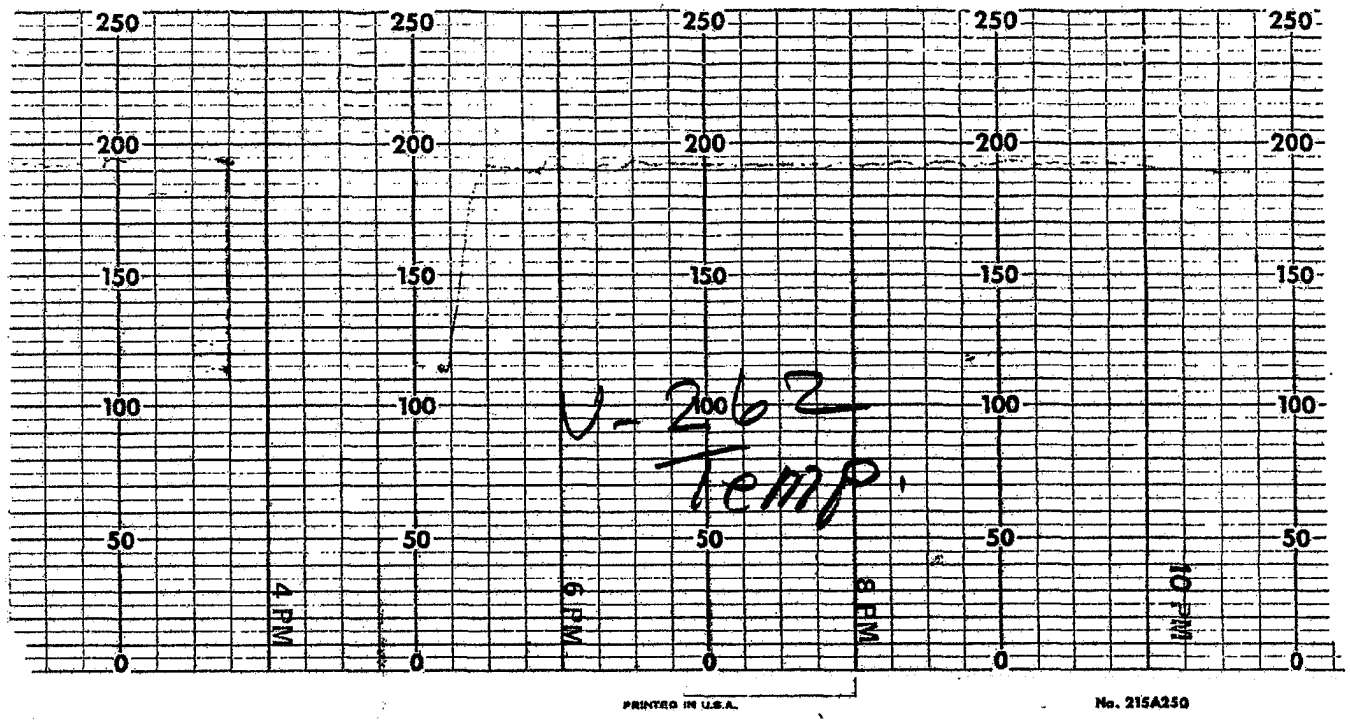
EQUIPMENT		PAGE 2 CG 03 CODE KY-781-D (M) EST. WGT. _____ LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	27	Record: Start / Finish / Minutes V-343 [illegible] / 6:15P / 245 V-349 [illegible] / 5:35P / 205			
		Record: Time / V-343 59 in / V-349 23 in / SV pH / Normal pH at 20 min 2:30 / 54(3[illegible]) 58 / 20(5) 21 / 9.65 / 9.3-10.0 40 min 2:50 / 49(3[illegible]) 52 / 18(3) 19 / 9.7 / 9.3-10.0 1 Hr 3:10 / 43(2[illegible]) 45 / 5(9) 16 / 9.65 / 9.3-10.0 2 Hrs 4:10 / 27(1[illegible]) 30 / 7(6) 8+ / 9.6 / 9.3-10.0 3 Hrs 5:10 / 11(0) 16 / (0) 2 / 9.55 / 9.3-10.0 Finish 6:15 / (0) / - / 7.85 / 7.5-8.5 Note: If pH drops below 9.3 in 1st hr, stop pumps & see Supv If final pH above 8.5. adj to (7.5-8.5) M _____ , _____ %		27-D	
357 7	28	Run 21" (150 G) water into V-357 & heat to 135-140°F			
	29	Dump in & stir to dissolve	300	15-A	300
302 8	30	Run 25" (300 G) water into V-302			
	31	Add & stir 2 min Assumes 50%	100	7-D	50
SV 9	32	When V-349 MT set pump at zero setting			
	33	When V-343 MT turn off pump motor			
	34	Drain in V-343 & V-349 lines & turn off steam			
	35	Run in V-357 from S 29 & stir 5 min			
	36	Record: pH 3.5 (3.3-3.7) & if necessary adj (down only) to 3.3-3.7 & Record: pH _____		15-A	
		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			
	37	Run in N-7-D from S 31 in 4-6 min & stir 5 min			
	38	Record: pH 4.1 (4.2-4.4) & if necessary adj to pH 4.2-4.4 & Record: pH 4.2 M _____ , _____ %		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	12	7-D	6
		Siphon N-7-D into SV			
	39	Pour in & stir 15 min	32	978-A	32
	40	Stop agitator			

Note
HAD To Prolong Strike
N-32 Line Overflowing

Start	Fin	Optr
10:15P	11:00P	235-320
11Pm	1Am	282-381
11:00A	3:00P	120-126
3:00P	7:00PM	235-287

Step	V-~~280~~ 262 (20 RPM)	V-234, 244
9	2" ~~5"~~	10"
17	28"	54"

DUP050457233



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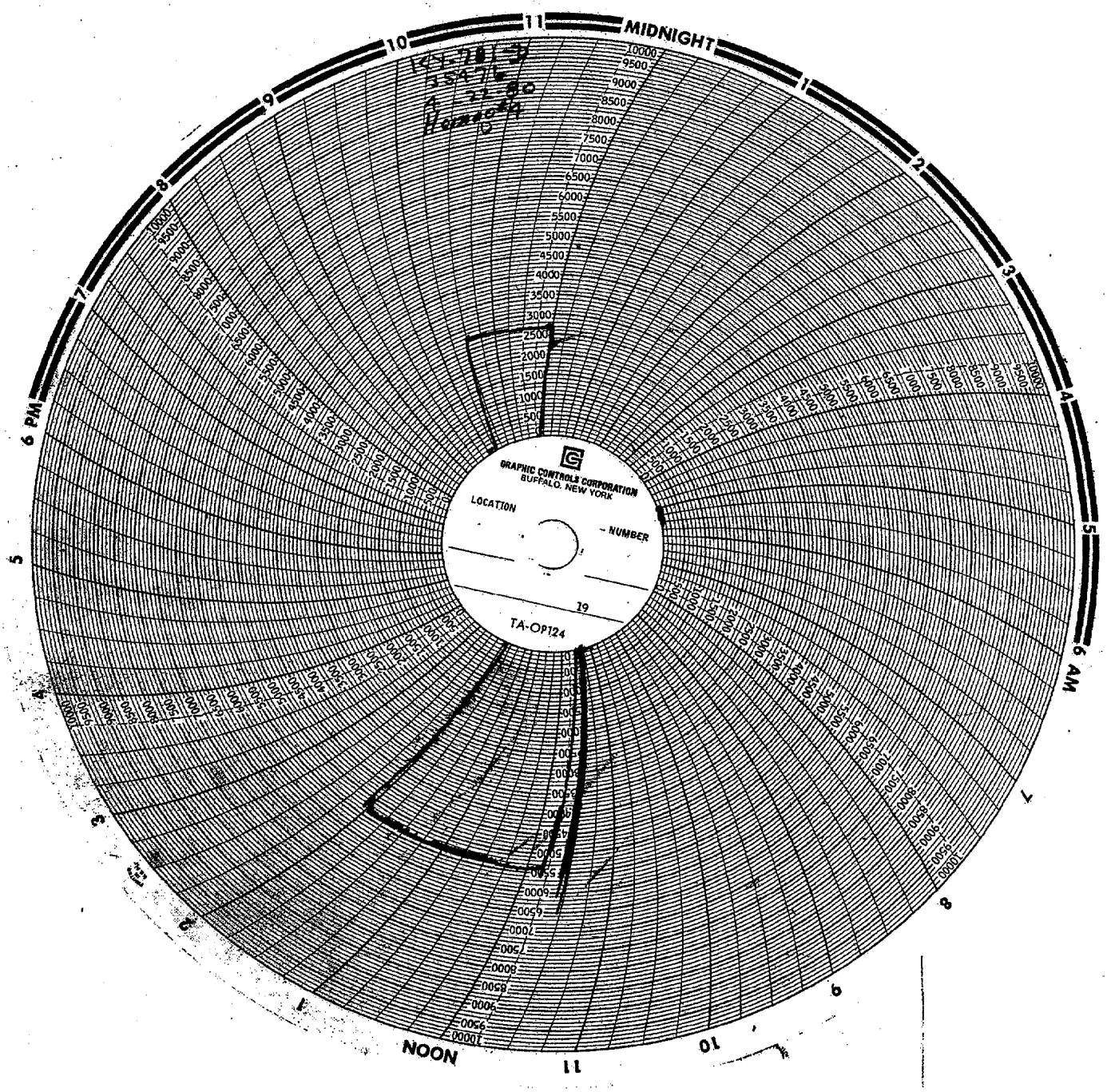

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