

MAY -0-81-21288

APPROVED BY
FMP 04/08/81

STANDARD HRS.

TIME _____ M

JOB NAME: 03KY908DME

CG	CODE	FR	LOT	LBS
14	YC003B	93	14024	2600
14	YC003B	93		
14	YC003B	93		
03	129721D	98	82946-1	50

TOTAL EST'D WGT 3549

3599

DO NOT USE YC-3-B

LOTS 14001 → 14004

Homog# 3-121 Pass

11 HA-200 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			
203	3 WEIGH SODIUM SILICATE INTO DRUM & POUR IN	345	32-D	345
	4 DUMP IN CHROME YELLOW & STIR 5 MIN	52X50	YC-3-B	2600
	5 RECORD: START 11:00 AM			
	6 FIN 12:15 AM	2600		
	7 1 x 50	129721D		50
	8 ADJUST TO 75" (1275 GAL)			
	9 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	10 HOMOG AT 2400-2600 PSI INTO V-205 263			
	11 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	12 HOT WATER AT 2400-2600 PSI INTO V-205			
	13 RECORD: V-263 VOL. 40" & ADJUST TO 60" (2100 GAL)			
	14 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	1 RUN 2" (200 GAL) WATER INTO V-262 START			
	2 AGITATOR & INSTALL TEMP CHART			
SV	3 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	4 RECORD: TIME START 5:50 AM			
	5 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	6 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	7 WHEN V-205 MT, RUN IN 5" (240 GAL) WATER & PUMP			
	8 THRU HOMOG AT 4800-5200 PSI INTO SV			
349	1 WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
	2 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	3 WEIGH INTO V-384 & PUMP TO V-349	1215	32-D	1215
	4 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	5 ADJ V-349 TO 14" (662 GAL) & STIR 15 MIN			
	6 RECORD DENSITY: 1.063 G/ML (1.063-1.065)			
SV	7 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 24" (2420 GAL)			
	8 RECORD: PH 10.3 & ADJ TO 11.0-11.2 WITH CAUSTIC			
	9 AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	10 ASSUME 50%	40	7-D	20
	11 SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	12 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F			
	13 & RECORD: 192°F			
	14 NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	15 ON COMPLETION OF HEATING			
349	1 WHILE HEATING SV, RUN 31" (850 GAL) WATER INTO V-349			
	2 MEYER III SULFURIC ACID FROM V-384			
	3 MK 14 - 1092# / GAL, 165 GAL			
384	4 STIR 15 MIN OR LONGER		27-D	180
	5 RECORD: DENSITY 1.014 G/ML (1.014-1.016)			

V-262 9.8

126 WHEN S 20 HEATING COMPLETE, RECORD: PH
127 SET V-343 ACID PUMP AT 56 SETTING (180 MIN)
127 SET V-349 SILICATE PUMP AT 49 SETTING (145 MIN)
128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
SV AT 190-194°F DURING STRIKE

25 RECORD: START FINISH MINUTES
V-343 12:15 PM 3:30 PM 185
V-349 2:45 PM 150
V-343 V-349 SV NORMAL
TIME INCHES INCHES PH PH
AT 20 MIN 12:35 P (28) (12) 9.6 (9.3-10.0)
40 MIN 12:55 P (24) 24 (10) 10 9.6 (9.3-10.0)
1 HR 1:15 P (21) 21 (8) 8 9.6 (9.3-10.0)
2 HR 2:15 P (10) 10 (3) 4 9.6 (9.3-10.0)
FINISH 3:15 P (0) (0) 8.9 (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 7.7 ASSUME 77%

130 SIFT IN

27-D 3
128-A 50

385 131 RUN 27" (210 G) WATER INTO V-385 & HEAT TO
7 135-140°F

132 DUMP IN & STIR TO DISSOLVE FOR S-60

415 15-A 415

302 133 ADD 24" (294 G) WATER TO V-302

8 134 ADD & STIR FOR 2 MIN FOR S 62

ASSUME 50% 100 7-D 50

135 DURING STRIKE PUMP INTO PT

312 169-A 312

PT 136 PUMP IN

36 155-A 36

9 137 PUMP IN

36 160-A 36

138 STIR 10 MIN WITH LIGHTENING MIXER FOR S 42

139 DURING STRIKE RUN 14" (244 G) WATER INTO V-356

140 TURN ON STEAM

356 141 ADJ TO 18" (317 G) AT 81-82°C

10 142 PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE
DISTRIBUTORS AS FAST AS POSSIBLE

143 RINSE PT WITH HOT WATER FROM HOT WATER MIXER
& PUMP IN

144 SHUT OFF PUMP

145 STIR 30 MIN AT 81-82°C FOR S 54

146 DO NOT SHUT OFF AGITATOR

SV 14 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
11 48 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
48 HEAT TO 198-200°F IN 5-10 MIN
50 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP
51 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET
52 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER
53 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER
54 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
55 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
56 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER
57 TURN OFF HOMOG & STEARATE PUMP
58 STIR 5 MIN AT 198-200°F
59 SHUT OFF STEAM
60 RUN IN V-385 FROM S-32 & STIR 5 MIN
RECORD: PH 3.6 (3.3-3.7)
61 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)
& RECORD: PH
62 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
63 RECORD: PH 4.0 (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
64 DO NOT STOP AGITATOR

	START	FINISH	OPERATOR
	12:11S	7:00 AM	235-244
	2:00 AM	3:00 PM	381-223
	3:00 PM	5:00 PM	409-54
STEP	V-262 (20 RPM)	V-243, 244, 246, 247	
9	2"	4"	
18	24"	47"	

27-D

7-D