

CB 46 CODE YT-808-D PK2.

MAY -0-81-1275

CST, UGT. 2238 LBS.

TIME M

| PROCESSES    |              | APPROVED BY |          |
|--------------|--------------|-------------|----------|
| ( )          | YT-808-D (D) | ENK         | 9/27/77  |
| ( )          | YT-810-D (D) | BBK         | 10/14/77 |
| ( )          | ( )          | DCG         | 10/17/77 |
| ( )          | ( )          | MTW         | 10/18/77 |
| TYPED BY     |              |             |          |
| JIC 10/26/77 |              |             |          |

EAST-PRESS

## NON-BLEEDING

| PHASE | NAME: DALAMAR® YELLOW                                         | USE LBS. | N CODE | ACCT. LBS. |
|-------|---------------------------------------------------------------|----------|--------|------------|
| PREP  | 1 Obtain for S 5                                              |          | 157-C  |            |
|       | 2 Obtain for S 22                                             |          | 46-C   |            |
|       | 3 Clean, dress, close 24" clarif press - 15 frames            |          |        |            |
| DV 2  | 4 Run 10" (323 G) water into V- 300                           |          |        |            |
|       | 5 Weigh in from V-324 M 2 32.00% 1431                         |          | 28-D   | 458        |
|       | 6 Dump & rinse in drums from ST                               |          | 157-C  | 974        |
|       | LOT # 100%                                                    | %        |        |            |
|       | 296 128                                                       | 73.3     | 175    |            |
|       | 296 134                                                       | 71.4     | 175    |            |
|       | 296 130                                                       | 69.1     | 175    |            |
|       | 296 131                                                       | 74.4     | 175    |            |
|       | 296 731                                                       | 74.7     | 175    |            |
|       | 296 132                                                       | 75.4     | 175    |            |
| e1    | 296 133                                                       | 73.8     | 175    |            |
|       | 307 39                                                        | 71.6     | 155    |            |
|       | 296 42                                                        | 76.4     | 55     |            |
|       |                                                               |          |        |            |
|       |                                                               |          |        |            |
|       |                                                               |          |        |            |
|       |                                                               |          |        |            |
|       |                                                               |          |        |            |
|       |                                                               |          |        |            |
|       |                                                               |          |        |            |
|       | 7 Stir 10 min or longer to wet                                |          |        |            |
|       | 8 Add to 33" (1155 G) at 28-32°F                              |          | 57-A   | 421        |
|       | 9 Siphon in in 12-15 min M 7 32.93% 1230                      |          | 725-A  | 405        |
|       | 10 Stir 30 min at 28-32°F maintaining + CR, + KI for S 12     |          |        |            |
|       | RECORD: Time Start 12:10 CR (+), KI (+)                       |          |        |            |
|       | NOTE:                                                         |          |        |            |
|       | (1) If CR-, KI-, add 20# "as is" increments Assume 32%        |          | 28-D   |            |
|       | RECORD: CR (+), KI (+)                                        |          |        |            |
|       | (2) If CR+, KI-, add 20# "as is" increments Assume 33%        |          | 725-A  |            |
|       | RECORD: CR (+), KI (+)                                        |          |        |            |
| MISC  | 11 Slurry in 40 Gal water in drum & precoat clarif press with | 5        | 777-A  | 5          |
|       | 12 When S 10 stir complete, dump in                           | 15       | 113-A  | 15         |
|       | 13 Dump in                                                    | 10       | 777-A  | 10         |
|       | 14 Stir 30 min at 28-32°F maintaining + CR, + KI for S 20     |          | 57-A   |            |
|       | RECORD: Time Start 12:30 CR (+), KI (+)                       |          |        |            |
|       | NOTE:                                                         |          |        |            |
|       | (1) If CR-, KI-, add 20# "as is" increments Assume 32%        |          | 28-D   |            |
|       | RECORD: CR (+), KI (+)                                        |          |        |            |
|       | (2) If CR+, KI-, add 20# "as is" increments Assume 33%        |          | 725-A  |            |
|       | RECORD: CR (+), KI (+)                                        |          |        |            |

| EQUIPMENT |    | PAGE 2 CG 46 CODE YT-808-D (D) EST. WGT. 2238 LBS.                                                                                                                                 | USE LBS.   | N CODE | ACCT. LBS. |
|-----------|----|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|--------|------------|
| CV 5      | 15 | Run 10" (970 G) water into V-105 & install temp chart                                                                                                                              |            |        |            |
|           | 16 | Pour in M 8, 49.83 % 935                                                                                                                                                           |            | 7-D    | 466        |
|           | 17 | Adj to 40" (3904 G) at 66-70°F                                                                                                                                                     | 3 x 330    | 57-A   |            |
|           | 18 | Close stack damper                                                                                                                                                                 |            |        |            |
|           | 19 | Stir for S 22                                                                                                                                                                      |            |        |            |
| DV 6      | 20 | When S 14 stir complete, test DV & record                                                                                                                                          |            |        |            |
|           |    | CR + (+), KI + (+) Temp: 31 (28-32°F)                                                                                                                                              |            | 57-A   |            |
|           |    | NOTE:                                                                                                                                                                              |            |        |            |
|           |    | (1) If CR-, KI-, add 20# "as is" increments Assume 32%                                                                                                                             |            | 28-D   |            |
|           |    | RECORD: CR (+), KI (+)                                                                                                                                                             |            |        |            |
|           |    | (2) If CR+, KI-, add 20# "as is" increments Assume 33%                                                                                                                             |            | 725-A  |            |
|           |    | RECORD: CR (+), KI (+)                                                                                                                                                             |            |        |            |
|           | 21 | Pump DV thru clarif press into V-343 maintaining temp at 28-32°F RECORD: Time Start 1:00 AM Total Min 100                                                                          | 2 x 330    | 57-A   | 660        |
| CV 7      | 22 | Dump into CV from S 2 LOT #100% %                                                                                                                                                  |            | 46-C   | 1265       |
|           |    | NOTE: BREAK UP LUMPS 80.597 1200 100% 1200                                                                                                                                         |            |        |            |
|           |    | 61.360 6.5 94.6 69                                                                                                                                                                 |            |        |            |
|           |    |                                                                                                                                                                                    |            |        |            |
|           | 23 | Stir 10 min to dissolve                                                                                                                                                            |            |        |            |
|           | 24 | Open stack damper                                                                                                                                                                  |            |        |            |
|           | 25 | Run in undersurface in 20-25 min M 77.00 % 976                                                                                                                                     |            | 30-D   | 713        |
|           | 26 | Stir 5 min & Record: pH 5.7 (5.8-6.3)                                                                                                                                              |            |        |            |
|           | 27 | If necessary, adj to pH 5.8-6.3 and                                                                                                                                                | Assume 50% | 7-D    |            |
|           |    | RECORD: pH (5.8-6.3)                                                                                                                                                               | Assume 77% | 30-D   |            |
| DV 8      | 28 | When S 21 clarif complete, wash DV (S 4) lines, pump & press for 20 min or to a -CR test on a sample to total press effluent, whichever comes first. Collect washings in DV (S 21) |            |        |            |
|           |    | RECORD: Time Start 2:00 AM CR - (- or +)                                                                                                                                           |            |        |            |
|           | 29 | Stir 5 min & Record: Temp 30 (28-32°F) & if necessary, adj to 28-32°F. RECORD: °F                                                                                                  |            | 57-A   |            |
|           | 30 | Weigh in rubber bucket & wash into DV                                                                                                                                              |            |        |            |
|           | 31 | Stir 5 min & RECORD: KI (-)                                                                                                                                                        |            |        |            |
|           | 32 | If necessary, adj to KI & RECORD: KI                                                                                                                                               |            | 30-D   |            |
|           | 33 | RECORD: DV 49 "                                                                                                                                                                    |            |        |            |
|           |    |                                                                                                                                                                                    |            |        |            |
| MISC 9    | 34 | Weigh in drums for S 41 M 8, 49.83 % 594                                                                                                                                           |            | 7-D    | 296        |
|           | 35 | Dissolve in 20 gal water in drum for S 43                                                                                                                                          | 62         | 979-A  | 62         |
| CV 10     | 36 | When S 33 complete, adj CV to 48" (4685 G) at 80-84°F                                                                                                                              |            |        |            |
|           | 37 | Check accuracy: HT 83 °F & Recorder 84 °F                                                                                                                                          |            |        |            |
|           | 38 | Immediately run in DV thru undersurface distributor in 60-65 min. Maintain CV at 80-84°F                                                                                           |            |        |            |
|           |    | RECORD: Time Start 4:50 AM Total Min 60                                                                                                                                            |            |        |            |
|           | 39 | When S 38 complete, stir 10 min                                                                                                                                                    |            |        |            |

| EQUIPMENT            | PAGE | 3                                                    | CG                                                     | 46      | CODE | YT-808-D (D) | EST. WGT.      | 2238       | LBS.      | USE        | N    | ACCT. |
|----------------------|------|------------------------------------------------------|--------------------------------------------------------|---------|------|--------------|----------------|------------|-----------|------------|------|-------|
|                      |      |                                                      |                                                        |         |      |              |                |            |           | LBS.       | CODE | LBS.  |
| CV<br>80<br>(Cont'd) | 40   | RECORD:                                              | Diazo                                                  | -       | Base | +            | pH             | 4.3        | (4.3-4.7) |            |      |       |
|                      |      | NOTE:                                                |                                                        |         |      |              |                |            |           |            |      |       |
|                      |      | (1)                                                  | If Diazo +, Base -, and pH below 4.3:                  |         |      |              |                |            |           |            |      |       |
|                      |      | (a)                                                  | adj to pH 4.3-4.7                                      |         |      |              |                |            |           | Assume 50% | 7-D  |       |
|                      |      | (b)                                                  | record: pH                                             |         |      |              |                |            |           |            |      |       |
|                      |      | (2)                                                  | If Diazo +, Base -, and pH 4.3 or above:               |         |      |              |                |            |           |            |      |       |
|                      |      | (a)                                                  | add 8% 100% N-7-D to a 55 G drum                       |         |      |              |                |            |           | 7-D        |      |       |
|                      |      | (b)                                                  | adj with water to ± 25 G                               |         |      |              |                |            |           |            |      |       |
|                      |      | (c)                                                  | add 20% 100% N-46-C                                    |         |      |              |                |            |           | 46-C       |      |       |
|                      |      | (d)                                                  | stir to dissolve                                       |         |      |              |                |            |           |            |      |       |
|                      |      | (e)                                                  | pour into CV                                           |         |      |              |                |            |           |            |      |       |
|                      |      | (f)                                                  | stir 10 min                                            |         |      |              |                |            |           |            |      |       |
|                      |      | (3)                                                  | Repeat (1) & (2) above as necessary to - Diazo, + Base |         |      |              |                |            |           |            |      |       |
|                      |      | 41                                                   | Pour in N-7-D from S 34 & stir 5 min                   |         |      |              |                |            |           |            |      |       |
|                      |      | 42                                                   | RECORD:                                                | pH      | 6.6  | (8.0-8.5)    | & if necessary | Assume 50% | 26        | 7-D        | 13   |       |
|                      |      | Adj to pH                                            | 8.0-8.5.                                               | RECORD: | pH   | 8.5          | Assume 32%     | 18         | 28-D      | 6          |      |       |
|                      | 43   | Dump in N-979-A from S 35                            |                                                        |         |      |              |                |            |           |            |      |       |
|                      | 44   | Heat to 190-194°F in 58-62 min                       |                                                        |         |      |              |                |            |           |            |      |       |
|                      | 45   | Stir 60 min at 190-194°F RECORD: Time Start 10:10 AM |                                                        |         |      |              |                |            |           |            |      |       |
|                      | 46   | Flood to 94" (9174 G) & stop agitator                |                                                        |         |      |              |                |            |           |            |      |       |
|                      |      | START                                                | FIN                                                    | OPTP    |      |              |                |            |           |            |      |       |
|                      |      | 9:00 P                                               | 11:00 P                                                | 259     |      |              |                |            |           |            |      |       |
|                      |      | 11:00 AM                                             | 7:00 AM                                                | 320     |      |              |                |            |           |            |      |       |
|                      |      | 7:00 AM                                              | 7:20 AM                                                | 20      |      |              |                |            |           |            |      |       |

