

OCT-29 00 37643

() KY-907-D (F)

FWF 10/20/80

STANDARD HRS.

TIME 11A M

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TYPED BY: FWF 10/20/80

CG	CODE	PQ	LOT	LBS
14	YC002B	93	13199	100
14	YC002B	93	13195	4000
14	YC002B	93	13182	100

TOTAL EST'D WGT 6053

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	NCODE	ACCT LBS
203	RUN 60" (990 GAL) WATER INTO V-203 & ADD CAUSTIC	40	7-D	20
&	RUN AGITATOR ON HIGH SPEED			
205	WEIGH SODIUM SILICATE INTO DRUM & POUR IN	560	32-D	560
	DUMP IN CHROME YELLOW & STIR 5 MIN	84X50	YC-2-B	4200
	RECORD: START			
	FIN			
	ADJUST TO 75" (1275 GAL)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	HOMOG AT 2400-2600 PSI INTO V-205			
	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL. 35" & ADJUST TO 60" (2100 GAL)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 5" (200 GAL) WATER INTO V-208 START			
&	AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 7:10 PM TOTAL MINUTES 180			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	WHEN V-205 MT, RUN IN 5" (240 GAL) WATER & PUMP			
	THRU HOMOG AT 4800-5200 PSI INTO SV			
349	WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
&	RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	WEIGH INTO V-384 & PUMP TO V-349	3220	32-D	3220
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN			
	RECORD DENSITY: 1.138 G/ML (1.138-1.142)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 11" (2420 GAL)			
	RECORD: PH 10.3 & ADJ TO 11.1-11.3 WITH CAUSTIC			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%			
	SIPHON N-7-D INTO SV & RECORD: PH 11.3			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 198°F			
	& RECORD: 194°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	ON COMPLETION OF HEATING			
	WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343			
343	METER IN SULFURIC ACID FROM V-384			
&	MK 64 2968# / GAL 53.6 GAL			
	STIR 15 MIN OR LONGER			
5	RECORD: DENSITY 1.032 G/ML (1.030-1.033)			

125 WHEN S 20 HEATING COMPLETE, RECORD: PH 9.6
 126 SET V-343 ACID PUMP AT 57 SETTING (225 MIN)
 127 SET V-349 SILICATE PUMP AT 48 SETTING (180 MIN)
 128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 SV AT 190-194°F DURING STRIKE

129 RECORD: START FINISH MINUTES
 V-343 1:00 4:55 AM 235
 V-349 1:00 4:00 180

V-343 V-349 SV NORMAL
 TIME INCHES INCHES PH PH
 AT 20 MIN 1:00 (36) (15) 9.5 (9.3-10.0)
 40 MIN 1:40 (33) (13) 9.5 (9.3-10.0)
 1 HR 3:00 (29) (11) 9.5 (9.3-10.0)
 2 HR 3:20 (19) (6) 9.5 (9.3-10.0)
 3 HR 4:00 (8) (0) 9.4 (9.3-10.0)
 FINISH 4:55 (0) (0) 6.5 (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 ASSUME 77%

130 SIFT IN 50 27-D 128-A 50

385 131 RUN 40" (308 G) WATER INTO V-385 & HEAT TO
 7 135-140°F

132 DUMP IN & STIR TO DISSOLVE FOR S-60 280 15-A 280

302 133 ADD 17" (208 G) WATER TO V-302
 8 134 ADD & STIR FOR 2 MIN FOR S 62

2 DRUMS
 ASSUME 50% 50 72-D 50

135 DURING STRIKE PUMP INTO PT

PT 136 PUMP IN

9 137 PUMP IN

138 STIR 10 MIN WITH LIGHTENING MIXER FOR S 42

558 169-A 558

62 155-A 62

62 160-A 62

139 DURING STRIKE RUN 18" (317 G) WATER INTO V-356

140 TURN ON STEAM

356 141 ADJ TO 23" (403 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 42 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
49 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 3.3. (3.3-3.7)
61 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)
& RECORD: PH 3.3.
62 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
RECORD: PH 4.3. (4.2-4.4) & IF NECESSARY, ADJ
TO PH 4.2-4.4 & RECORD: PH 4.3. ASSUME 78%
(DILUTE 40 PARTS TO 1 WITH WATER) ASSUME 50%
SIPHON N-7-D INTO SV
64 DO NOT STOP AGITATOR

START

FINISH

OPERATOR

3:08 PM
11: PM11:00 AM
6: AM320-244
223

STEP	V-262 (20 RPM)	V-243, 244, 246, 247
9	2"	4"
18	24"	47"

27-D

7-D