

CG 03 CODE KY-908-D

R2H73

MAY 28 1982

PROCESSSES

APPROVED BY

STANDARD HRS.

TIME _____ M

() KY-908-D (F)

FWP 03/26/82

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JOB NAME: 03KY908DMF

CG CODE PQ

LOT

LBS

14 YC-3-B 93

14774 2600

(2)

14 YC-3-B 93

13069

NOTE

YC-3

JUN 8 1982

EST. WT. 6110* LBS.

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	NCODE	ACCT LBS
203	1 BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF.			
	2 RUN 60" (990 GAL) WATER INTO V-203			
	3 RUN AGITATOR ON HIGH SPEED			
V-203	2 WEIGH SODIUM SILICATE INTO DRUM & POUR IN	610	32-D	610
	3 DUMP IN CHROME YELLOW & STIR 5 MIN	92X50	YC-3-B	4600
1	RECORD: START 5:15 AM 14274	2600		
	FIN 5:55 AM 13069	2000		
	4 ADJUST TO 75" (1275 GAL) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-203 V-263			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2400-2600 PSI INTO V-203 V-263			
	7 RECORD: V-203 VOL. 46" & ADJUST TO 60" (2100G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 4" (200 GAL) WATER INTO V-240, START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
V-263	RECORD: TIME START 5:12 PM TOTAL MINUTES 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 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	2150	32-D	2150
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 20" (946 GAL) & STIR 15 MIN			
	17 RECORD DENSITY: 10.78 G/ML (1.077-1.080)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 48" (2420G)			
	19 RECORD: PH 9.6 & ADJ TO 11.0-11.2 WITH CAUSTIC			
4	AT 5% (10 PARTS WATER TO 1 PART N7D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH 11.2	36	7-D	18
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____ °F & RECORD: _____ °F NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N39285

LOT

240

DATE PRINTED: 3/26/82

EQUIP MENT	PAGE 2 CG 03 KY-908-D	USE	N-	ACCT
	COMTYP JOB NAME: 03KY908DMF	LBS	CODE	LBS

343	21	WHILE HEATING SV, RUN 45" (1237G) WATER INTO V343			
	22	METER IN SULFURIC ACID FROM V-386			
		MK 12 10.318/GAL 30.8 GAL			
386	23	STIR 15 MIN OR LONGER		27-D	318
5	24	RECORD: DENSITY 1.016 G/ML (1.015-1.016)			

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.8			
	26	SET V-343 ACID PUMP AT 64 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 57 SETTING (180 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
		AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 10:55P			
		V-349			
		V-343 V-349 SV NORMAL			
		TIME INCHES INCHES PH PH			
		AT 20 MIN 11:15 (42) (18) 9.7 (9.3-10.0)			
		40 MIN 11:35 (38) (15) 9.7 (9.3-10.0)			
		1 HR 11:55 (34) (13) 9.7 (9.3-10.0)			
		2 HR 12:55 (22) (6) 8.4 (9.3-10.0)			
		3 HR 1:15 (11) (0) 7.6 (9.3-10.0)			
		FINISH 2:40P 0) (0) 7.6 (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%			
	30	SIFT IN	50	27-D	128-A 50

385	31	ADD 42" (320 G) WATER TO V-385			
7	32	ADD & STIR FOR 2 MIN FOR S 31 (1D) ASSUME 50%	160V	7-D	80

	33	DURING STRIKE CHECK LEVEL IN V-387			
387	34	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37			
8	35	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING			
		THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	36	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW			
		STEARATE MAKE-UP PROCEDURE.			

388	37	RUN IN 32" (317 GAL). DO NOT MAKE UP THIS			
		SOLUTION MORE THAN 30 MINUTES IN ADVANCE.			
9		DELAY BETWEEN END OF STEP 43 HEAT-UP AND			
		START OF STEP 52 HOMOGENIZATION SHOULD BE			
		LESS THAN 30 MINUTES.			
	38	TURN ON STEAM & AGITATOR			
	39	ADJ TO 42" (403 G) AT 178-182°F			
	40	SET BADGER METER FOR 698#			
	41	PUMP IN FROM V-387 THRU UNDERSURFACE	570	169-A	570
		DISTRIBUTORS AS FAST AS POSSIBLE	64	155-A	64
			64	160-A	64
	42	SHUT OFF PUMP			
	43	STIR 30 MIN AT 178-182°F FOR S 52			
	44	DO NOT SHUT OFF AGITATOR			

SV	45	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &			
10		SET PUMP AT ZERO SETTING			
	46	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &			
		TURN OFF PUMP MOTOR			

LOT

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EQUIP MENT	PAGE 3 CG 03 KY-908-D COMTYP JOB NAME: 03KY908DMF	USE LBS	N- CODE	ACCT LBS
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SV 10	47	HEAT TO 198-200°F IN 5-10 MIN			
	48	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
	49	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
	50	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
	51	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
	52	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
	53	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
	54	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
	55	TURN OFF HOMOG & STEARATE PUMP			
	56	STIR 5 MIN AT 198-200°F			
	57	SHUT OFF STEAM			
	58	RUN IN ALUM USING BADGER METER	830	115-D	415
	59	FLUSH ALUM LINE WITH WATER			
	60	RECORD PH <u>3.6</u> (3.3-3.7). IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD PH NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%		115-D	
	61	RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
	62	RECORD: PH <u>4.4</u> (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%		27-D	
		SIPHON N-7-D INTO SV.		7-D	
	63	DO NOT STOP AGITATOR			

START

FINISH

OPERATOR

5:30 P
11 PM
11:00 P
SAI
126-301
282-023

63
92
10-5

