

STANDARD HRS.

TIME _____ M

 () KY-907-D (F) FWP 12/16/80
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 () ()
 COMTYP JOB NAME: 03KY907DMG

CG	CODE	PQ	LOT	LBS	CG	CODE	PQ	LOT	LBS
14	YC002B	93	13488	400	14	YC002B	93	13477	2000
14	YC002B	93	13479	2000	14	YC002B	93	14488	400

 TOTAL EST'D WGT 7236 DEC 30 1980 *Homog # 3 - 1st Pass* 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			
203	WEIGH SODIUM SILICATE INTO DRUM & POUR IN	690	983-D	690
	DUMP IN CHROME YELLOW & STIR 5 MIN	100X50	YC-2-B	5000
	RECORD: START <i>8:30</i>			
	FIN <i>10:30</i>			
	ADJUST TO 75" (1275 GAL)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	HOMOG AT 2400-2600 PSI INTO V-205 <i>263</i>			
	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V- <i>2250</i> L. & ADJUST TO 60" (2100 GAL)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	RUN 2" (200 GAL) WATER INTO V- <i>262</i> START			
	AGITATOR & INSTALL TEMP CHART			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <i>3:40A</i> TOTAL MINUTES <i>120</i>			
	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	3970	983-D	3970
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	ADJ V-349 TO 22" (1041 GAL) & STIR 15 MIN			
	RECORD DENSITY: <i>1.129</i> G/ML (1.128-1.129)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO <i>24</i> (2420 GAL)			
	RECORD: PH <i>10.8</i> & ADJ TO 11.1-11.3 WITH CAUSTIC			
	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%			
	SIPHON N-7-D INTO SV & RECORD: PH <i>11.3</i>	<i>15</i>	7-D	<i>7</i>
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT <i>192</i> °F			
	& RECORD: <i>192</i> °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-386			
	MK31- <i>9.64</i> #/GAL <i>59.6</i> GAL			
384	STIR 15 MIN OR LONGER		27-D	575
	RECORD: DENSITY <i>1.038</i> G/ML (1.037-1.039)			

N34693

25		WHEN S 20 HEATING COMPLETE, RECORD: PH <u>10.3</u>			
26		SET V-343 ACID PUMP AT 57 SETTING (225 MIN)			
27		SET V-349 SILICATE PUMP AT 62 SETTING (180 MIN)			
SV	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
	29	AT 190-194°F DURING STRIKE			
RECORD:		START FINISH MINUTES			
		V-343 <u>7:20</u> <u>10:30</u> <u>190</u>			
		V-349 <u>7:20</u> <u>11:05</u> <u>225</u>			
		V-343 V-349 SV NORMAL			
		TIME INCHES INCHES PH PH			
6	AT 20 MIN	<u>7:40</u> (36) <u>37</u> (20) <u>19</u> <u>9.8</u> (9.3-10.0)			
	40 MIN	<u>8:20</u> (33) <u>33</u> (17) <u>17</u> <u>9.8</u> (9.3-10.0)			
	1 HR	<u>8:50</u> (29) <u>30</u> (15) <u>15</u> <u>9.8</u> (9.3-10.0)			
	2 HR	<u>9:20</u> (19) <u>20</u> (7) <u>7</u> <u>9.3</u> (9.3-10.0)			
	3 HR	<u>10:00</u> (8) <u>8</u> (0) <u>1</u> <u>9.3</u> (9.3-10.0)			
	FINISH	<u>11:05</u> (0) (0) <u>0</u> <u>7.5</u> (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	200	27-D	200
385		31 RUN 40" (308 G) WATER INTO V-385 & HEAT TO			
7		135-140°F			
32		DUMP IN & STIR TO DISSOLVE FOR S-60	330	15-A	330
302		133 ADD 17" (208 G) WATER TO V-302			
8		134 ADD & STIR FOR 2 MIN FOR S 62 ASSUME 50%	120	7-D	60
35		DURING STRIKE PUMP INTO PT	660	169-A	660
PT 36		PUMP IN	72	155-A	72
9		37 PUMP IN	72	160-A	72
38		STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			
39		DURING STRIKE RUN 18" (317 G) WATER INTO V-356			
40		TURN ON STEAM			
356		41 ADJ TO 23" (403 G) AT 81-82°C			
10	42	PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE			
	43	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN			
44		SHUT OFF PUMP			
45		STIR 30 MIN AT 81-82°C FOR S 54			
46		DO NOT SHUT OFF AGITATOR			

- SV 147 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
- 11 148 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
- 149 HEAT TO 198-200°F IN 5-10 MIN
- 150 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP
- 151 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET
- 152 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER
- 153 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER
- 154 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
- 155 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
- 156 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER
- 157 TURN OFF HOMOG & STEARATE PUMP
- 158 STIR 5 MIN AT 198-200°F
- 159 SHUT OFF STEAM
- 160 RUN IN V-385 FROM S-32 & STIR 5 MIN
RECORD: PH 3.5 (3.3-3.7)
- 161 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)
& RECORD: PH _____
- 162 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- 163 RECORD: PH 4.2 (4.2-4.4) & IF NECESSARY, ADJ
TO PH 4.2-4.4 & RECORD: PH _____ ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
- SIPHON N-7-D INTO SV
- 164 DO NOT STOP AGITATOR

27-D
7-D

START	FINISH	OPERATOR
<u>10:30P</u>	<u>11:00P</u>	<u>235</u>
<u>700A</u>	<u>100P</u>	<u>120-126</u>

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



