

MAY -0.81-31319

STANDARD HRS.

TIME ----- M

PROCESSES () KY-908-D (E) APPROVED BY FWP 04/08/81
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JOB NAME: 03KY908DME

CG CODE PQ LOT LBS
14 YC003B 93 14024 - 1200
14 YC003B 93 13676 - 800
14 YC003B 93 14017 150
03 KY 781D 98 82946-1 50
TOTAL EST'D WGT 3549 3599

DO NOT USE

Homog #3 - 1st Pass
11 03-2nd Pass

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	NCODE	ACCT LBS
203	1 RUN 60" (990 GAL) WATER INTO V-203			
	& RUN AGITATOR ON HIGH SPEED			
203	2 WEIGH SODIUM SILICATE INTO DRUM & POUR IN	345	32-D	345
	3 DUMP IN CHROME YELLOW & STIR 5 MIN	52X50	YC-3-B	2600
1	RECORD: START 11:15	1200		
	FIN 12:30	800		
	4 ADJUST TO 75" (1275 GAL)	1 X 50	KY 781D	50
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU	150		
	HOMOG AT 2400-2600 PSI INTO V-205	450		
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	HOT WATER AT 2400-2600 PSI INTO V-205 263			
	7 RECORD: V-205 VOL. 40 & ADJUST TO 60" (2100 GAL)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	9 RUN 2" (200 GAL) WATER INTO V-202 START			
	& AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 5:55 AM TOTAL MINUTES 19			
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	1215	32-D	1215
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 14" (662 GAL) & STIR 15 MIN			
	17 RECORD DENSITY: 1.064 G/ML (1.063-1.065)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 24" (2420 GAL)			
	19 RECORD: PH 11.8 & ADJ TO 11.0-11.2 WITH CAUSTIC			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	40	7-D	20
	20 SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	ON COMPLETION OF HEATING			
343	21 WHILE HEATING SV, RUN 31" (850 GAL) WATER INTO V-343			
	22 METER IN SULFURIC ACID FROM V-384			
	MK 14 10.200/GAL, 16.8 GAL			
384	23 STIR 15 MIN OR LONGER		27-D	180
5	24 RECORD: DENSITY 1.015 G/ML (1.014-1.016)			

SM

V-262

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH <u>9.8</u>			
	26	SET V-343 ACID PUMP AT 56 SETTING (180 MIN)			
	27	SET V-349 SILICATE PUMP AT 49 SETTING (145 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
		AT 190-194°F DURING STRIKE			
	29	RECORD:	START	FINISH	MINUTES
		V-343	<u>12:00</u>	<u>3:15</u>	<u>2:15</u>
		V-349	<u>12:00</u>	<u>2:00</u>	<u>1:00</u>
		V-343	V-349	SV	NORMAL
		TIME INCHES	INCHES	PH	PH
6		AT 20 MIN <u>12:40</u> (28)	(12)	<u>7.6</u>	(9.3-10.0)
		40 MIN <u>12:45</u> (24)	(10)	<u>7.6</u>	(9.3-10.0)
		1 HR <u>1:00</u> (21)	(8)	<u>7.5</u>	(9.3-10.0)
		2 HR <u>2:00</u> (10)	(3)	<u>7.3</u>	(9.3-10.0)
		FINISH <u>2:45</u> (0)	(0)	<u>8.0</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	<u>50</u>	27-D	128-A 50
385	31	RUN 27" (210 G) WATER INTO V-385 & HEAT TO			
7		135-140°F			
	32	DUMP IN & STIR TO DISSOLVE FOR S-60	415	15-A	415
302	33	ADD 24" (294 G) WATER TO V-302			
8	34	ADD & STIR FOR 2 MIN FOR S 62	ASSUME 50%	100	7-D 50
PT	35	DURING STRIKE PUMP INTO PT	312	149-A	312
	36	PUMP IN	36	155-A	36
	37	PUMP IN	36	160-A	36
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			
356	39	DURING STRIKE RUN 14" (244 G) WATER INTO V-356			
	40	TURN ON STEAM			
	41	ADJ TO 18" (317 G) AT 81-82°C			
	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			

EQUIP-

PAGE 3 CG 03 KY-908-D EST WGT 35494

USE
LBSN-
CODEUSE
LBS

SV 47 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 3.0 (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 3.2 (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
<u>1:00A</u>	<u>7:00A</u>	<u>235-243</u>
<u>2:45</u>		<u>233-342</u>
<u>3:10A</u>	<u>5:47PM</u>	<u>301-54</u>
STEP V-262 (20 RPM)	V-243, 244, 246, 247	
9 2"	4"	
18 24"	47"	

27-D
7-D40