

APR 10 1983

MAKING INSTRUCTIONS BATCH UNIT

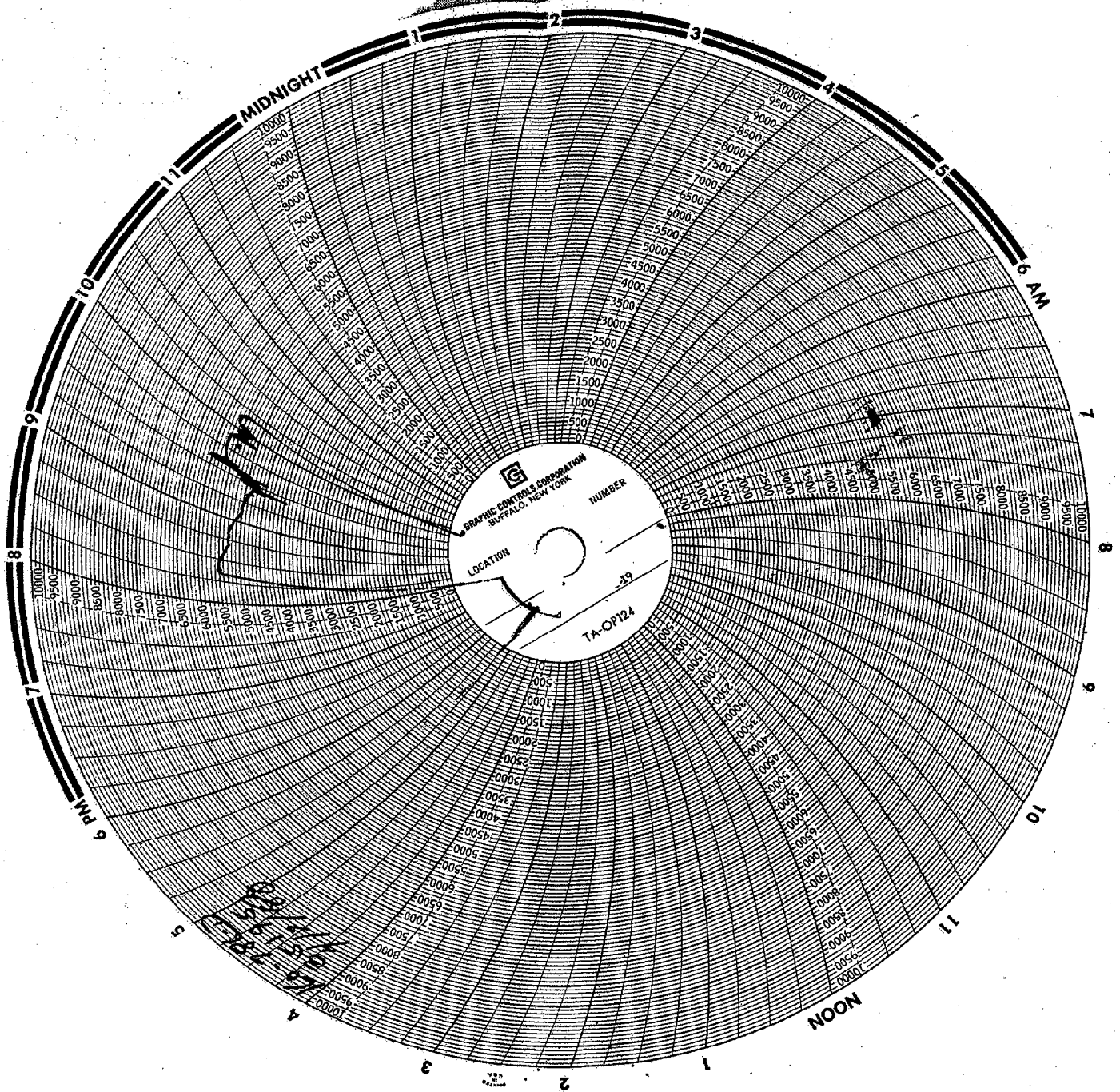
SV	248	C.V.	D.V.
CG	04	CODE	K0-786-D
EST	WGT	862	CS
STD	PRS	10.5	TIME
01	Y0-10-B	93	4
01	Y0-10-B	93	4
01	Y0-10-B	93	4
Total Weight 49627 (Reg)			

PROCESSES	APPROVED BY
K0-786-D	EWK 9-21-76
	DCG 9-21-76
	MTW 10-1-76
TYPED BY	
116-11-15-76	

EQUIPMENT	NAME	USE	N	WGT
		LES	CODE	LES
211	Run 60" (990 G) water in V-211 and add	Assume 50%	7-D	115
208	Watch in drum and pour in V-211	270	32-D	170
1	Pump in and stir 5 minutes	24	32 x 50	4100
	Record Start	24		
	Fin	24		
	Adjust to 80" (1370 G)	24		
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208	24		
	When V-211 MIV wash color thru Homog at 1800-2200 psi using minimum water	24		
	Record V-208 Vol 50 and adjust to 50" (1840 G)	24		
	Inspect Homog strainer and clean if necessary	24		
208	Run 15" (771 G) water into V-208 and start agitator and			
SV	Install temperature chart			
2	Pump V-208 thru Homog at 4200-5200 psi into SV			
	Record Time Start 8:20 AM Total Minutes 160			
	Note: If homog pressure falls below 4800 psi, 1/2 way valve			
	will recirculate slurry to V-208			
	When V-208 MIV run in 5" (240 G) water and pump thru Homog			
	at 4200-5200 psi			
349	While Homog run 6" (284 G) water into V-349			
384	Run 4000# water into V-384 and heat to 110-120°F	2400	32-D	2480
3	Weigh into V-384 and pump to V-349			
	Run 1000# water into V-384 and pump to V-349			
	Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	Record 9:52 1.673 (10.5-2) (1.017-1.031)			
SV	When 3-1 Homog complete, adjust to 60" (3400 G) in SV			
4	Record pH 4.0 and adjust to 10.4 to 8 using N-7-D diluted			
	to 5% (10 parts water to 1 part N-7-D) Assume 50%			
	Siphon N-7-D into SV and Record pH			
	Heat to 190-194°F in 35-65 minutes & Record pH 12.4 F and			
	Rec 1:22 F			
	Note: Strike must be started immediately on completion			
	of heating			
343	While heating SV, run 51" (1400 G) water into V-343			
386	Water in from V-386 M. 38 #/Gal 7.18 Gal 38.0	27-D		395
5	Stir 15 minutes or longer			
	Record 9:53 1.017 (1.017-1.019)			

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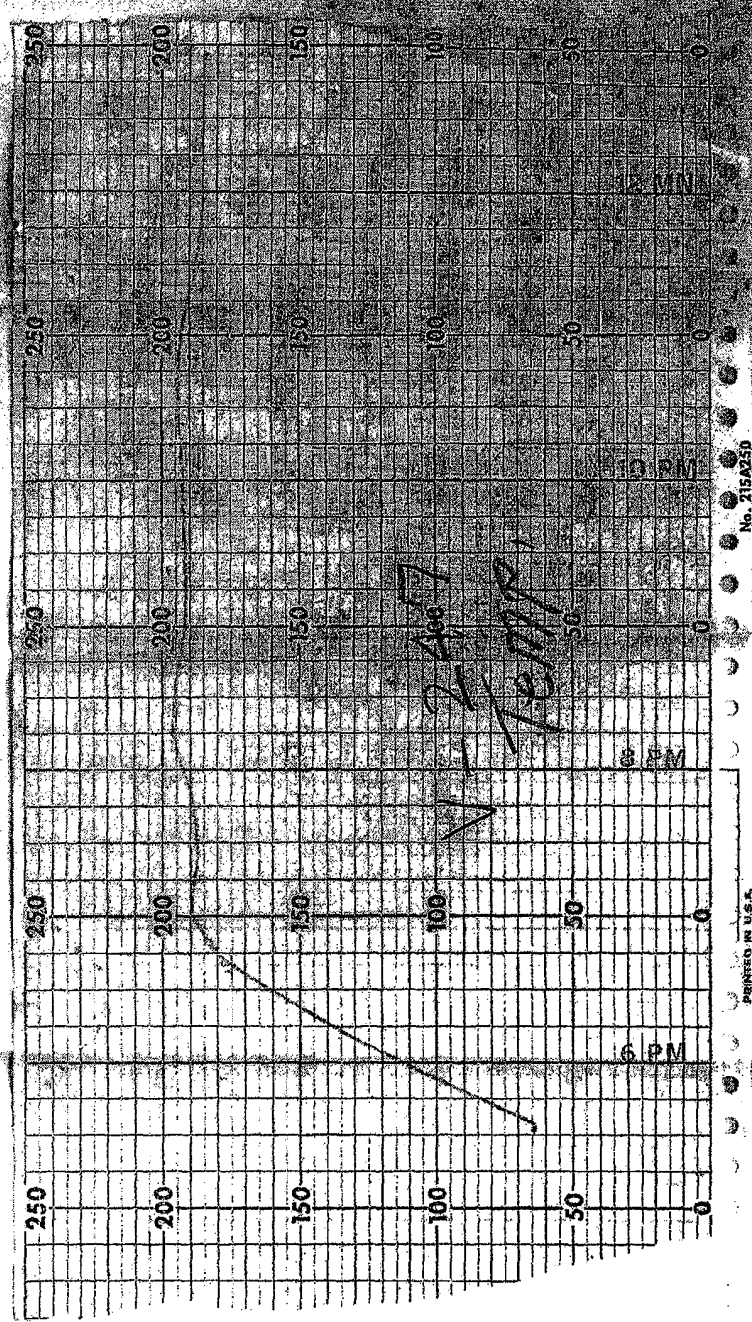
EQUIPMENT	PAGE	CODE	KG-76and (N)	Est. Weir	4962	lbs	USE	N-	CCY
							lbs	CODE	lbs
SV	2	20-04	CODE	KG-76and (N)	Est. Weir	4962			
6	25	When S-20 heating complete, Record pH 10.2 (9.6-10.2)							
	26	Set V-343 acid pump at 72 setting (325 minutes)							
	27	Set V-343 silicate pump at 66 setting (180 minutes)							
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike							
	29	Record	Start	Finish	Minutes				
		V-343	1:00	4:55 AM	235				
		V-349	1:00	4:05 AM	135				
		Record	Time	V-343	V-349	SV	NonHd		
				Inches	Inches	pH	pH		
		at 20 min	1:20	(47) 4.8	(20) 3.5	9.9	9.3-10.0		
		40 min	1:40	(43) 4.4	(17) 3.5	9.9	9.3-10.0		
		1 hr	2:00	(38) 3.9	(15) 3.2	9.9	9.3-10.0		
		2 hrs	3:00	(24) 2.6	(7) 2.5	9.95	9.3-10.0		
		3 hrs	4:00	(10) 1.2	(0) 1.0	9.8	9.3-10.0		
		Finish	4:55	(0)	(0)	8.8	7.8-8.5		
		Note	If pH drops below 9.3 in 1st hour, stop pumps and ABG supervisor. If final pH is above 8.5, adjust to 4. (7.5-8.5) and Record pH 8.4 Assume 77%						
								12	27-D
357	30	Run 21 (150 G) water into V-357 and heat to 135-140°F							
7	31	Dump in and stir acid dissolve					300	15-A	300
302	32	Add 42 (1514 G) water to V-302							
8	33	Add and stir 2 minutes					Assume 60%	150	7-D
									75
SV	34	When V-349 MTV, rinse in with minimum water then set pump to zero setting							
9	35	When V-343 MTV, rinse in with minimum water, then turn off pump motor							
	36	TURN OFF STEAM							
	37	Run in V-357 from S-31 and stir 5 minutes							
	38	Record pH 3.4 (3.3-3.7)							
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record pH 10						15-A	
	40	Run in N-7-D from S-33 in 4-6 minutes and stir 5 minutes							
	41	Record pH 4.75 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record pH 4.2 Assume 77%						10	27-D
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%							7-D
		Siphon N-7-D into SV							
	42	Stop agitator							
		START	FINISH	OPTR					
		3:00 PM	11:00 AM	124					
		11:00 PM	11:00 AM	235					



N32427.01

DUP050457972

V-247



N32427.02

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