

03 03 CODE KY-907-D
DEC 17 80 38256

PROCESSES APPROVED BY
() KY-907-D (F) FWP 11/20/80

STANDARD HRS. TIME M

JOB NAME: 03KY-907-DMF

CG	CODE	PQ	LOT	LBS
14	YC002B	93	13411	2200
14	YC002B	93	13176	2000
14	YC002B	93		

HOMO5 #4-2nd Pass

TOTAL EST'D WGT 6053

DEC 19 1980

NON-BLEEDING

EQUIP	NAME	USE LBS	NCODE	ACCT LBS
	NAME: "KROLOR" YELLOW MEDIUM			
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	570	983-D	570
	DUMP IN CHROME YELLOW & STIR 5 MIN	84X50	YC-2-B	4200
	RECORD: START	2200		
	FIN	2000		
	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. 48" & ADJUST TO 60" (2100 GAL)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	RUN 2" (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 12:30 TOTAL MINUTES 120			
	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	3285	983-D	3285
	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN			
	RECORD DENSITY: 1.1386/ML (1.138-1.142)			
SV	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 24" (2420 GAL)			
	RECORD: PH 10.8 & ADJ TO 11.1-11.3 WITH CAUSTIC			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	20	7-D	10
	SIPHON N-7-D INTO SV & RECORD: PH 11.15			
	HEAT TO 190-194°F IN 55-65 MIN & REC: HT			
	& RECORD: 193°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	ON COMPLETION OF HEATING			
343	WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343			
	METER IN SULFURIC ACID FROM V-384			
	MK 29 9.695#/GAL, 49.6		27-D	481
384	STIR 15 MIN OR LONGER			
	RECORD: DENSITY 1.0326/ML (1.030-1.033)			

V - 262

125	WHEN S 20 HEATING COMPLETE, RECORD: PH	10.1			
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	6:10 AM	9:55 AM	225	
	V-349	6:10 AM	9:10 AM	180	
	V-343	V-349	SV	NORMAL	
	6:10	TIME INCHES	42 INCHES	17	PH
	AT 20 MIN	6:30 (36)	38	(15)	9.9 (9.3-10.0)
	40 MIN	6:50 (33)	35	(13)	9.9 (9.3-10.0)
6	1 HR	7:10 (29)		(11)	9.9 (9.3-10.0)
	2 HR	8:10 (19)		(6)	9.9 (9.3-10.0)
	3 HR	9:10 (8)		(0)	9.9 (9.3-10.0)
	FINISH	9:55 (0)		(0)	8.1 (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	ASSUME 50%	100	7-D 50
135	DURING STRIKE PUMP INTO PT		558	169-A	558
PT	136	PUMP IN	62	155-A	62
9	137	PUMP IN	62	160-A	62
138	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42				
139	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			

V-262

- 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 3.2. (3.3-3.7)
- ~~61~~ IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH 3.2.
- ~~62~~ RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- ~~63~~ RECORD: PH 4.3. (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH 4.3. ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50% SIEMON N-7-D INTO SV
- ~~64~~ DO NOT STOP AGITATOR

START

11:00 PM

7:00 AM

FINISH

7:00 AM

11:55 AM

OPERATOR

235-37

223-201

STEP V-262 (20 RPM) V-243, 244, 246, 247

9 2"

18 24"

47"

27-D

7-D