

S.V. 243, 244, 246, 247, (262)

C.V.

D.V.

CG 03 CODE KY-787-D PKG. \_\_\_\_\_

→ MAR-4 34697

EST. WGT. 1090 990 LBS.

STD. HRS. 10.6 TIME

14 YC-2-B 93 4 Lot 24479, 2000#

14 YC-2-B 93 4 Lot 24066, 400#

14 YC-2-B 93 4 Lot \_\_\_\_\_

PUNCHED &amp; CHECKED

3390

Total Wgt. 3490# Req( )

MAR - 5 1980

# 3 2ND PASS

## PROCESSES

## APPROVED BY

( ) KY-787-D (R)

( ) Alternate ( )

( ) ( )

( ) ( )

TYPED BY

NE 2/12/77

FWK 9/22/76

DCG 9/22/76

MTW 9/30/76

| EQUIPMENT   | NAME:                                                                                                       | USE LBS.  | N CODE | ACCT. LBS. |
|-------------|-------------------------------------------------------------------------------------------------------------|-----------|--------|------------|
|             | 60" (2406) "KROLOR" YELLOW-MEDIUM                                                                           |           |        |            |
| 203 & 205 1 | 1 Run 33" (560 G) water into V-203- SET AGITATOR ON HIGH SPEED                                              |           |        |            |
|             | 2 Weigh in drum & pour in                                                                                   | 320       | 32-D   | 320        |
|             | 3 Dump in & stir 5 min                                                                                      | 48 x 50   | YC-2-B | 2400       |
|             | Record: Start 6.40 min                                                                                      | 24479     |        |            |
|             | Fin 7.35 min                                                                                                | 24066     |        |            |
|             | 25" (1225 G)                                                                                                |           |        |            |
|             | 4 Adj to 70" (1200 G)                                                                                       | 2400-2600 |        |            |
|             | 5 Pump V-203 thru Homog # 3 at 1800-2200 psi into V-205                                                     |           |        |            |
|             | 6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water                                |           |        |            |
|             | 7 Record: V-205 Vol 41 " & adj to 60" (2100 G)                                                              |           |        |            |
|             | 8 Inspect Homog strainer & clean if Necessary                                                               |           |        |            |
|             | DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED                                                               |           |        |            |
| SV & 205 2  | 9 Run 5 " (514 G) water into V-262 Install temp chart & start agitator                                      |           |        |            |
|             | 10 Pump V-205 thru Homog at 4800-5200 psi into SV-262                                                       |           |        |            |
|             | Record: Time Start 11.50 PM Total Min 150                                                                   |           |        |            |
|             | Note: If homog pressure falls below 4800 psi 3-way valve will recirculate slurry to V-205                   |           |        |            |
|             | 11 When V-205 MTY, run in 5" (240 G) water & pump thru Homog at 4800-5200 psi                               |           |        |            |
| 349 & 384 3 | 12 While Homog, run 6" (284 G) water into V-349                                                             |           |        |            |
|             | 13 Run ± 1000# water into V-384 & heat to 110-120F                                                          |           |        |            |
|             | 14 Weigh into V-384 & Pump to V-349                                                                         | 1840      | 32-D   | 1840       |
|             | 15 Run ± 1000# water into V-384 & pump to V-349                                                             |           |        |            |
|             | 16 Adj V-349 to 17" (805 G) & stir 15 min or longer                                                         |           |        |            |
|             | 17 Record: Be 1.080 (10.95 ± 0.2) (1.079-1.082)                                                             |           |        |            |
| SV 4        | 18 When S 14 Homog complete, Adj SV to 25 " (2470 G)                                                        |           |        |            |
|             | 19 Record: pH 10.7 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 Parts water to 1 part N-7-D) Assume 50% | 24        | 7-D    | 12         |
|             | Siphon into SV & Record: pH 11.3                                                                            |           |        |            |
|             | 20 Heat to 190-194 F in 55-65 min & Record: HT 190 F & Rec 190 F                                            |           |        |            |
|             | Note: Strike must be started immediately on completion of heating                                           |           |        |            |
| 343 & 386 5 | 21 While heating SV, run 39" (1070 G) water into V-343                                                      |           |        |            |
|             | 22 Meter in from V-386 M 20, 9.19 #/Gal 29.9 Gal                                                            |           | 27-D   | 275        |
|             | 23 Stir 15 min or longer                                                                                    |           |        |            |
|             | 24 Record: Be 1.017 (2.8 ± 0.1) (1.017-1.018)                                                               |           |        |            |

N 26312

U-262

| EQUIPMENT | PAGE 2 | CG03                                                                                     | CODE KY-787-D (R) | EST. WGT.            | 3490     | LBS.  | USE LBS.  | N CODE | ACCT. LBS. |
|-----------|--------|------------------------------------------------------------------------------------------|-------------------|----------------------|----------|-------|-----------|--------|------------|
| SV 6      | 25     | When S 20 heating complete Record: pH <u>10.0</u> (9.5-10.0)                             |                   |                      |          |       |           |        |            |
|           | 26     | Set V-343 acid pump at 82 setting ( $\pm$ 150 min)                                       |                   |                      |          |       |           |        |            |
|           | 27     | Set V-349 silicate pump at 72 setting ( $\pm$ 120 min)                                   |                   |                      |          |       |           |        |            |
|           | 28     | Immediately meter in V-343 & 349, Maintain SV at 190-193F during strike                  |                   |                      |          |       |           |        |            |
|           | 29     | Record: Start Finish Minutes                                                             |                   |                      |          |       |           |        |            |
|           |        | V-343                                                                                    | 5:00              |                      |          | 150   |           |        |            |
|           |        | V-349                                                                                    | 5:20 AM           | 7:10 AM              |          | 150   |           |        |            |
|           |        | Record:                                                                                  | Time              | V-343 in             | V-349 in | SV pH | Normal pH |        |            |
|           |        | at 20 min                                                                                | 5:20              | (35) 35              | (14) 14  | 9.9   | 9.3-10.0  |        |            |
|           |        | 40 min                                                                                   | 5:40              | (30) 31              | (11) 12  | 9.9   | 9.3-10.0  |        |            |
|           |        | 1 hr                                                                                     | 6:00              | (24) 25              | (9) 10   | 9.9   | 9.3-10.0  |        |            |
|           |        | 2 hrs                                                                                    | 6:00              | (8)                  | (0)      | 9.9   | 9.3-10.0  |        |            |
|           |        | Finish                                                                                   | 7:30              | 0                    |          | 8.0   | 7.5-8.5   |        |            |
|           |        | Note: If pH drops below 9.0 in 1st hr. stop pumps & see Supv.                            |                   |                      |          |       |           |        |            |
|           |        | If final pH is above 8.5 adj to 7.5-8.5 & Record: pH Assume 77 %                         |                   |                      |          |       |           |        |            |
|           |        |                                                                                          |                   |                      |          |       |           | 27-D   |            |
| 7         | 30     | Run 20" (392 G) water into V-300 & heat to 80-100 °F                                     |                   |                      |          |       |           |        |            |
|           | 31     | Add in 7-8 min                                                                           |                   |                      |          |       |           |        |            |
|           | 32     | Stir 5 min & Record: pH <u>10.1</u> (9.5-10.5)                                           |                   |                      |          |       |           |        |            |
|           | 33     | Stir 20 min or longer to dissolve for S 46                                               |                   |                      |          |       |           |        |            |
| 357 8     | 34     | Run 11" (80 G) water into V-357 & heat to 135-140 °F                                     |                   |                      |          |       |           |        |            |
|           | 35     | Dump in & stir to dissolve for S-42                                                      |                   |                      |          |       |           |        |            |
|           |        |                                                                                          |                   |                      |          | 160   |           | 15-A   | 160        |
| 302 9     | 36     | Run 30" (360 G) water into V-302                                                         |                   |                      |          |       |           |        |            |
|           | 37     | Add & stir 2 min for S44                                                                 |                   |                      |          |       |           |        |            |
|           |        |                                                                                          |                   |                      |          | 180   |           | 7-D    | 90         |
| SV 10     | 38     | When V-349 MTY. Rinse in with minimum water then set pump to zero setting                |                   |                      |          |       |           |        |            |
|           | 39     | When V-343 MTY. rinse in with minimum water then turn off pump motor                     |                   |                      |          |       |           |        |            |
|           | 40     | Turn off steam                                                                           |                   |                      |          |       |           |        |            |
|           | 41     | Stir in 2 bags                                                                           |                   |                      |          |       |           |        |            |
|           |        |                                                                                          |                   |                      |          | 100   |           | 128-A  | 100        |
|           | 42     | Run in V-357 from S 35 & stir 5 min                                                      |                   |                      |          |       |           |        |            |
|           | 43     | Record: pH <u>3.6</u> (3.7-4.2)                                                          |                   |                      |          |       |           |        |            |
|           | 44     | Run in N-7-D from S 37 in 10-12 min & stir 5 min                                         |                   |                      |          |       |           |        |            |
|           | 45     | Record: pH <u>9.0</u> (9.0-9.5) & if necessary adj to pH 9.0-9.5 & Record: pH Assume 77% |                   |                      |          |       |           |        |            |
|           |        |                                                                                          |                   |                      |          |       |           | 27-D   |            |
|           |        | (Dilute 10 parts water to 1 part N-7-D) Assume 50%                                       |                   |                      |          |       |           |        |            |
|           |        |                                                                                          |                   |                      |          |       |           | 7-D    |            |
|           |        | Siphon N-7 into SV                                                                       |                   |                      |          |       |           |        |            |
|           | 46     | Run in V-330 thru 20 mesh screen & stir 20 min                                           |                   |                      |          |       |           |        |            |
| 313 11    | 47     | Run 10" (128 G) water into V-313 & dump in                                               |                   |                      |          |       |           |        |            |
|           |        |                                                                                          |                   |                      |          | 135   |           | 20-A   | 135        |
|           | 48     | Stir 5 min to dissolve for S 49                                                          |                   |                      |          |       |           |        |            |
| SV 12     | 49     | Run V-313 into SV in 15-20 min                                                           |                   |                      |          |       |           |        |            |
|           | 50     | Stir 15 min                                                                              |                   |                      |          |       |           |        |            |
|           | 51     | Record: pH <u>9.0</u> (9.0-10.0)                                                         |                   |                      |          |       |           |        |            |
|           | 52     | Stop agitator                                                                            |                   |                      |          |       |           |        |            |
|           |        | START                                                                                    | FINISH            | OPTR                 |          |       |           |        |            |
|           |        | 11:00 PM                                                                                 | 7:00 AM           | 409-381              |          |       |           |        |            |
|           |        | 7:00 PM                                                                                  | 10:00 PM          | 100                  |          |       |           |        |            |
|           |        | Step                                                                                     | V-262 (20 RPM)    | V-243, 244, 246, 247 |          |       |           |        |            |
|           |        | 9                                                                                        | 5"                | 10"                  |          |       |           |        |            |
|           |        | 18                                                                                       | 25"               | 48"                  |          |       |           |        |            |



