

MAY 27 1981

E1575

DATE

LOT NUMBER

STANDARD HRS.

TIME ____ M

JOB NAME: 03KY907DME

() KY-907-D (E) FWP 05/13/81
 () () 25% CUT IN
 () () N-32-D AS
 () () XOB-26.

CG	CODE	PQ	LOT	LBS
14	YC002B	93	83619-1	2000
14	YC002B	93	83619-2	400
14	YC002B	93		

DO NOT USE YC-2-B LOTS 13839 - 13855

Homog = 3-20

TOTAL EST'D WGT 3300.

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	NCODE	ACCT LBS
203	1 RUN 60" (990 GAL) WATER INTO V-203. RUN AGITATOR ON HIGH SPEED.			
V-263	2 WEIGH SODIUM SILICATE INTO DRUM & POUR IN DUMP IN CHROME YELLOW & STIR 5 MIN	320	32-D	320
1	RECORD: START 3:05 PM	48X50	YC-2-B	2400
	FIN 3:05 PM	2000		
		400		
	4 ADJUST TO 75" (1275 GAL)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-203			
V-263	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2400-2600 PSI INTO V-203			
	7 RECORD: V-203 VOL. _____ & ADJUST TO 60" (2100 GAL)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	1 RUN 2" (200 GAL) WATER INTO V-208. START AGITATOR & INSTALL TEMP CHART			
SV	110 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 3:00 PM TOTAL MINUTES 120			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
111	WHEN V-205 MT, RUN IN 5" (240 GAL) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349	112 WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
&	113 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	114 WEIGH INTO V-384 & PUMP TO V-349	1300	32-D	1300
	115 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	116 ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN			
	117 RECORD DENSITY: 1.038 ML (1.057-1.060)			
SV	118 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 24" (2420 GAL)			
	119 RECORD: PH 10.5 & ADJ TO 11.1-11.3 WITH CAUSTIC AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4	ASSUME 50%	30	7-D	15
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
120	HEAT TO 190-194°F IN 55-65 MIN & REC: HT 18.7°F			
	& RECORD: 19.7°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON ON COMPLETION OF HEATING			

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V-262

343	21	WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343			
&	22	METER IN SULFURIC ACID FROM V-386			
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY <u>1.014</u> /ML (1.013-1.014)		27-D	206

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH <u>9.9</u>			
	26	SET V-343 ACID PUMP AT 82 SETTING (150 MIN)			
	27	SET V-349 SILICATE PUMP AT 72 SETTING (120 MIN)			
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
	29	AT 190-194°F DURING STRIKE			
		RECORD: START FINISH MINUTES			
		V-343 7:20 10:00 160			
		V-349 7:20 9:25 125			
		V-343 V-349 SV NORMAL			
		7:20 TIME INCHES 4 INCHES 17 PH PH			
		AT 20 MIN 7:40 (35) 37 (14) 9.7 (9.3-10.0)			
		40 MIN 8:00 (30) 39 (11) 9.6 (9.3-10.0)			
		1 HR 8:20 (24) 42 (9) 9.4 (9.3-10.0)			
		2 HR 8:40 (8) 47 (0) 9.3 (9.3-10.0)			
		FINISH 9:50 (0) (0) 8.2 (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%		27-D	
	30	CONTINUE TO NEXT STEP			

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	160	15-A	160

302	33	ADD 17" (208 G) WATER TO V-302			
8	34	ADD & STIR FOR 2 MIN FOR S 62 ASSUME 50%	60	7-D	30

PT	35	DURING STRIKE PUMP INTO PT	318	169-A	318
	36	PUMP IN	36	155-A	36
9	37	PUMP IN	36	160-A	36
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			

	39	DURING STRIKE RUN 14" (244 G) WATER INTO V-356			
	40	TURN ON STEAM			
356	41	ADJ TO 18" (317 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 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 3.3 (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 4.8 (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH 4.3 ASSUME 78Z (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50% SIPHON N-7-D INTO SV
- 164 DO NOT STOP AGITATOR

START

FINISH

OPERATOR

2:00 PM 11:00 PM 235-244

11 PM 1130 342-282

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

9 2" 4"

18 24" 47"

4 27-D 3
7-D