

S.V. HF MILL 1.0

C.V. V-9, V-10, V-13, V-14

D.V.

DATE PRINTED: 12/07/81

CG 16 CODE RC-3-A PKG ---

PROCESSES

APPROVED BY

JUN 8 1982

F2J03

() RC-3-A

(C)

BBK 11/5/81

(DATE)

(LOT NUMBER)

EST. WT. 1729* LBS.

TYPED BY: JMH

STANDARD HRS. _____

TIME _____ 1

PREPARATION NOTES: _____

EQUIP MENT	NAME: MONASTRAL RED B	5 PAGES	USE LBS	N-CODE	ACCT LBS
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PREP 1	1	INSTALL TEMP & AMP CHARTS			
	2	WEIGH +/-600# OF RC-1/RC-3 BORAX SLUDGE FOR S5			
	3	DIP LIQUID FROM SLUDGE & ADD TO CLASSIFIER INTAKE			
	4	OBTAIN +/-200# CHOPPED ICE FOR S13-B			

HF MILL 2	5	SHOVEL 600# OF BORAX SLUDGE (EQUIVALENT TO +/-300# 100% BROAX) INTO HF MILL. NOTE: TOTAL WEIGHT INCLUDES LIQUID REMOVED IN S3.			
	6	ADD	18	834-B	0
	7	START COOLING WATER SPRAY			
	8	STIR 3-5 MIN TO UNIFORMITY			
	9	STOP AGITATOR & DUMP IN. NOTE: RECORD: LOT, #100%, & "AS IS LBS" IN S35.	130	7500-A	0
	10	STIR 3-5 MIN TO UNIFORMITY			
	11	ADD IN 5-10 MIN WHILE AGITATING	300	972-A	0
	12	IMMEDIATELY START MILLING CYCLE			
	13	STIR 4 HOURS, MAINTAINING 38-42 AMPS AND 110-130 DEG F.			

N-7500-A LOT

MILLING HOURS

any

4.0

A. AFTER 1/2 HR MILLING ADD N-972-A OR TRICKLE IN WATER TO MAINTAIN 38-42 AMPS. DO NOT ADD N-972-A AT LESS THAN 10 MIN INTERVALS. RECORD ADDITIONAL N-972-A USED IN S35.

B. IF NECESSARY, ADD N-57-A TO MAINTAIN 110-130 DEG F.

C. IF CAKE FORMS, STOP AGITATOR, SCRAPE MILL WALL TO PERMIT HEAT TRANSFER.

D. RECORD NECESSARY DATA IN S19, 20, 35 AND PAGE 5.

JUN 16 1982

N38957

(JL)

EQUIP MENT		PAGE 2 OF 5 CG 16 CODE RC-3-A (C)	USE LBS	N-CODE	ACCT LBS
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CLASS 3	14	DURING S13 STIR, HOOK UP LINES FROM DORR CLASSIFIER TO V-10. NOTE: FEED VALVE MUST BE CLOSED.			
	15	OBTAIN TWO 55 GAL. DRUMS FOR S27.			

SHRIV 4	16	SET UP 20 PLATES EACH IN NO. 1 & NO. 2 SHRIVER THICKENERS			
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HF MILL 5	17	ADD 5-10 GAL. WATER TO HF MILL. CAUTION: TOO MUCH WATER WILL CAUSE CHARGE TO SPLASH OVER EDGE OF MILL.			
	18	STOP AGITATOR & TURN OFF COOLING WATER.			

MISC 6	19	RECORD:							
		CHG #	DATE START	TIME START	DATE FIN	TIME FIN	MILL HRS		
		1	6-8-82	9:15 PM	6-8-82	1:15 AM	4 HRS		
		2	6-8-82	3:30 AM	6-9-82	7:30 AM	4 HRS		
		3	6-8-82	9:30 AM	6-9-82	1:30 PM	4 HRS		
		4	6-9-82	9:30 AM	6-9-82	1:30 PM	4 HRS		
		5	6-9-82	9:30 AM	6-9-82	1:30 PM	4 HRS		
		6	6-9-82	9:30 AM	6-9-82	1:30 PM	4 HRS		
		7	6-9-82	5:30 PM	6-9-82	9:30 PM	4 HRS		
		8	6-9-82	5:30 PM	6-9-82	9:30 PM	4 HRS		
		9	6-10-82	9:30 AM	6-10-82	1:30 PM	4 HRS		
		10	6-10-82	9:30 AM	6-10-82	1:30 PM	4 HRS		
		11	6-10-82	5:30 PM	6-10-82	9:30 PM	4 HRS		
		12	6-10-82	5:30 PM	6-10-82	9:30 PM	4 HRS		
		13	6-10-82	12:30 PM	6-10-82	4:30 AM	4 HRS		
		14	6-10-82	12:30 PM	6-10-82	4:30 AM	4 HRS		

20	RECORD ACCURACY ONCE PER SHIFT WHILE MILLING:
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DATE	TIME	CHG NO.	AM- METER AMPS	RE- CORDER AMPS	HT *F	RECORD *F
6-9-82	10 AM	324	40-40	37-41		125-123
6-10-82	12:30 PM	11-12	41-41	41-38		123-114
6-10-82	3:30 PM	13-14	40-41	40-41		126-117

SV-11 7	21	ADD 10" (122G) WATER TO V-11			
	22	HEAT TO 140-150 DEG F FOR S24			

EQUIP- MENT		PAGE 3 OF 5 CG 16 CODE RC-3-A (C)	USE LBS	N-CODE	ACCT LBS
13/14	23	PUMP 2 CHARGES FROM HF MILLS TO V13 OR V14			
8	24	WASH OUT HF MILLS, WITH HEATED WATER FROM V11			
	25	ADJ TO 24" (408G) AT 140-150 DEG F			
	26	IMMEDIATELY COOL TO 75-80 DEG F	6X330	57-A	0
	27	RECORD DATE ON BOTTOM OF PAGE 5			
CLASS	28	BACK WASH LINES FROM CLASSIFIERS TO V-13 OR V-14			
9	29	PLACE 55 GAL DRUM UNDER SLUDGE DISCHARGE & START MOTOR			
	30	OPEN INLET VALVE & RUN V-13 OR V-14 THRU CLASSIFIER TO V-10 AT 2.5-3.0 GPM			
	31	WHEN DRUM CONTAINS +/-45G OF SLUDGE, CHANGE DRUM, WEIGH & RECORD IN TABLE ON BOTTOM OF PAGE 5			
	32	WHEN V-13 OR V-14 IS MT, CLOSE FEED VALVE & BACKWASH LINE TO VAT FOR 1/2 MIN.			
	33	OPEN FEED VALVE & DRAIN VAT TO CLASSIFIER, DO NOT WASH IN VAT. NOTE: 4 OR FEWER HF MILL CHARGES MAY BE RUN FROM V-13 OR V-14 TO V-9 OR V-10, WITHOUT TREATMENT OR CLASSIFICATION. RECORD: CHARGE NO. -----			
MISC	34	REPEAT S'S 1-23 UNTIL 14 CHARGES ARE COLLECTED. *****CAUTION***** AFTER 9TH CHARGE WATCH VOLUME IN V-10.			
10					
*****CONTINUE TO NEXT PAGE FOR CHART*****					

EQUIP MENT	PAGE 4 OF 5 CG 16 CODE RC-3-A (C)	USE LBS	N-CODE	ACCT LBS
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MISC 11	35 CHARGE OUT RAW MATERIALS BELOW
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		RECORD SLUDGE		N-7500-A							
		N834		N							
CHG NO.	MILL NO.	AS IS	100%	AS IS	100%	LOT	100%	%	AS IS	N57A	OPTR
1	1	18	600	300	300	602	130	99.2	131	2310	101
2	2	18	600	300	300	602	130	99.2	131	2310	101
3	1	18	600	300	300	602	130	99.2	131	2310	438
4	2	18	600	300	300	602	130	99.2	131	2310	438
5	5	18	600	300	300	602	130	99.2	131	2310	101
6	5	18	600	300	300	602	130	99.2	131	2310	101
7	1	18	600	300	300	318	130	99.0	131	2310	105
8	2	18	600	300	300	608	130	99.1	131	2310	105
9	1	18	600	300	300	602	130	99.2	131	2310	322
10	2	18	600	300	300	602	130	99.2	131	2310	322
11	1	18	600	300	300	604	130	99.6	130	2310	101
12	2	18	600	300	300	604	130	99.6	130	2310	101
13	1	18	600	300	300	602	130	99.6	130	438	
14	2	18	600	300	300	604	130	99.5	130	438	
TOT		252	4200			1820				113,860	

972-A 4200

834-B 252

7500-A 1820

57-A 13860

36	ENTER RAW MATERIAL TOTALS IN "ACCT LBS" COLUMN
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V-10 12	37	HEAT V-10 TO 150-160 DEG F
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V-9 13	38	PUMP V-10 TO V-9 CAUTION DO NOT OVERFLOW V9
	39	START AGITATOR
	40	ADJ TO +/-50" MAINTAINING 150-160 DEG F
	41	RINSE IN V-10 & V-10 LINES
	42	CIRCULATE THRU SHRIVER THICKENERS TO 50"
		(2220G) AT 150-160 DEG F
	43	RECORD: START DATE 6-11-82 TIME 2:20 PM VOL 50
	44	CIRCULATE UNTIL EFFLUENT REACHES 3000 OHMS
	45	RECORD: FINISH DATE 6-15 TIME 6:30 AM
		OHMS 3100 PH (8.4-9.0)
		TIME
		OHMS
		TIME
		OHMS
		NOTE: AFTER 16 HRS WASHING TAKE OHM READINGS EVERY 4 HRS
	46	SHUT OFF WATER

EQUIP MENT		PAGE 5 OF 5 CG 16 CODE RC-3-A (C)	USE LBS	N-CODE	ACCT LBS
V-9	47	CIRCULATE THRU THICKENERS TO 23" (1012G)			
13	48	DISCHARGE INTO 55 GAL. DRUMS			
CONT	49	WHILE FILLING DRUM TAKE A 1 QT. JAR SAMPLE			
		& DELIVER TO CTL FOR D.C.			
	50	RUN 10" (450G) WATER INTO V-9			
	51	HEAT TO 158-162 DEG F			
	52	RECIRCULATE THRU SHRIVER FOR 15 MIN OR			
		UNTIL EFFLUENT IS CLEAR.			
	53	STOP AGITATOR			
		START FIN OPTR			

CHG		VOLUME	FINAL	N-57	SLUDGE
NO.	VAT	INIT	FINAL	USED	CLASS
1&2					
3&4					
5&6					
7&8					
9&10					
11&12					
13&14					















