

CG 18 CODE GC-1-A PKG.

→ OCT 28 80 37635
EST. WGT. 2166 LBS.

STD. HRS. _____ TIME 11:00 M 11: PM

PROCESSES		APPROVED BY	
(C)	GC-1-A	()	AJC 1-10-78
()		()	DCG 1-13-78
()		()	MTW 3-6-78
()		()	
TYPED BY			
NSA 3-14-78			

PLINCHED & CHECKED

1107 - 7 (95)

NON-BLEEDING

EQUIPMENT		NAME: MONASTRAL® GREEN G	USE LBS.	N CODE	ACCT. LBS.	
PREP 1	1	Install Temp & Amps Charts Daily				
	2	Weigh GC-1-A Borax Sludge for S-5 + 11. Record Wgt. in S-23 per Calc S-3				
		NOTE: Total Wgt Includes Liquid. After Weighing, Dipper Off Excess Liquid & Pour Into V-291 Thru Classifier				
	3	Calc For S-10, 12 & 23 660# - (0.7 x # Sludge, S-2) = # N-972-A 720#				
HF Mill 2	4	Start agitator with cooling water off				
	5	Dump in 1 buggy of sludge from S-2 & add	18	567-B	0	
	6	Dump in & stir 10-15 min to uniformity	150	8000-A	0	
		NOTE: Turn on water sprays when mill temp reaches 120°F Omit S-7-9 on 1st charge of 1st batch of a campaign				
CLASS 3	7	During S-6 stir, backwash lines from classifier to V-391 & place cart under sludge discharge				
391 4	8	Adj to 36" (420 G) & turn on agitator				
291 5	9	Run V-391 at 3.0-3.5 GPM(120-140 Min) thru classifier into V-291				
HF-Mill 6	10	During S-9 dump in all but 50# N-972-A Calc in S-3		972-A	0	
	11	Add 2nd buggy of sludge from S-2 & stir 3-6 min to uniformity				
	12	Add 50# N-972-A from S-10 & Adj to 27-32 AMPS with N-972-A or water		972-A	0	
	13	When 27-32 AMPS reached with 1 15" Vortex Stir for 3 Hrs at 27-32 AMPS & below 130°F A. Add N-972-A water or ice to maintain 27-32 AMPS below 130°F B. Record all N-Code ingredients used in table S-23 C. Record data in table S-40				
	14	When S-13 stir completed, add 5-10 Gal water avoiding overflowing HF-Mill				
	15	Stop agitator & Cooling water sprays				
	CLASS 7	16	When S-9 complete & V-391 MTY Close Classifier Feed Valve & backwash line to V-391 for 30 secs.			
		17	Open feed valve & drain V-391 to classifier NOTE: DO NOT WASH IN V-391			
		18	Stop V-391 agitator & close classifier feed valve			

EQUIPMENT	PAGE	2	CG	CODE	GC-1-A	EST. WGT.	2166	LBS.	USE	LBS.	N	CODE	ACCT.	LBS.
391 8	19	When S-15 done turn on agitator & pump in charge from HF-Mill continuously diluting mill charge with #100 Gal water												
	20	Wash in Mill & flush pumping lines into V-391												
180 9	21	Pump V-291 to V-180												
		NOTE: V-382 May Be Used As An Auxiliary Collection Vat Up to 10 Charges. If Used Heat V-382 to 150-160°F before Running Into V-180												
MISC. 10	22	Repeat S 1-21 until 15 charges are collected in V-180												
	23	Charge out raw materials in Table 1 below:												
		TABLE 1												
		CHGE	N-567-B	REC SLUDGE	N-972-A	N-8000-A								
		NO	LBS	#AS IS	100%	#S3	#S13	#TOTAL	LOT NO	#	OPTR			
		1	18	820	574	146	-	146	825	150	101			
		2	18	710	497	223	-	223	826	150	101			
		3	18	830	581	139	-	139	828	150	101			
		4	18	730	511	209	-	209	826	150	101			
		5	18	867	607	120	-	120	826	150	101			
		6	18	839	587	133	27	160	826	150	101			
		7	18	760	532	188	-	188	823	150	101			
		8	18	715	501	219	-	219	823	150	101			
		9	18	960	672	48	-	48	821	150	101			
		10	18	920	644	76	-	76	821	150	101			
		11	18	780	546	174	-	174	828	150	101			
		12	18	655	482	233	-	233	829	150	101			
		13	18	655	459	261	-	261	833	150	101			
		14	18	855	599	121	-	121	833	150	101			
		15	18	829	575	145	-	145	833	150	101			
		TOTALS												
		Enter Total Lbs of R/Ms in Acct Lbs column												
		NOTE: Enter Chge. No. Being Milled. Extra Spaces Included In Table For Use If More Than 1-Lot N-8000-A Used In A Chge.												
180 11	25	Turn on agitator & install Temp Chart												
	26	Run in from V-386 M 66 68.24% 1539 27-D 1050												
	27	Record: pH 6.4 (1.0-2.0)												
	28	If necessary Adj to pH 1.0-2.0 Assume 78% 27-D												
		Record: pH												
	29	Heat to 178-182°F in 40-45 Min												

EQUIPMENT	PAGE 3 CG 18 CODE GC-1-A	EST. WGT. 2166	LBS.	USE LBS.	N CODE	ACCT LBS.
384	30 Run in 2250# water into V-384					
12	21 Weigh in Acid-Drum & pour in	M 10	31.35%	172	28-D	54
	22 Turn on agitator & steam					
313	23 Weigh & Add in 3-5 min	Lot	%	180	365-B	180
	34 Heat to 130-140°F & stir to dissolve for S-35					
100	35 When S-29 Complete Run V-384 at 130-140°F into V-180 at					
13	178-182°F in 10-15 min					
213	36 Stir 30 Min at 178-182°F					
	37 Record: Spot Test (+) ☒ (-) ☐					
	If (-), Contact Supervisor					
	38 Flood to 86" (9159 G) at 178-182°F					
	39 Stop Agitator					
	NOTE: DURING PRESSING, REHEAT SV TO 178-182°F AT THE START OF EACH SHIFT					

MISC
14

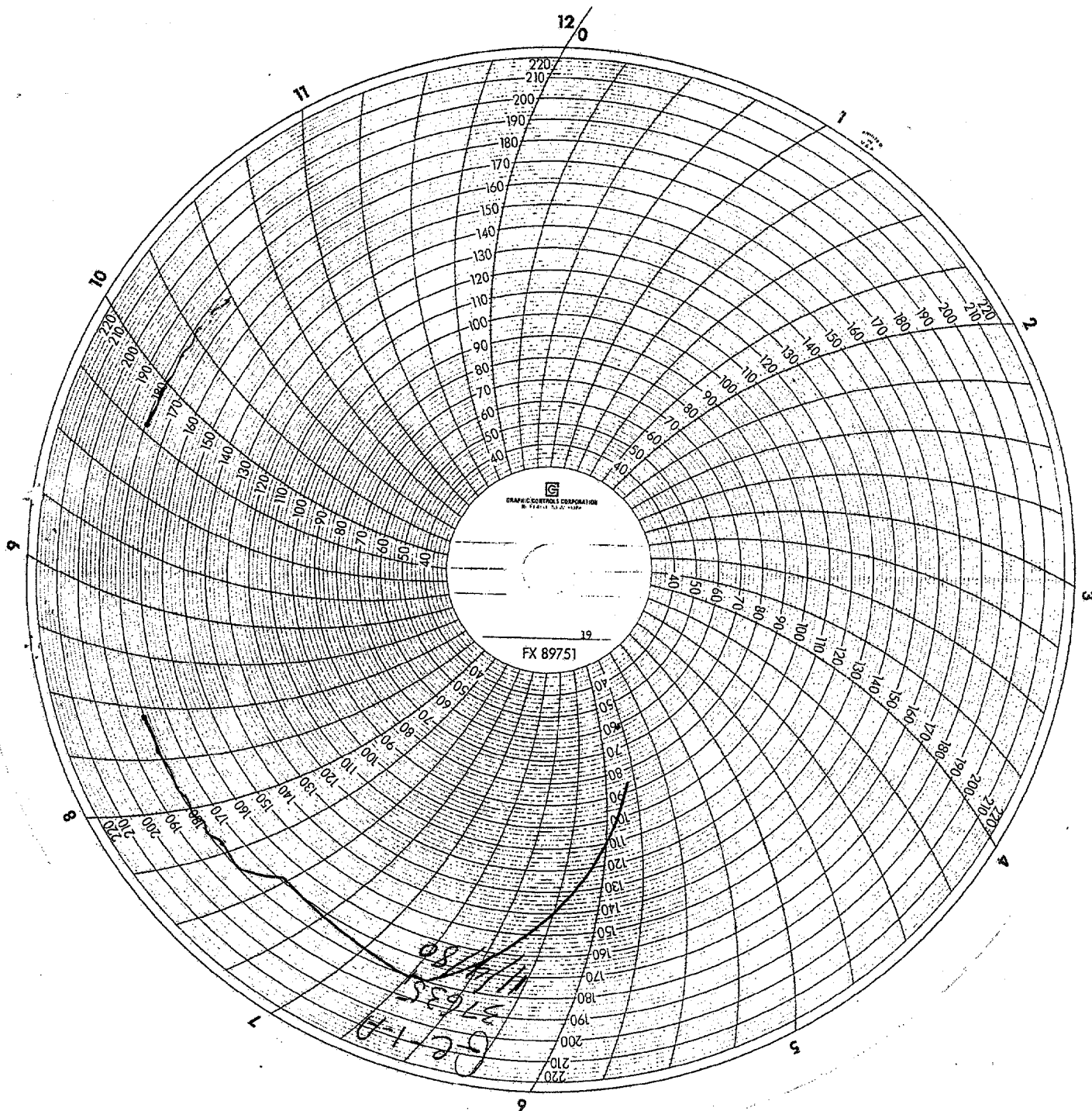
40 Record Data while milling (once each charge)

TABLE 2

CHGE NO	DATE	TIME		MILL HRS	TIME	ACCURACY AMPS		°F REC
		START	FIN			AMMETER	REC	
1	10/8/80	5:20 AM	8:30	3	7:00 PM	29	29	113
2	10-30-80	7:00 PM	5:00 PM	3	3:00 PM	28	28	118
3	10-30-80	7:00 PM	5:00 PM	3	9:30 AM	29	29	117
4	10-30-80	2:00 AM	5:00 AM	3	3:00 AM	27	26	110
5	10-30-80	6:30 AM	9:30 AM	3	8:30 PM	29	28	123
6	10-31-80	12:30 PM	3:30	3	2:30	30	30	129
7	10/31	6:30 P	9:30 P	3	8:00 P	30	30	122
8	11-3-80	8:45 AM	11:45 AM	3	10:15 A	29	29	111
9	11-3-80	1:45 PM	4:45 P	3	3:15 PM	29	30	112
10	11-3-80	7:00 PM	10:00 PM	3	9:30	29	29	118
11	11-4-80	12:15 PM	3:15 PM	3	2:30 PM	31	31	115
12	11-4-80	5:45 PM	8:45 PM	3	6:45 PM	28	28	110
13	11-4-80	10:45 AM	1:45 PM	3	11:45	30	30	116
14	11-4-80	4:45 PM	7:45 PM	3	6:45 PM	27	28	112
15	11-4-80	10:15	11:15	3	11:15 AM	28	28	116
16	Σ	Σ	Σ	7	7	7	7	7
17	Σ	Σ	Σ	7	7	7	7	7
18	Σ	Σ	Σ	7	7	7	7	7
19	Σ	Σ	Σ	7	7	7	7	7
20	Σ	Σ	Σ	7	7	7	7	7
21	Σ	Σ	Σ	7	7	7	7	7

START	FIN	OPTR
5:00 AM	7:00 AM	105
7:30 AM	9:35 AM	109

DUP050041639



PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSED	APPROVED BY
(C) GC-1-A	AJC 1-10-78
	DCG 1-13-78

TYPED BY
 NSA 3-14-78
 MAKING NOTES

REMARKS

NAME: MONASTRAL® GREEN G

NON-BLEEDING

INSTRUCTIONS

-PRESSING-

RECORD

VAT	213					PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE	11-5-80					STARTED	11:20 AM				
TIME	8:35 AM					CAKES USED	414				
RELEASED BY	180					WATER ON	8 PM				
PRESS	31					HRS. WASHED	22				
NO. OF CAKES	44					OHMS	4000				
PRESS WITH		AGITATION				HRS. WASHED					
WASH TO - 3000		OHMS 135-145°F water				OHMS					
TEST AFTER 20		HOURS				HRS. WASHED					
LOAD	in metal drums at 360# net wgt.					OHMS					
NOTE:	1. Request making reheat SV to 178-182°F once per shift					CAKE CONDITION					
	2. Air-blow presscake when 3000 ohms reached for 15 min at 40 PSI					NO. CARS LOADED					
						EXPLAIN LOSSES					

SAMPLES Thief sample per SOP

DELIVER TO CTL

SAMPLED BY

RELEASED BY

-DRYING-

DO NOT DRY

LUMP: - OK - WET - SALTS - CONTAMINATE

ADDITIONAL DRYING HOURS REQUIRED:

SAMPLES

DELIVER TO

[illegible]

SAMPLED BY	_____
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NO DRUMS

LUMP WGT.

RELEASED BY

-GRINDING-

MILL	SCREEN	RPM	SCREEN	RPM
MAX. TEMP.	OF		MAX. TEMP.	OF
			EXPLAIN LOSSES	
SAMPLE AFTER / WITHOUT MIXING			DATE MIXED	
SAMPLES				
DELIVER TO	CTL		SAMPLED BY	RELEASED BY

DUP050041641

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