

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

C.V.

MAY 5 1980

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 03 CODE KY-795-D PKG.

→ APRIL 28 35106

EST. WGT. 1178 938 LBS.

STD. HRS. 11.1 TIME 2:21 M

14 YC-2-B 93 4 Lot 24473, 2000

14 YC-2-B 93 4 Lot 24076, 600

14 YC-2-B 93 4 Lot 24777, 500

24463 600

Total Wgt. 4970# 4638

| PROCESSES     |     | APPROVED BY  |  |
|---------------|-----|--------------|--|
| ( ) KY-795-D  | (I) | EWK 10/5/76  |  |
| ( ) ALTERNATE | ( ) | DCG 10/7/76  |  |
| ( )           | ( ) | MTW 10/11/76 |  |
| ( )           | ( ) |              |  |
| TYPED BY      |     |              |  |
| NE 3/3/77     |     |              |  |

| EQUIPMENT                   |     | NAME:                                                                                                    | USE        | N      | ACCT. |
|-----------------------------|-----|----------------------------------------------------------------------------------------------------------|------------|--------|-------|
|                             |     |                                                                                                          | LBS.       | CODE   | LBS.  |
| 203<br>&<br>205<br>1<br>263 | 60" | "KROLOR" YELLOW - MEDIUM                                                                                 |            |        |       |
|                             | 1   | Run 26" (416 G) water in V-203 SET V-203 AGITATOR ON HIGH SPEED                                          |            |        |       |
|                             | 2   | Water in drum & pour in                                                                                  | 500        | 32-D   | 500   |
|                             | 3   | Dump in & stir 5 min                                                                                     | Lot 74x50  | YC-2-R | 3700  |
|                             |     | Record: Start 11:30 A                                                                                    | 24473 2000 |        |       |
| SV<br>263<br>205<br>2       |     | Fin 1:30 A                                                                                               | 24076 600  |        |       |
|                             |     | 75" (12756)                                                                                              | 24777 500  |        |       |
|                             | 4   | Add to 78" (1328 G) 2400-2600                                                                            | 24463 600  |        |       |
|                             | 5   | Pump V-203 thru Homog # 3 at 1800-2200 psi into V-205 263                                                |            |        |       |
|                             | 6   | When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water 263                            |            |        |       |
| 349<br>&<br>384<br>3        |     | Record: V-205 Vol " & adj to 51" (1874 G)                                                                |            |        |       |
|                             | 8   | Inspect homog, strainer & clean if necessary                                                             |            |        |       |
|                             | 9   | Run V-205 (514 G) water into V-262, install temp charts & start agitator                                 |            |        |       |
|                             | 10  | Pump V-205 thru Homog at 4800-5200 psi into SV 262                                                       |            |        |       |
|                             |     | Record: Time Start 12:45 Total Min 1:15                                                                  |            |        |       |
| SV<br>4                     |     | 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                                |            |        |       |
|                             | 12  | While Homog, run 6" (284 G) water into V-349                                                             |            |        |       |
|                             | 13  | Run ± 1000# water into V-384 & heat to 110-120°F                                                         | 2000       |        | 2000  |
|                             | 14  | Weigh into V-384 & pump to V-349                                                                         | 2000       | 32-D   | 2000  |
| SV<br>4                     | 15  | Run ± 1000# water into V-384 & pump to V-349                                                             |            |        |       |
|                             | 16  | Add V-349 to 29" (1372 G) & stir 15 min or longer                                                        |            |        |       |
|                             | 17  | Record: Be 1050 (9.85 ± 0.2) (1.049-1.051)                                                               |            |        |       |
|                             | 18  | When S 2V Homog complete, adj. to 25" (2495 G)                                                           |            |        |       |
|                             | 19  | Record: pH 10.3 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% | 40         | 1-D    | 20    |
| 343<br>&<br>386<br>5        | 20  | Siphon into SV & Record: pH 11.2                                                                         |            |        |       |
|                             |     | Heat to 190-194°F in 55-65 min & Record: HT 192°F & Re 192°F                                             |            |        |       |
|                             |     | Note: Strike must be started immediately on completion of heating                                        |            |        |       |
|                             | 21  | While heating SV, run 69" (1898 G) water into V-343                                                      |            |        |       |
|                             | 22  | Meter in from V-386 M 21 11.15 #/Gal 18.1 Gal                                                            |            | 27-D   | 312   |
| SV<br>6                     | 23  | Stir 15 min or longer                                                                                    |            |        |       |
|                             | 24  | Record: Be 1012 (2.3 ± 0.1) (1.010-1.012)                                                                |            |        |       |
|                             | 25  | When S 2V heating complete Record: pH 10.0 (9.5-10.0)                                                    |            |        |       |
|                             | 26  | Set V-343 acid pump at 96 setting (±225 min)                                                             |            |        |       |
|                             | 27  | Set V-349 Silicate pump at 82 setting (± 180 min)                                                        |            |        |       |
| 3820 REV.                   | 28  | Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike                               |            |        |       |

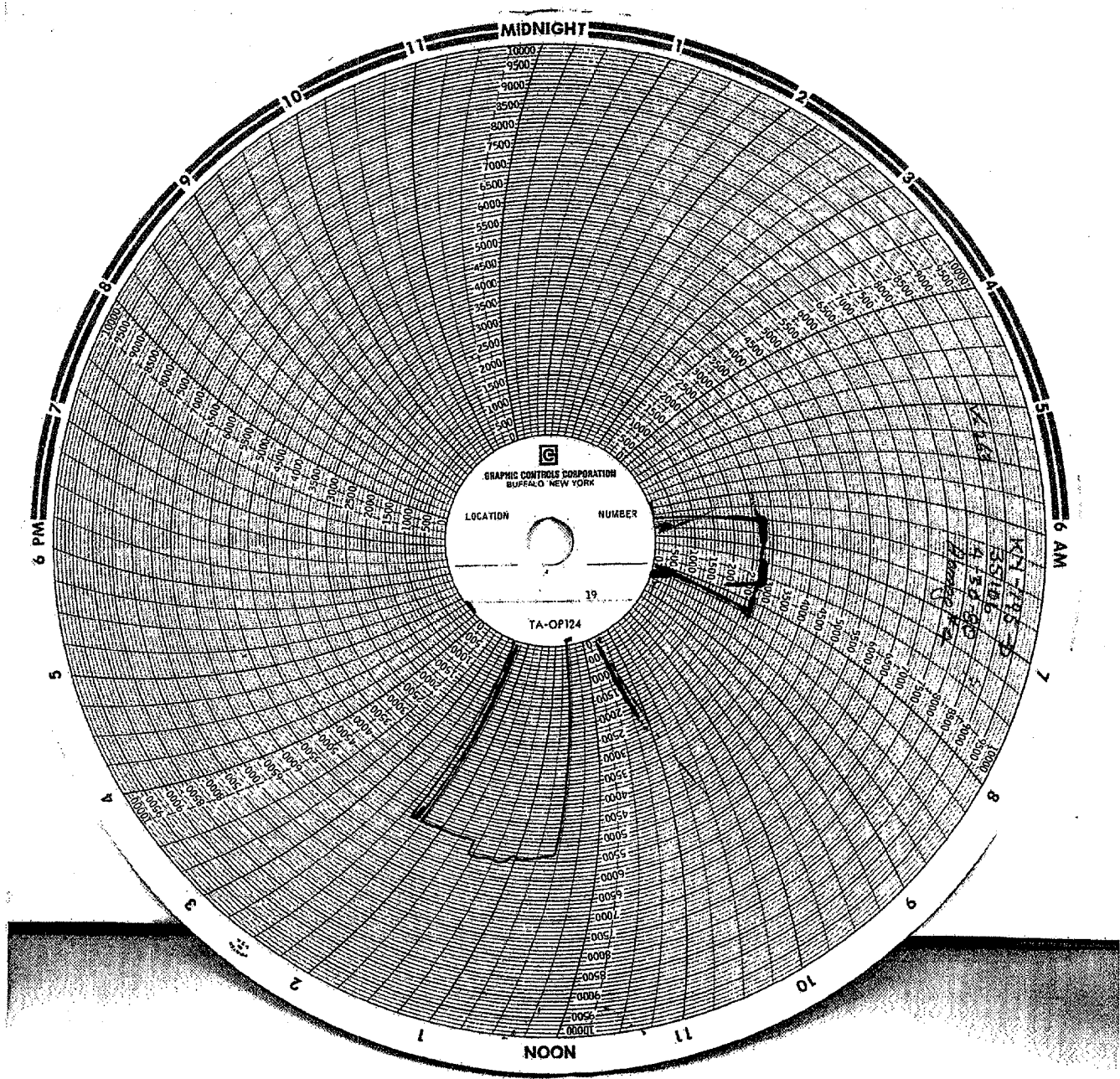
NON-BLEEDING

Homog #4 - 1st Pass

JW

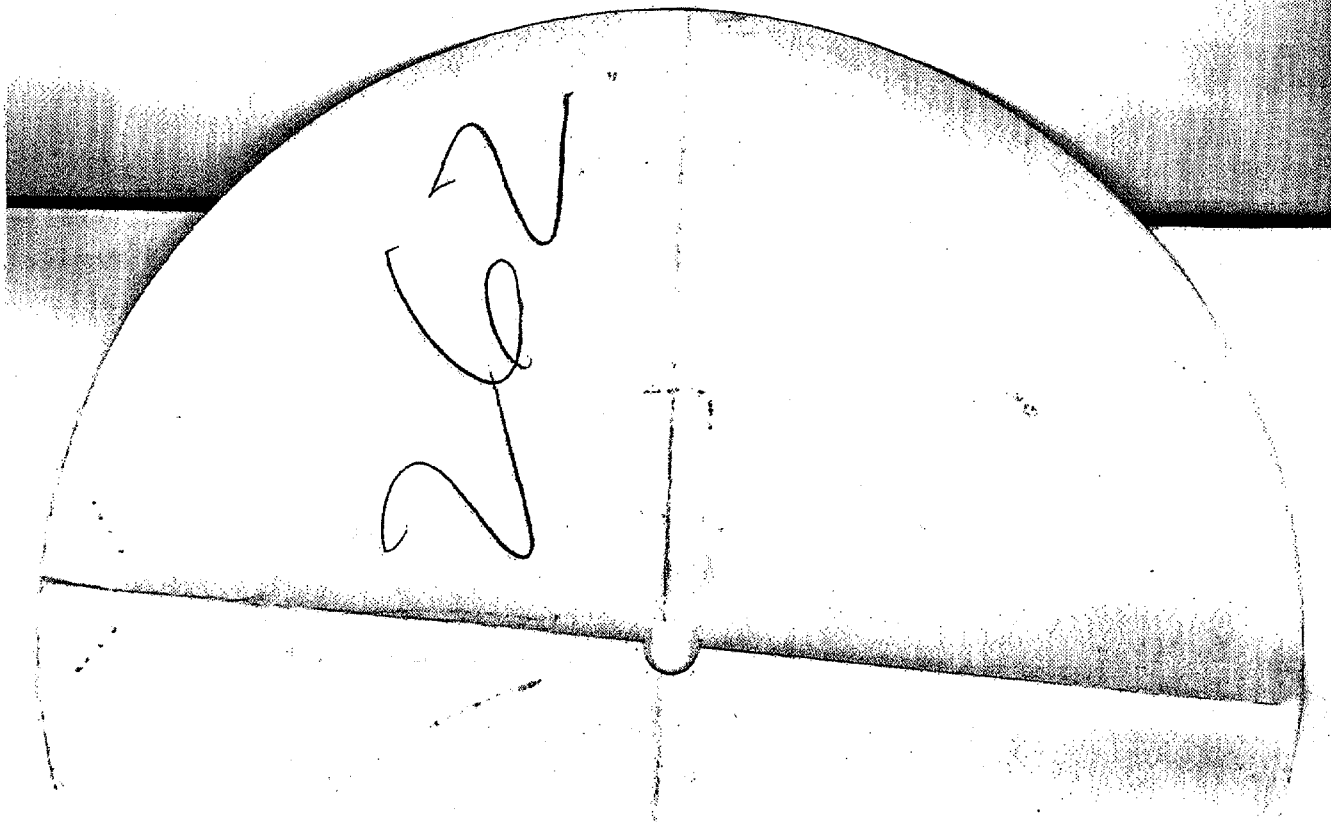
262

| EQUIPMENT | PAGE 2 | CG 03                                                                                                                           | CODE           | KY-795-D(I)     | ALT     | EST. WGT. 4878 | LBS.     | USE  | N    | ACCT. |       |     |
|-----------|--------|---------------------------------------------------------------------------------------------------------------------------------|----------------|-----------------|---------|----------------|----------|------|------|-------|-------|-----|
|           |        |                                                                                                                                 |                |                 |         |                |          | LBS. | CODE | LBS.  |       |     |
| SV        | 29     | Record:                                                                                                                         | Start          | Finish          | Minutes |                |          |      |      |       |       |     |
| 6         |        | V-343                                                                                                                           | 3:20           | 7:50            | 140     |                |          |      |      |       |       |     |
| Cont.     |        | V-349                                                                                                                           | 6:35           | 7:55            | 120     |                |          |      |      |       |       |     |
|           |        | Record:                                                                                                                         | Time           | V-343           | V-349   | SV             | Normal   |      |      |       |       |     |
|           |        |                                                                                                                                 |                | in              | in      | pH             | pH       |      |      |       |       |     |
|           |        | at 20 min                                                                                                                       | 3:40           | (64)            | (26)    | 9.9            | 9.0-10.0 |      |      |       |       |     |
|           |        | 40 min                                                                                                                          | 4:20           | (58)            | (23)    | 9.9            | 9.0-10.0 |      |      |       |       |     |
|           |        | 1 hr                                                                                                                            | 4:50           | (51)            | (19)    | 9.9            | 9.0-10.0 |      |      |       |       |     |
|           |        | 2 hrs                                                                                                                           | 5:20           | (33)            | (10)    | 9.9            | 9.0-10.0 |      |      |       |       |     |
|           |        | 3 hrs                                                                                                                           | 6:20           | (14)            | (0)     | 9.9            | 9.0-10.0 |      |      |       |       |     |
|           |        | Finish                                                                                                                          | 7:05           | (0)             |         | 8.7            | 7.5-8.5  |      |      |       |       |     |
|           |        | Note: If pH drops below 9.0 in 1st. hr, stop pumps & see Supv.                                                                  |                |                 |         |                |          |      |      |       |       |     |
|           |        | If pH. above 8.5 at final adj to 7.5-8.5                                                                                        |                |                 |         |                |          |      |      |       |       |     |
|           |        | Record: pH                                                                                                                      | 8.15           | Assume 77%      |         |                |          | 15   | 27-D | 5     |       |     |
| 35/       | 30     | Run 15" (108 G) water into V-357 & heat to 135-140°F                                                                            |                |                 |         |                |          |      |      |       |       |     |
| 17        | 31     | Dump in & stir to dissolve for S 38                                                                                             |                |                 |         |                |          |      |      | 220   | 15-A  | 220 |
| Drum      | 32     | Weigh into 55 Gal Drum                                                                                                          |                |                 |         |                |          |      |      | 60    | 7-D   | 30  |
| 8         | 33     | Fill with water & stir 2 min for S 40                                                                                           |                |                 |         |                |          |      |      |       |       |     |
| SV        | 34     | When V-349 MTY, rinse in with minimum water then set pump to zero setting                                                       |                |                 |         |                |          |      |      |       |       |     |
|           | 35     | When V-343 MTY, rinse in with minimum water then turn off pump motor                                                            |                |                 |         |                |          |      |      |       |       |     |
| 9         | 36     | Turn off steam                                                                                                                  |                |                 |         |                |          |      |      |       |       |     |
|           | 37     | Stir in 3 bags                                                                                                                  |                |                 |         |                |          |      |      | 150   | 128-A | 150 |
|           | 38     | Run in V-357 from S 31 & stir 5 min                                                                                             |                |                 |         |                |          |      |      |       |       |     |
|           | 39     | Record: pH 5.7 (3.3-3.7) & if necessary adj (down only) to 3.3-3.7 & Record: pH                                                 |                |                 |         |                |          |      |      |       | 15-A  |     |
|           |        | Note: Dissolve extra N-15-A in water at 135-140°F in drum. Use ± 40 Gal water to 50# N-15-A. Stir SV 5 min after each addition. |                |                 |         |                |          |      |      |       |       |     |
|           | 40     | Siphon in N-7-D from S 33 in 4-6 min & stir 5 min                                                                               |                |                 |         |                |          |      |      |       |       |     |
|           | 41     | Record: pH 4.0 (4.0-4.2) & if necessary adj to pH 4.0-4.2 & Record: pH                                                          |                |                 |         |                |          |      |      |       | 27-D  |     |
|           |        | (Dilute 10 parts water to 1 part N-7-D) Assume 50%                                                                              |                |                 |         |                |          |      |      |       | 7-D   |     |
|           |        | Siphon N-7-D into SV                                                                                                            |                |                 |         |                |          |      |      |       |       |     |
|           | 42     | Pour in & Stir 15 min                                                                                                           |                |                 |         |                |          |      |      | 45    | 978-A | 45  |
|           | 43     | Stop agitator                                                                                                                   |                |                 |         |                |          |      |      |       |       |     |
|           |        | Start                                                                                                                           | Fin            | Optr            |         |                |          |      |      |       |       |     |
|           |        | 1:30 AM                                                                                                                         | 7:00 AM        | 235             |         |                |          |      |      |       |       |     |
|           |        | 7:00 AM                                                                                                                         | 3:00 PM        | 223-262         |         |                |          |      |      |       |       |     |
|           |        | 3:00 PM                                                                                                                         | 8:30 PM        | 120             |         |                |          |      |      |       |       |     |
|           |        | Step                                                                                                                            | V-262 (20 RPM) | V-243, 244, 247 |         |                |          |      |      |       |       |     |
|           |        | 9                                                                                                                               | 5"             | 10"             |         |                |          |      |      |       |       |     |
|           |        | 18                                                                                                                              | 25"            | 68"             |         |                |          |      |      |       |       |     |



DUP050456686

N32114.01



DUP050456687

