

D.V. 300, 315, 317, 322, 323

.v. (105) 106

C.Y.

CG 46 CODE YT-858-D PKG.

→ FEB 12 - 34353

EST. WGT. ~~223-245~~ LBS.

STO. HRS.	TIME
1	10:00
2	10:15
3	10:30
4	10:45
5	11:00
6	11:15
7	11:30
8	11:45
9	12:00
10	12:15
11	12:30
12	12:45
13	13:00
14	13:15
15	13:30
16	13:45
17	14:00
18	14:15
19	14:30
20	14:45
21	15:00
22	15:15
23	15:30
24	15:45
25	16:00
26	16:15
27	16:30
28	16:45
29	17:00
30	17:15
31	17:30
32	17:45
33	18:00
34	18:15
35	18:30
36	18:45
37	19:00
38	19:15
39	19:30
40	19:45
41	20:00
42	20:15
43	20:30
44	20:45
45	21:00
46	21:15
47	21:30
48	21:45
49	22:00
50	22:15
51	22:30
52	22:45
53	23:00
54	23:15
55	23:30
56	23:45
57	00:00
58	00:15
59	00:30
60	00:45
61	01:00
62	01:15
63	01:30
64	01:45
65	02:00
66	02:15
67	02:30
68	02:45
69	03:00
70	03:15
71	03:30
72	03:45
73	04:00
74	04:15
75	04:30
76	04:45
77	05:00
78	05:15
79	05:30
80	05:45
81	06:00
82	06:15
83	06:30
84	06:45
85	07:00
86	07:15
87	07:30
88	07:45
89	08:00
90	08:15
91	08:30
92	08:45
93	09:00
94	09:15
95	09:30
96	09:45
97	10:00
98	10:15
99	10:30
100	10:45

PROCESSES		APPROVED BY
() YT-858-D	(A)	EWK 10-18-78
()	()	EAS 05-24-78
()	()	DCG 05-30-78
()	()	MW 05-30-78
TYPED BY		
emw080778		

- R.T.D. to follow
- Shut AL#2 Pump up hose from AL#1 to TRANSFER LINE TO STEAM PUMP AT EAST DIAZO PUMP. PICK UP LINE FROM PUMP TO TRANSFER LINE TO V-300
- PUMP HOT SODASH ASH AND THEN ENTIRE SYSTEM TO V-300 TO SQUASH.
- THEN PUMP WATER AND RUN ENTIRE SYSTEM

BLEEDING

EQUIPMENT		NAME:	"DALAMAR" YELLOW	USE LBS.	N CODE	ACCT. LBS.
Prep	1	Obtain For S7			N-157-C	
1	2	Obtain For S's 23 & 52			46-C	
	3	Install dust hood				
	3A	Clean, dress, close 24" clarif press - 15 frames				
	4	Close ALM - outlet and run in 1900# water				
ALM	5	Zero water meter				
2		Note: All water used to rinse in N-157-C drums or added to fluidize must be metered				
	6	Start agitator				
	7	Dump & rinse in using minimum water			157-C	974
		Note: (1) Stir 1 minute after each drum addition				
		(2) Use minimum water to maintain fluid				
		Record:				
		Drum stencilling	Newark Check-Weigh			
		Lot Dr No Net % #100%	Gross Tare Net			
	99	195 13 165 59.0 97	186 18 168			
	110	195 12 165 66.4 110	182 17 165			
	102	195 16 165 61.0 101	184 17 167			
	104	195 14 165 63.8 105	180 17 163			
	115	195 15 165 68.8 114	184 17 167			
	108	195 10 165 66.0 109	182 18 164			
	111	195 9 165 67.0 111	183 17 165			
	113	195 11 165 68.4 113	183 17 165			
	822		820			
		net = 175 Strong	200 65.8	216	170 (Strong)	
	8	Stir 45 min Record: Start 11:45 PM				
		Note: Add minimum water to fluidize if necessary				
	9	When S8 stir complete, take 2 - 16 oz samples and deliver to Analytical lab for % amine analysis				
	11	Record: Water meter reading 116 #				
	12	Stop agitator & record: pH 3.8 (3.5 - 5.0)				
DV	13	Run 2" (50 g) water into V-300				
3	14	Pump ALM without agitation into DV & turn on agitator				
	15	Add 1000# water to ALM & pump in				
	16	Rinse down sides of ALM & basket & pump in				
	17	Do not proceed with batch until lab analysis available.				
	18	When analysis available, calc total amine				
		1900# + 1494 # net wt N-157-C + 116 # water				
		From S11 X .2663 % Amine = 434 # amine				

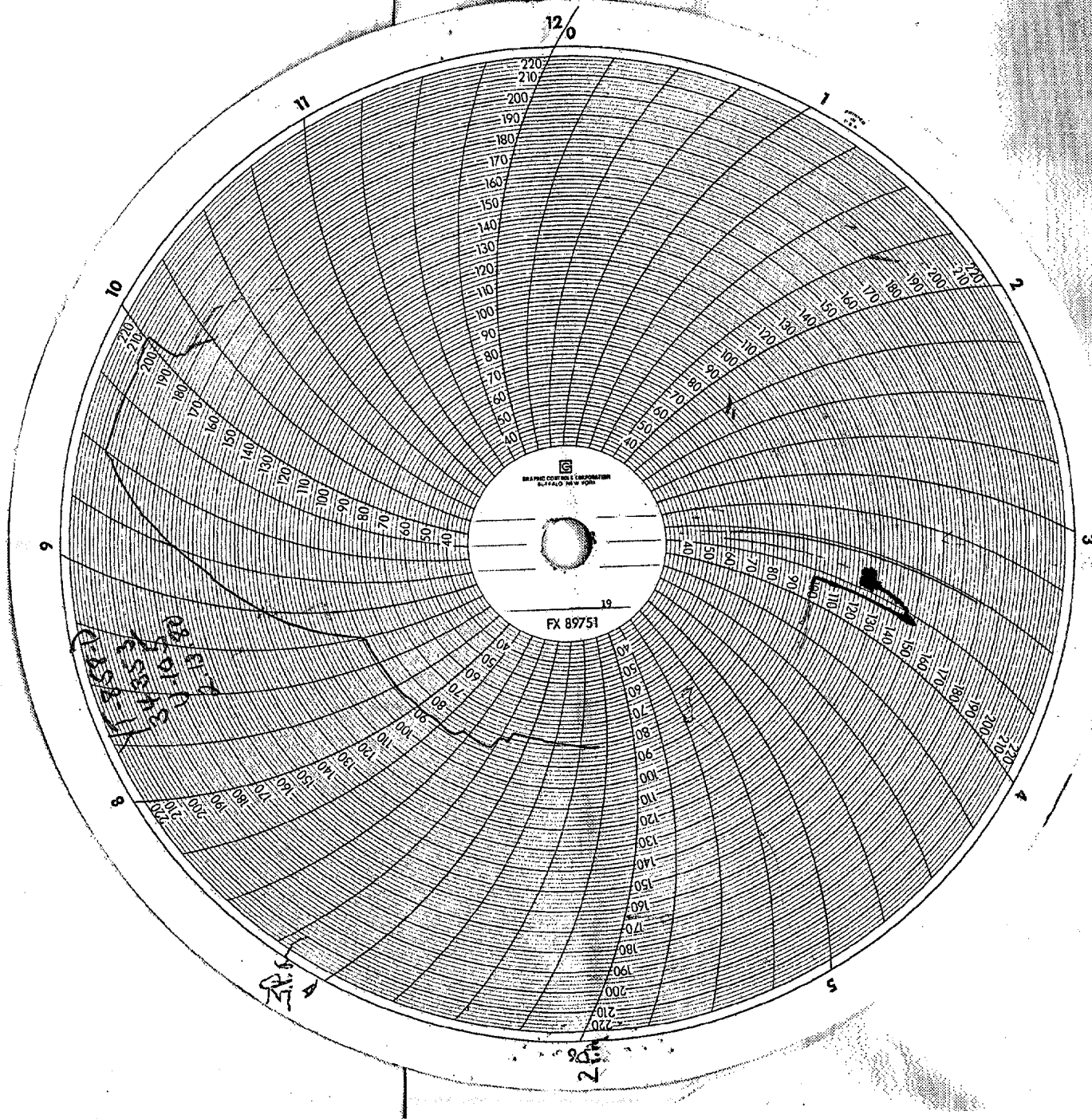
EQUIPMENT	PAGE 2 CG 46 CODE YT-58-D	EST. WGT. 2313	LBS.	USE LBS.	N CODE	ACCT LBS.
19	Calc factor for adjusting batch = <u>9.34</u> # amine from S 18 ÷ 974 = <u>0.959</u>					
20	Scaleup or down ingredients (calculate)					
	1. N-7-D Step 22 32 X <u>0.959</u> factor = <u>31</u> #					
	2. N-46-C Step 23 88 X <u>✓</u> factor = <u>84</u> #					
	3. N-725-A Step 28 26 X <u>✓</u> factor = <u>25</u> #					
	4. N-30-D Step 30 189 X <u>✓</u> factor = <u>181</u> #					
	5. N-28-D Step 35 458 X <u>✓</u> factor = <u>439</u> #					
	6. N-725-A Step 38 405 X <u>✓</u> factor = <u>388</u> #					
	7. N-7-D Step 40 444X <u>✓</u> factor = <u>426</u> #					
	8. N-30-D Step 41 689 X <u>✓</u> factor = <u>660</u> #					
	9. N-979-D Step 51 67 X <u>✓</u> factor = <u>64</u> #					
	10. N-46-C Step 52 1265 X <u>✓</u> factor = <u>1213</u> #					
	11. N-398-C Step 61 10 X <u>✓</u> factor = <u>10</u> #					
	12. Calc Est wt = 2313# X <u>✓</u> factor = <u>2218</u> #.					
	NOTE: Proceed with batch when above calc complete					
303 4	22 Run 24" (583 g) water into V-303					
	22 Pour in M3. <u>48.04</u> %			<u>65</u>	7D	<u>31</u>
	23 Weigh on Postal Scale & dump in From S2			<u>88</u>	46-C	<u>84</u>
	Note: Break up lumps Lot #100%					
	<u>91960</u> - <u>84</u> - <u>956</u>					
	24 Stir 45 min. to dissolve for S 28					
DV 5	25 During S24 Run in 10" (323 G) water into V- <u>304</u>					
	26 Dump in & stir 5 min			5	777-A	5
	27 Pump DV thru clarif press to precoat					
303 6	28 When S24 stir complete weigh on postal M 3. <u>33.46</u> %			<u>75</u>	725-A	<u>25</u>
	29 Scale, pour in & stir 5 min					
	29 Adj to 60-62°F Record Temp °F				57-A	
	30 Siphon in in 4-6 min M4. <u>72.64</u> %			<u>249</u>	30-D	<u>181</u>
	31 Adj to 49" (1175 G) at 66-70°F				57-A	
	32 Stir 5 min & record: pH <u>4.15</u> (4.1-4.5)					
	33 If necessary, adj to pH 4.1-4.5 Assume 77%				30-D	
	& Record: pH <u>✓</u> Assume 50%				7-D	
	34 Stir 3 hrs minimum for S58 maintaining at 66-70°F					
	Record: Start <u>9:55AM</u> Total min <u>210</u>				57-A	
DV 7	35 Weigh into DV from V-324 M 2. <u>30.86</u> %			<u>1423</u>	28-D	<u>439</u>
	36 Stir 10 min or longer to wet					
	37 Adj DV to 37" (1280 g) at 20-22°F			<u>14330</u>	57-A	<u>4630</u>
	38 Siphon in in 12-15 min M3. <u>33.46</u> %			<u>1160</u>	725-A	<u>388</u>
	39 Stir 30 min at 28-32°F maintaining + CR + KI for S42				57-A	
	Record: Time Start <u>11:30 A</u> , CR <u>+</u> (+) KI <u>+</u> (+)					
	NOTE: <u>VOLUME = 444</u>					
	(1) If CR-, add 20# "as is" increments Assume 32%				28-D	
	Record: CR <u>✓</u> (+), KI <u>✓</u> (+)					
	(2) If CR+, KI-, add 20# "as is" increments Assume 33%				725-A	
	Record: CR <u>✓</u> (+), KI <u>✓</u> (+)					
Misc 8	40 During S39 stir weigh in drums for S46. M 3. <u>48.04</u> %			<u>887</u>	7-D	<u>426</u>
	41 Weigh in Buggy for S55 M 4. <u>72.64</u> %			<u>909</u>	30-D	<u>660</u>
DV 9	42 When S39 stir complete, dump in			15	113-A	15
	43 Dump in			10	777-A	10
	44 Stir 30 min at 28-32°F maintaining + CR, + KI for S49				57-A	
	NOTE: <u>12:00 PM</u>					
	(1) If CR-, add 20# "as is" increments Assume 32%				28-D	
	Record: CR <u>+</u> (+) KI <u>+</u> (+)					

K 13830 REV.

DUP050292952

EQUIPMENT	PAGE 3 CG 46 CODE YT-858-D	EST. WGT. 2313	LBS.	USE LBS.	N CODE	ACCT LBS.
DV 9 cont'd	(2) If CR+, KI=, add 20# "as is" increments Record: CR (+), KI (+)	Assume 33%			725-A	
CV 10	45 During S44 stir, run 10" (970 G) water into V-105 & Install temp chart 46 Dump in N-7-D from S 40 47 Adj to 30" (2928 G) at 66-70°F 48 Close stack damper			2 x 330	57-A	
DV 11	49 When S44 stir complete, test DV & Record: CR + (+), KI + (+), temp 32 °F (28-32°F) NOTE: (1) If CR-, KI- add 20# "as is" increments Record: CR (+), KI (+) (2) If CR+, KI- add 20# "as is" increments Record: CR (+), KI (+) 50 Pump DV thru clarif press into V-315 maintaining Temp at 28-32°F Record: time start 1:10 PM total min. 50	Assume 32% Assume 33%			57-A 28-D 725-A	
Misc 12	51 Dissolve in 20 gal water in drum for S68			64	979-D	64
CV 13	52 Dump in from S2 Lot #100% Note: Break up lumps 91960 392 956 91900 607 91.6 91110 199 95.3 91900 15 91.6 53 Stir 10 min to dissolve 54 Open stack damper 55 Run in N-30-D from S41 undersurface in 20-25 min 56 Stir 5 min & Record: pH 5.9 (5.8-6.3) 57 If necessary, adj to pH 5.8-6.3 & Record: pH 58 When S34 stir complete, run in V-303 on surface AFAP			410 6163 2009 16	46-C	1213
DV 14	59 When S50 complete, wash DV lines, pump & press for 20 min or to a - CR test on a sample of total press effluent, whichever comes first collect washings in DV (S50) 60 Stir 5 min & record: Temp 33 (28-32°F) & if necessary, adj to 28-32°F Record: F. VOL 52" 61 Weigh in rubber bucket & wash into DV 62 Stir 5 min & record: KI WWT (-) 63 If necessary adjust to - KI & Record: KI	Assume 50% Assume 77%			7-D 30-D	
CV 15	64 When S63 complete, adj CV to 38" (3708G) at 80-84°F & Record: HT 87 °F, REC 88 °F, VOLUME 46 65 Immediately run in DV thru undersurface distributor in 60-65 min. Maintain CV at 80-84°F, Record: Time Start 3:00 PM Total min 60			10	395 D	10
	66 When S65 complete, stir 10 min 67 Record: Diazo - (-) Base + (+) pH 4.15 (4.3-4.7) CK NOTE: VOLUME 67" (1) If Diazo +, Base -, and pH below 4.3: (a) adj to pH 4.3-4.7 (b) record: pH (2) If Diazo +, Base -, and pH 4.3 or above (a) add 8# 100% N-7-D to a 55 g drum (b) Adj with water to # 25 G	Assume 50%			7-D 7-D	

EQUIPMENT		PAGE 4 CG 46 CODE YT-858-D	EST. WGT. 2313	LBS.	USE LBS.	N CODE	ACCT. LBS.
CV		(c) add 20# 100% N-46-C				46-C	
15(cont)	d	(d) stir to dissolve					
		(e) pour into CV					
		(f) stir 10 min					
		(3) Repeat (1) & (2) above as necessary to - Diazo, + Base					
		65 Dump in N-979-A from S 51					
		66 Heat to 200-204°F in 40-45 min					
		70 Stir 30 min at 200-204°F Record: Time 5:35 PM					
		71 Shut off steam					
		72 Record pH 4.15 (4.2-4.7)					
		73 Flood to 94" (9174G) & stop agitator					
		RECORD: TEMP 174 °F					
		H.T.					
		START 8:20 AM	FIN 3:00 PM	OPTR 381-347			
		3 PM	6:20 PM	120			



N 31964.01

DUP050292955

34 353 - 1384
34 395 884

2218 1403
884 884
334 227

N 31964.02

DUP050292956