DATE 5-01-81 LOT NUMBER 81483

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

STANDARD HRS. TIME ____ M JOB NAME: 03KY907DME

CG	CODE	PQ	LOT	LBS
14	YC002B	93	83609-1	2000
14	YC002B	93	13367	400
14	YC002B	93		

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

TOTAL EST'D WGT 3300. NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW MEDIUM	USE LBS	NCODE	ACCT LBS
203 & ~~205~~ V-263 1	1	RUN 60"(990 GAL) WATER INTO V-203. RUN AGITATOR ON HIGH SPEED.			
	2	WEIGH SODIUM SILICATE INTO DRUM & POUR IN	320	32-D	320
	3	DUMP IN CHROME YELLOW & STIR 5 MIN	48X50	YC-2-B	2400
		RECORD: START 7:38pm	2000		
		FIN 9:25pm	400		
	4	ADJUST TO 75" (1275 GAL)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-~~205~~ V-263			
	6	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2400-2600 PSI INTO V-~~205~~ V-263			
V-263	7	RECORD:V-~~205~~ VOL._____" & ADJUST TO 60"(2100 GAL)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV 2	~~9~~	RUN ___"(200 GAL) WATER INTO V-~~205~~ 262 START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-~~205~~ THRU HOMOG AT 4800-5200 PSI INTO SV-1			
		RECORD: TIME START 1:40AM TOTAL MINUTES 105			
		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	11	WHEN V-205 MT, RUN IN 5"(240 GAL) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384 3	~~12~~	WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
	~~13~~	RUN 1000# WATER INTO V-384 & HEAT TO 110-120*F			
	~~14~~	WEIGH INTO V-384 & PUMP TO V-349	1300	32-D	1300
	~~15~~	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	~~16~~	ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN			
	~~17~~	RECORD DENSITY: 1.06 GM/ML (1.057-1.060)			
SV 4	~~18~~	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 24"(2420 GAL)			
	~~19~~	RECORD: PH 10.3 & ADJ TO 11.1-11.3 WITH CAUSTIC AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
		ASSUME 50%	30	7-D	15
		SIPHON N-7-D INTO SV & RECORD: PH 11.3			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC:HT 190 *F & RECORD: 190 *F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON ON COMPLETION OF HEATING			

MAY 22 1981

(2)

EQUIP		PAGE 2 CG 03 KY-907-D EST WGT 3480# V-262	USE LBS	N-CODE	USE LBS
	21	WHILE HEATING SV, RUN 39* (1070 GAL) WATER INTO V-343			
343 & 386 5	22	METER IN SULFURIC ACID FROM V-386 MK 16, 11.146#/GAL, 18.5 GAL		27-D	206
	23	STIR 15 MIN OR LONGER			
	24	RECORD: DENSITY 1.014 G/ML (1.013-1.014)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.9			
	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			
SV		AT 190-194*F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 6:10 AM 8:45 AM 155			
		V-349 6:10 AM 8:20 AM 130			
		TIME V-343 INCHES V-349 INCHES SV PH NORMAL PH			
		AT 20 MIN 6:30 (35) 35 (14) 14 9.5 (9.3-10.0)			
		40 MIN 6:50 (30) 29 (11) 11 9.7 (9.3-10.0)			
6		1 HR 7:10 (24) + (9) + 9.7 (9.3-10.0)			
		2 HR 8:10 (8) 10 (0) 1 9.6 (9.3-10.0)			
		FINISH 8:40 (0) - (0) 1 7.8 (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 7	31	RUN 40* (308 G) WATER INTO V-385 & HEAT TO 135-140*F			
	32	DUMP IN & STIR TO DISSOLVE FOR S-60	160	15-A	160
302 8	33	ADD 17* (208 G) WATER TO V-302			
	34	ADD & STIR FOR 2 MIN FOR S 62 ASSUME 50%	60	7-D	30
	35	DURING STRIKE PUMP INTO PT	318	169-A	318
PT	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			

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EQUIP		PAGE 3 CC 03 KY-907-D EST WGT 3480# V-262	USE LBS	N-CODE	USE LBS
SV	~~47~~	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
11	~~48~~	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	~~49~~	HEAT TO 198-200*F IN 5-10 MIN			
	~~50~~	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
	~~51~~	OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP INLET			
	~~52~~	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
	~~53~~	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
	~~54~~	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200*F.			
	~~55~~	WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
	~~56~~	WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT WATER FROM HOT WATER MIXER			
	~~57~~	TURN OFF HOMOG & STEARATE PUMP			
	~~58~~	STIR 5 MIN AT 198-200*F			
	~~59~~	SHUT OFF STEAM			
	~~60~~	RUN IN V-385 FROM S-32 & STIR 5 MIN RECORD: PH 3.55 (3.3-3.7)			
	~~61~~	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH ____			
	~~62~~	RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN			
	~~63~~	RECORD: PH 4.3 (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH ____ ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50% SIPHON N-7-D INTO SV	_____ _____	27-D 7-D	_____ _____
	~~64~~	DO NOT STOP AGITATOR			

START	FINISH	OPERATOR
11:00 PM	7:00 AM	409-301
7:00 A	10:00 AM	235-244

STEP	V-262 (20 RPM)	V-243,244,246,247
9	2"	4"
18	24"	47"

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