

CG 03 CODE KY-781-D PKG
 OCT-27-1982 L2H64 4248*
 (DATE) (LOT) (EST WGT)

PROCESSES APPROVED BY:
 () KY-781-D (N) FWP 10/19/82
 COMTYF JOB NAME: 03KY781DMN

STANDARD HRS. TIME M

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
14	YC-3	93								
14	YC-3	93								
14	YC-3	93								

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	N- CODE	ACCT LBS
203	"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF"			
205	RUN 60" (990 G) WATER IN V-203, ADD CAUSTIC SODA SOLN. SET AGITATOR ON HIGH SPEED. ASSUME 50% WEIGH SODIUM SILICATE IN DRUM & POUR IN DUMP IN MONASTRAL BED B & STIR 5 MIN RECORD: START <u>1:30 PM</u> LOT <u>K2B05</u> FIN <u>2:45 PM</u> <u>D2D12</u>	36 442 66X50 2000 1300	7-D 32-D YC-3-B	18 442 3300
204	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205 RECORD: V-205 VOL <u>34</u> & ADJ TO 45" (1662 G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
SV	RUN 10" (514 G) WATER INTO V-240 & START AGITATOR PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>5:10 PM</u> TOTAL MINUTES <u>120</u> NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 1 (V-243) OR POSITION 6 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F) RECORD LEVELS LIQUID ALUM & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG <u>4.6</u> % PRESET #3 70 GAL SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D SULFURIC ACID 60% CONTROLLER IN MANUAL) 0.90 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM 3FR10 (N-27-D/WATER) RATIO 0.7 3FC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM 3FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM 3FC20 (N-32-D WATER) IN REMOTE 3FR10 (N-32-D/WATER) RATIO 0.9			
3			115-A	374
			27-D	373
			32-D	2527

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(Jpe)

EQUIP PAGE 2 CG 03 KY-781-D V-240 USE N- ACCT
MENT LBS CODE LBS

16 OPERATOR STEP PB
17 RECORD LEVEL 2LG 90% IF (35% FOLLOW SOLUTION
SV MAKE-UP PROCEDURE FOR N-27-D
SP 18 ADJUST SV TO 54" (2800 G)
CP 19 RECORD PH 10.0. ADJ TO 11.4-11.6 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 20 SIPHON INTO SV. RECORD: PH 11.6 ASSUME 50% 50 7-D 25
20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.1
SV 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 23 OPERATOR STEP PB
24 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 25 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
26 OPERATOR STEP PB
27 DURING STRIKE RECORD:
SP STEP

V-243/V-244

	PH	RANGE	TIME
13/41 (30 MIN)	<u>9.5</u>	9.3-10.0	<u>8:45 PM</u>
14/47 (60 MIN)	<u>9.5</u>	9.3-10.0	<u>9:15</u>
15/48 (2 HRS)	<u>9.4</u>	9.3-10.0	<u>10:15</u>
16/49 (3 HRS)	<u>9.3</u>	9.3-10.0	<u>11:15</u>
17/50 (FINAL)	<u>7.5</u>	7.5-8.5	<u>12:00 AM</u>

NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE
IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5
& RECORD: PH _____ ASSUME 77% _____ 27-D _____

385 28 RUN 49" (379 G) WATER INTO V-385
6 29 ADD & STIR 5 MIN ASSUME 50% ✓ 124 7-D 62

30 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
SV 31 SIFT IN BLANC FIXE N ✓ 165 128-A 165
32 SP STEP 23/53.
33 RECORD: PH 3.5 (3.3-3.7) & IF NECESSARY ADJ.
(DOWN ONLY) TO 3.3-3.7 & RECORD: PH _____
NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
BADGER METER. STIR 5 MIN AFTER EACH ADDITION.

ASSUME 50% _____ 115-D _____
SP 34 RUN IN N-7-D FROM S-29 IN 10-12 MIN, STIR 5 MIN
7 35 RECORD: PH 3.9 (4.2-4.4). ADJ IF NECESSARY &
RECORD: PH 4.2 ASSUME 77% _____ 27-D _____
(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 30 7-D 15
(SIPHON N-7-D INTO SV)

36 OPERATOR STEP PB
37 SP STEP 24/54-ADD PLASTOLEIN 9746A & STIR 5 MIN ✓ 40 978-A 40
38 OPERATOR STEP PB
39 SP STEP 60. BATCH COMPLETE.

START
TIME SP STEP

3:00 PM

11:00 PM

FINISH
TIME SP STEP

11:00 PM

12:15 PM

OPTR

237

320

