

STANDARD HRS. TIME H COMTYP JOB NAME: 03KY790DMD

TOTAL EST'D WGT 40064 LBS. **FIRST MANUAL** NON-BLEEDING

EQUIP	NAME : "KROLER" YELLOW-PRIMROSE	USE LBS	N-CODE	ACCT LBS
203 & 205	1 RUN 60" (992 G) WATER IN V-203. RUN AGITATOR ON HIGH SPEED.			
1	2 WEIGH IN DRUM & POUR IN	415	32-D	415
	3 DUMP IN & STIR 5 MIN	62X50	104-B	3100
	4 RECORD: START <u>7:00 PM</u> LOT <u>3922</u>	<u>3100</u>		
	FIN <u>9:00 PM</u>			
	5 ADJUST TO 75" (1275 G) & RECORD: PH (7.0-9.0)			
	NOTE: VOLUMES HIGHER THAN 75" WILL CAUSE DUSTING FROM DUMP HOOD.			
	6 WITH AGITATOR ON LOW SPEED, PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	7 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2400-2600 PSI INTO V-205			
	8 RECORD: V-205 VOL <u>41</u> & ADJ TO 55" (2016 G)			
	9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
HERE	10 RUN 4" (200 G) WATER INTO V-240 & START AGITATOR			
2V	11 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
2	12 RECORD: TIME START <u>2:55 PM</u> TOTAL MINUTES <u>155</u>			
	13 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	14 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI. RINSE WITH HOT WATER.			
349 & 384	15 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	16 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	17 WEIGH INTO V-384 & PUMP TO V-349	2375	32-D	2375
	18 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	19 ADJ V-349 TO 28" (1324 G) & STIR 15 MIN			
	20 RECORD DENSITY: <u>1.063</u> G/ML (1.062-1.063)			
SV	21 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 63" (3238 GAL)			
4	22 RECORD PH: <u>7.8</u>			
	23 HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>191</u> °F			
	24 & RECORD: <u>194</u> °F			
	25 ADJUST PH TO 9.0-9.5 (UP ONLY) ASSUME 50%	<u>80</u>	7-D	<u>40</u>
	DILUTE N-7-D TO 5% (10 PARTS WATER TO 1 PART N-7-D). RECORD PH: <u>9.4</u>		7-D	
	STRIKE MUST BE STARTED IMMEDIATELY AFTER PH ADJUSTMENT.			

343 122 WHILE HEATING SV, RUN 67° (1843 G) WATER INTO
 & V-343
 386 123 METER IN FROM V-386 N **4 9.86** #/GAL **357** GAL
 5 124 STIR 15 MIN OR LONGER
 125 RECORD DENSITY **10.14** G/ML (1.012-1.014)

126 SET V-343 ACID PUMP AT 93 SETTING (225 MIN)
 127 SET V-349 SILICATE PUMP AT 79 SETTING (180 MIN)
 128 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 AT 190-194°F DURING STRIKE.

RECORD	START	FINISH	MINUTES
V-343	8:30	11:30 AM	300
V-349	8:30	12:00 PM	210

TIME	V-343 INCHES	V-349 INCHES	SV PH	NORMAL PH
AT 20 MIN	8:50 (62) 6.3	(25) 2.4	9.4	(9.3-10.0)
40 MIN	9:10 (56) 5.7	(22) 2.2	9.5	(9.3-10.0)
1 HR	9:30 (50) 5.1	(19) 1.8	9.5	(9.3-10.0)
2 HRS	10:30 (32) 3.3	(9) 1.0	9.5	(9.3-10.0)
3 HRS	11:30 (14) ---	(0) ---	9.5	(9.3-10.0)
FINISH	12:05 (0) ---	(0) ---	6.0	(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 & RECORD: **PH** ASSUME 77 %

SV 130 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 8 131 SET PUMP TO ZERO SETTING
 132 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 133 TURN OFF PUMP MOTOR
 132 TURN OFF STEAM
 133 SIFT IN
 134 RUN IN ALUM USING BADGER METER
 135 FLUSH ALUM LINE WITH WATER
 136 RECORD: PH **4.1** (3.3-3.7) & IF NECESSARY ADJ
 (DOWN ONLY) TO 3.3-3.7 & RECORD: PH **3.7**
 NOTE: USE LIQUID ALUM, N-115-A, ADD TO SV VIA
 BADGER METER. SWIR 5 MIN AFTER EACH
 ADDITION. ASSUME 50%
 137 RECORD: PH **4.1** (4.0-4.4) & IF NECESSARY ADJ TO
 PH 4.0-4.4 & RECORD. PH **---** ASSUME 77%
 DILUTE N-7-D 10 TO 1 WITH WATER. ASSUME 50%
 SIPHON N-7-D INTO SV
 138 STOP AGITATOR

START	FINISH	OPERATOR
10:00 PM	11:00 PM	54-114
7:00 PM	3:30 PM	114-126
		438-37

