

DEC 16 80 38251

() KY-907-D (F) FWP 11/20/80

STANDARD HRS.

TIME _____ M

JOB NAME: 03KY-907-DMF

CG	CODE	PQ	LOT	LBS
14	YC002B	93	13410	4000
14	YC002B	93	13411	200
14	YC002B	93		

Homog #3 - 1st Pass
Homog #4 2nd Pass

TOTAL EST'D WGT 6053

DEC 18 1980

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	NCODE	ACCT LBS
203	1 RUN 60" (990 GAL) WATER INTO V-203 & ADD CAUSTIC	40	7-D	20
&	2 RUN AGITATOR ON HIGH SPEED			
205	3 WEIGH SODIUM SILICATE INTO DRUM & POUR IN	570	983-D	570
	4 DUMP IN CHROME YELLOW & STIR 5 MIN	84X50	YC-2-B	4200
1	RECORD: START <u>9:45 PM</u> FIN <u>9:50 PM</u>			
	5 ADJUST TO 75" (1275 GAL)			
	6 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	7 HOMOG AT 2400-2600 PSI INTO V-205			
	8 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	9 HOT WATER AT 2400-2600 PSI INTO V-205			
	10 RECORD: V-205 VOL. <u>58</u> " & ADJUST TO 60" (2100 GAL)			
	11 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	12 RUN <u>2</u> " (200 GAL) WATER INTO V- <u>207</u> START			
&	13 AGITATOR & INSTALL TEMP CHART			
SV	14 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START <u>10:00 AM</u> TOTAL MINUTES <u>90</u>			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	15 WHEN V-205 MT, RUN IN 5" (240 GAL) WATER & PUMP			
	THRU HOMOG AT 4800-5200 PSI INTO SV			
349	16 WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
&	17 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	18 WEIGH INTO V-384 & PUMP TO V-349	3285	983-D	3285
	19 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	20 ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN			
	21 RECORD DENSITY: <u>1.041</u> G/ML (1.138-1.142)			
SV	22 WHEN S-11 HOMOG COMPLETE, ADJ SV TO <u>24</u> " (2420 GAL)			
	23 RECORD: PH <u>10.8</u> & ADJ TO 11.1-11.3 WITH CAUSTIC			
4	AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	<u>15</u>	7-D	<u>7</u>
	24 SIPHON N-7-D INTO SV & RECORD: PH <u>11.3</u>			
	25 HEAT TO 190-194°F IN 55-65 MIN & REC: HT _____ °F			
	& RECORD: _____ °F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	ON COMPLETION OF HEATING			
	26 WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343			
343	27 METER IN SULFURIC ACID FROM V-384			
&	28 MK <u>28</u> <u>9077</u> G/L <u>53.0</u> GAL			
384	29 STIR 15 MIN OR LONGER		27-D	481
5	30 RECORD DENSITY <u>1.033</u> G/ML (1.030-1.033)			

N34697

26 WHEN S 20 HEATING COMPLETE, RECORD: PH 12.0
 26 SET V-343 ACID PUMP AT 57 SETTING (225 MIN)
 27 SET V-349 SILICATE PUMP AT 48 SETTING (180 MIN)
 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 SV AT 190-194°F DURING STRIKE

RECORD:	START	FINISH	MINUTES
V-343	<u>120</u>	<u>5:18</u>	<u>235</u>
V-349	<u>120</u>	<u>4:20</u>	<u>180</u>
	V-343	V-349	SV NORMAL
	TIME INCHES	INCHES	PH PH
AT 20 MIN	<u>1.40</u> (36)	(15)	<u>9.7</u> (9.3-10.0)
40 MIN	<u>2:00</u> (33)	(13)	<u>9.7</u> (9.3-10.0)
1 HR	<u>2:20</u> (29)	(11)	<u>9.6</u> (9.3-10.0)
2 HR	<u>3:20</u> (19)	(6)	<u>9.5</u> (9.3-10.0)
3 HR	<u>4:20</u> (8)	(0)	<u>9.5</u> (9.3-10.0)
FINISH	<u>5:05</u> (0)	(0)	<u>9.9</u> (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%

130 SIFT IN

50

27-D

128-A

50

385 131 RUN 40" (308 G) WATER INTO V-385 & HEAT TO
 7 135-140°F

132 DUMP IN & STIR TO DISSOLVE FOR S-60

280

15-A

280

302 133 ADD 17" (208 G) WATER TO V-302

8 134 ADD & STIR FOR 2 MIN FOR S 62

ASSUME 50%

100

7-D

50

135 DURING STRIKE PUMP INTO PT

558

169-A

558

PT 136 PUMP IN

62

155-A

62

9 137 PUMP IN

62

160-A

62

138 STIR 10 MIN WITH LIGHTENING MIXER FOR S 42

139 DURING STRIKE RUN 18" (317 G) WATER INTO V-356

140 TURN ON STEAM

356 141 ADJ TO 23" (403 G) AT 81-82°C

10 142 PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE

DISTRIBUTORS AS FAST AS POSSIBLE

143 RINSE PT WITH HOT WATER FROM HOT WATER MIXER

& PUMP IN

144 SHUT OFF PUMP

145 STIR 30 MIN AT 81-82°C FOR S 54

146 DO NOT SHUT OFF AGITATOR

- SV 147 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
SET PUMP AT ZERO SETTING
- 11 148 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
TURN OFF PUMP MOTOR
- 149 HEAT TO 198-200°F IN 5-10 MIN
- 150 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP
- 151 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET
- 152 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER
- 153 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER
- 154 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
- 155 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
- 156 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER
- 157 TURN OFF HOMOG & STEARATE PUMP
- 158 STIR 5 MIN AT 198-200°F
- 159 SHUT OFF STEAM
- 160 RUN IN V-385 FROM S-32 & STIR 5 MIN
- RECORD: PH 3.2. (3.3-3.7)
- 161 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)
& RECORD: PH .
- 162 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- 163 RECORD: PH 3.2. (4.2-4.4) & IF NECESSARY, ADJ
TO PH 4.2-4.4 & RECORD: PH 4.2. ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%
SIPHON N-7-D INTO SV
- 164 DO NOT STOP AGITATOR

START

11:00P

FINISH

7:00AM

OPERATOR

235300P6:15P120-257

STEP V-262 (20 RPM) V-243, 244, 246, 247

9

2"

4"

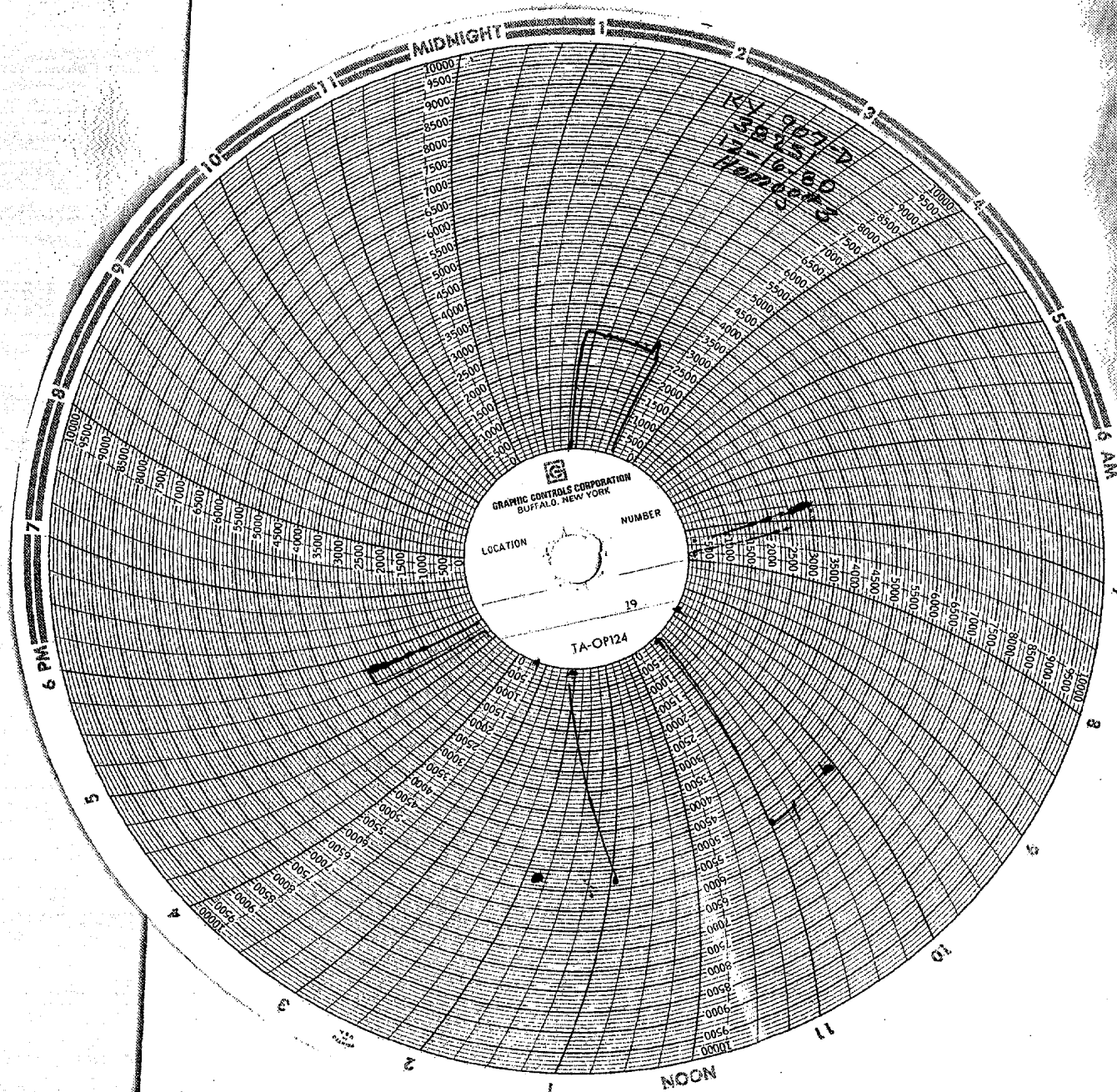
18

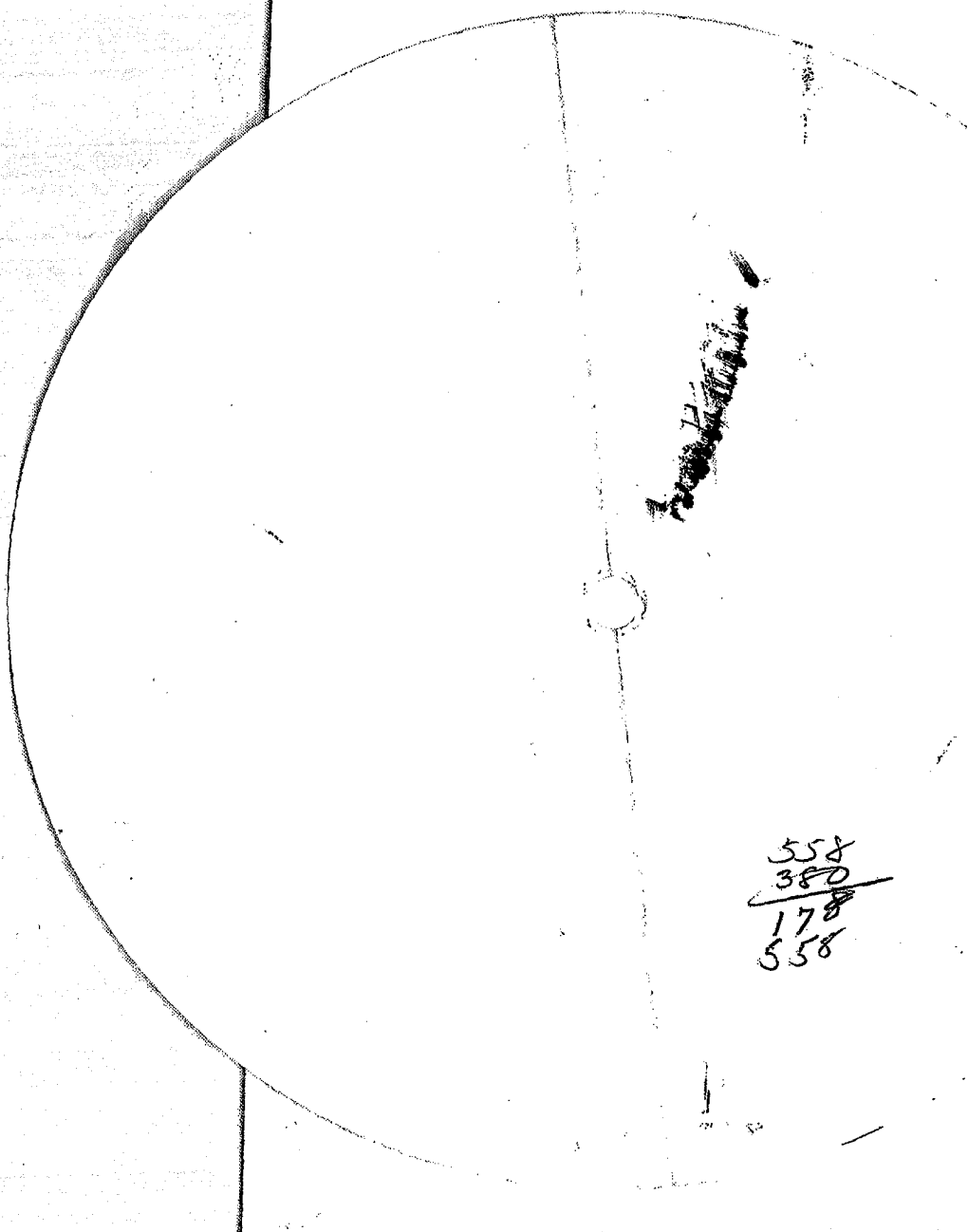
24"

47"

27-D

7-D





558
380

178
558