

10/19/82

GRK

S. V. (240) 244 (AUTOMATED)

CG 03 CODE KY-781-D PKG

PROCESSES

APPROVED BY:

OCT 22 1982

K2L18

4246*

KY-781-D (N)

FWP 10/19/82

(DATE)

(LOT)

(EST WGT)

COMTYP 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	K2L18			66	50	3300	
	14	YC-3	93							
	14	YC-3	93							

NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
	KROLOR YELLOW LIGHT			
	BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF			
203	1 RUN 60" (990 G) WATER IN V-203, ADD CAUSTIC SODA			
5	2 SOLN. SET AGITATOR ON HIGH SPEED. ASSUME 50%	36	7-D	18
205	3 WEIGH SODIUM SILICATE IN DRUM & POUR IN	442	32-D	442
	4 DUMP IN MONASTRAL RED B & STIR 5 MIN	66X50	YC-3-B	3300
	RECORD: START 5:00 AM LOT K2L18	3300		
1	FIN 8:30 PM			
	5 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	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 OF HOT WATER AT 2400-2600 PSI INTO V-205			
	10 RECORD: V-205 VOL ____ " & ADJ TO 45" (1662 G)			
	11 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	12 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	13 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 11:00 AM TOTAL MINUTES 180			
2	14 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	15 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	16 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP			
	17 THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	18 STEP 01 - SET FORMULA SELECTOR TO POSITION			
&	19 1 (V-240) OR POSITION 6 (V-244)			
CP	20 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	21 REMOTE (TEMP IS SET AT 190-194°F)			
3	22 RECORD LEVELS LIQUID ALUM & SET R/M COUNTER #1			
	23 AS FOLLOWS: A. 11LG 40% PRESET #3 70 GAL			
	24 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	25 3FC10 (N-27-D SULFURIC ACID 60% CONTROLLER IN			
	26 MANUAL) 0.96 GPM			
	27 3FC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM			
	28 3PR10 (N-27-D/WATER) RATIO 0.7			
	29 8FC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM			
	30 8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	31 8PR20 (N-32-D WATER) IN REMOTE			
	32 8PR10 (N-32-D/WATER) RATIO 0.9			

OCT 26 1982

115-A 374

27-D 373

32-D 2527

gc

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 *7.6* ADJ TO 11.4-11.6 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 SIPHON INTO SV. RECORD: PH *11.5* ASSUME 50% 7-D *30*
20 OPERATOR STEP PB

24 SP STEP 06/39. AFTER HEAT-UP RECORD: PH *8.7 (10.0)* 40 7-D *20*
SV 23 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 3:35
27 DURING STRIKE RECORD:

SP STEP
V-243/V-244
13/41 (30 MIN) PH *9.4* RANGE 9.3-10.0 TIME *4:00*
14/47 (60 MIN) PH *9.3* RANGE 9.3-10.0 TIME *4:30*
15/48 (2 HRS) PH *9.6* RANGE 9.3-10.0 TIME *5:30*
16/49 (3 HRS) PH *9.4* RANGE 9.3-10.0 TIME *6:30*
17/50 (FINAL) PH *7.7* RANGE 7.5-8.5 TIME *7:15*

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

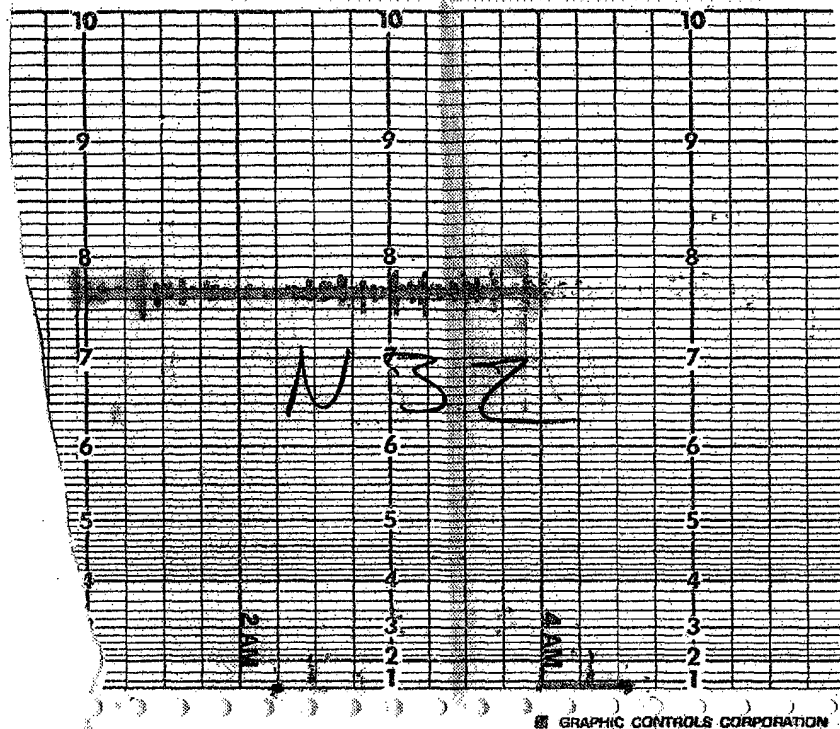
385 28 RUN 49" (379 G) WATER INTO V-385
6 29 ADD & STIR 5 MIN ASSUME 50% 124 7-D 62

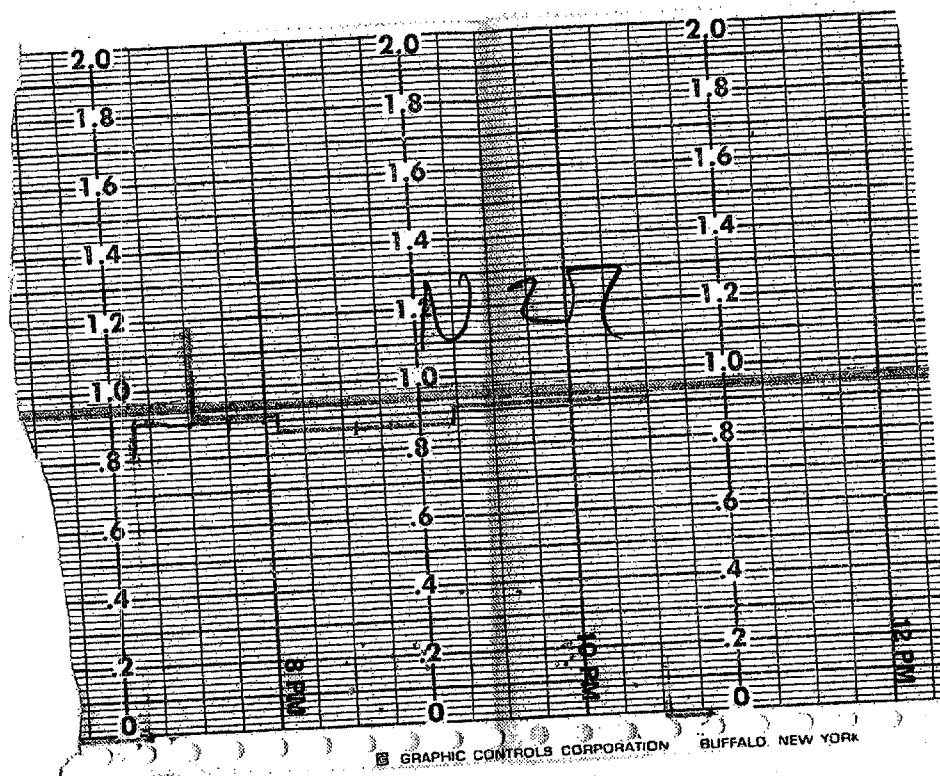
30 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
31 SIFT IN BLANC FIXE N ✓ 165 128-A 165
SV 32 SP STEP 23/53.
33 RECORD: PH *3.4* (3.3-3.7) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.3-3.7 & RECORD: PH _____
NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
PADGER METER. STIR 5 MIN AFTER EACH ADDITION.

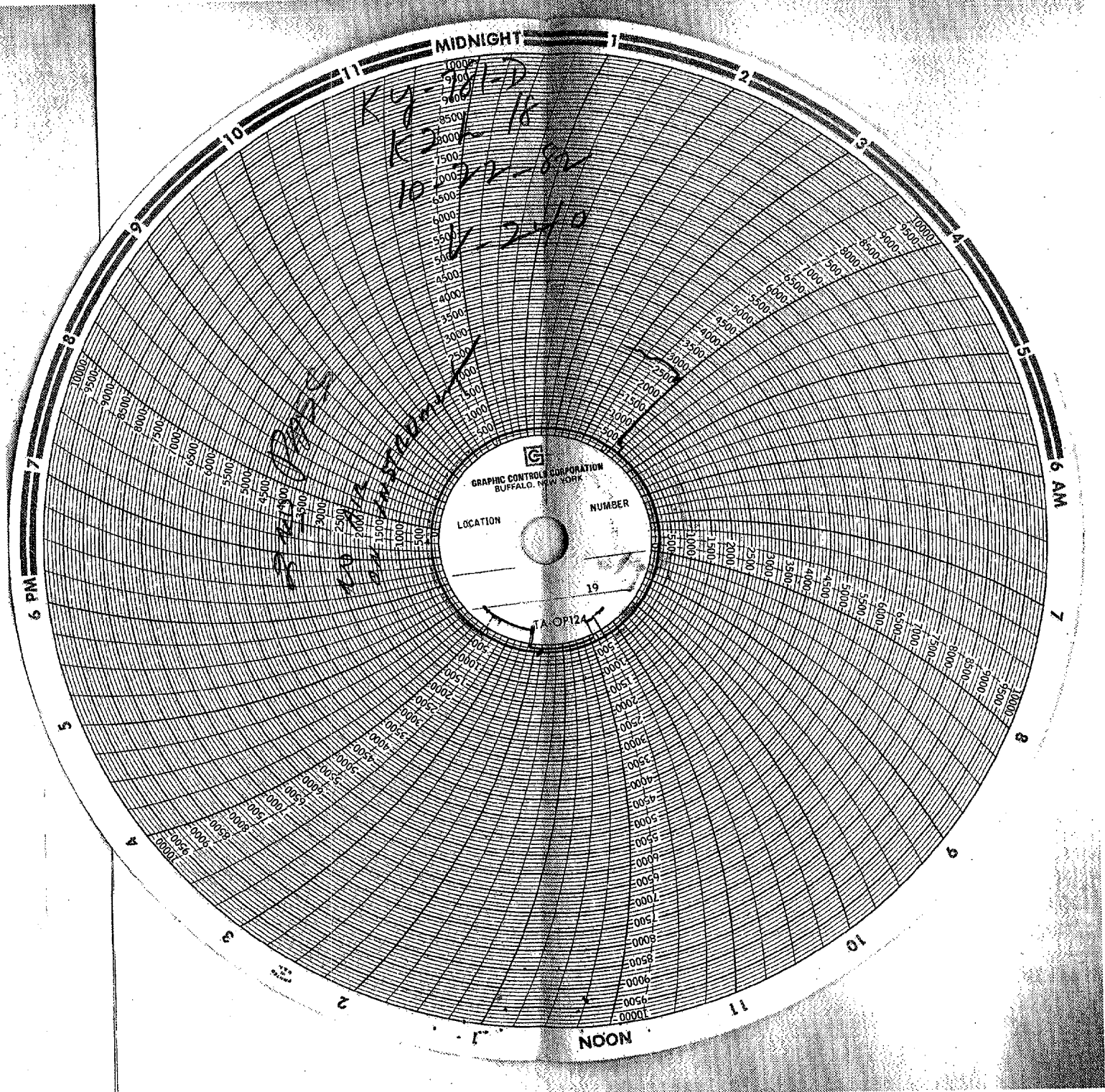
ASSUME 50% 115-D
SP 34 RUN IN N-7-D FROM S-29 IN 10-12 MIN, STIR 5 MIN
7 35 RECORD: PH *4.3* (4.2-4.4). ADJ IF NECESSARY &
RECORD: PH _____ ASSUME 77% 27-D
(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 7-D
(SIPHON N-7-D INTO SV)

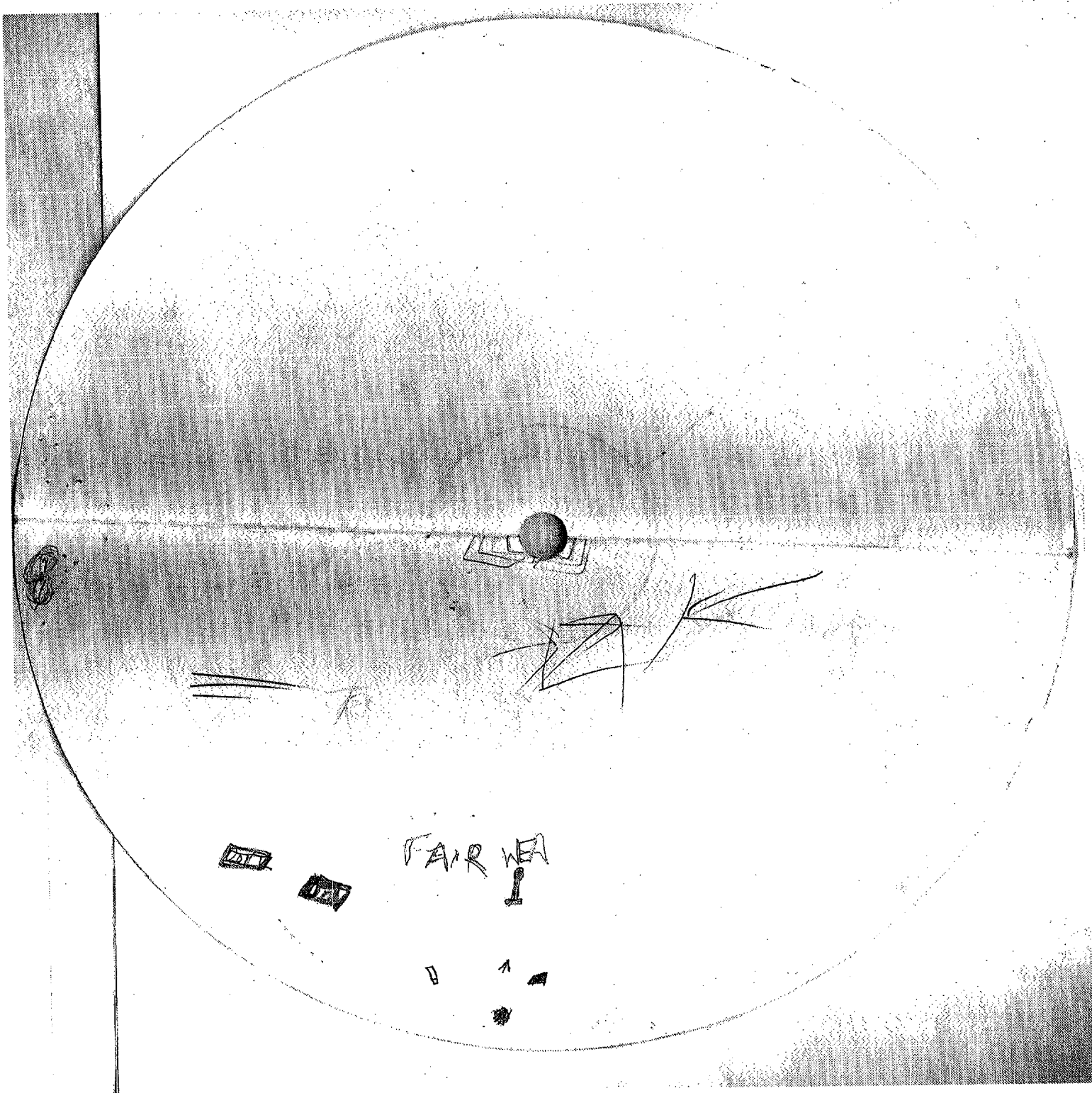
36 OPERATOR STEP PB
37 SP STEP 24/54-ADD PLASTOLEIN 9746A & STIR 5 MIN 40 978-A 40
38 OPERATOR STEP PB
39 SP STEP 60. BATCH COMPLETE.

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<i>11:00</i>	<i>7:4</i>	<i>120</i>
<i>11:00A</i>	<i>3:00P</i>	<i>156</i>
<i>3:00</i>	<i>7:50</i>	<i>202</i>









DUP050103491

MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE Ky-781 LOT K2410

NET WT/PKG NO. PKG PACK. WGT LOCATION PQ

50 85 4250 TOTAL NET WT. 4250 PKG. N-CODE 1000PROD. SPVR. RA DATE 11/1/82 WHSE. OPER.

STUMP

4316

DUP050103492