

CG 02-

CODE KY-907-D

PROCESSES

APPROVED BY

() KY-907-D (F)

FWP 10/8/80

STANDARD HRS.

TIME 11A M

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TYPED BY: FWP 10/8/80

CG CODE PQ LOT LBS
 14 YC002B 93
 14 YC002B 93
 14 YC002B 93

TOTAL EST'D WGT 6053

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	NCODE	ACCT LBS
203 & 205	1 RUN 60" (990 GAL) WATER INTO V-203 & ADD CAUSTIC RUN AGITATOR ON HIGH SPEED	40	7-D	20
205	2 WEIGH SODIUM SILICATE INTO DRUM & POUR IN 3 DUMP IN CHROME YELLOW & STIR 5 MIN RECORD: START _____ FIN _____	320 48X50	32-D YC-2-B	320 2400
1	4 ADJUST TO 75" (1275 GAL) 5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2400-2600 PSI INTO V-205 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-____, START AGITATOR & INSTALL TEMP CHART 10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START _____ TOTAL MINUTES _____ 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	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 15 RUN 1000# WATER INTO V-384 & PUMP TO V-349 3 16 ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN 17 RECORD DENSITY: _____ G/ML (1.138-1.142)	3220	32-D	3220
SV 4	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO ____" (2420 GAL) 19 RECORD: PH _____ & ADJ TO 11.1-11.3 WITH CAUSTIC AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH _____ 20 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		7-D	
343 & 386	21 WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343 22 METER IN SULFURIC ACID FROM V-386 MK _____ #/GAL, _____ GAL 123 STIR 15 MIN OR LONGER		27-D	481

	25	WHEN S 20 HEATING COMPLETE, RECORD: PH			
	26	SET V-343 ACID PUMP AT 57 SETTING (225 MIN)			
	27	SET V-349 SILICATE PUMP AT 48 SETTING (180 MIN)			
SV	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
		AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 -----			
		V-349 -----			
		V-343 V-349 SV NORMAL			
		TIME INCHES INCHES PH PH			
		AT 20 MIN (36) (15) (9.3-10.0)			
		40 MIN (33) (13) (9.3-10.0)			
6		1 HR (29) (11) (9.3-10.0)			
		2 HR (19) (6) (9.3-10.0)			
		3 HR (8) (0) (9.3-10.0)			
		FINISH (0) (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 ASSUME 77%			
	30	SIFT IN	50	27-D 128-A	50
385	31	RUN 40" (308 G) WATER INTO V-385 & HEAT TO			
7		135-140°F			
	32	DUMP IN & STIR TO DISSOLVE FOR S-60	280	15-A	280
302	33	ADD 17" (208 G) WATER TO V-302			
8	34	ADD & STIR FOR 2 MIN FOR S 62 ASSUME 50%	100	7-D	50
	35	DURING STRIKE PUMP INTO PT	558	169-A	558
PT	36	PUMP IN	62	155-A	62
9	37	PUMP IN	62	160-A	62
	38	STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			
	39	DURING STRIKE RUN 18" (317 G) WATER INTO V-356			
	40	TURN ON STEAM			
356	41	ADJ TO 23" (403 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			

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____. (3.3-3.7)			
	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____. (4.2-4.4) & 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			

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

CG 03 CODE KY-907-D PKG
→ OCT 60 37414
EST. WGT. 1853 LBS.

OK
1/8

PROCESSING INSTRUCTIONS: BATCH UNIT

	PROCESSES	APPROVED BY
	KY-907-D (F)	FWK 12/12/7
	Alternate	DCG 12/14/7
	TYPED BY	
	ri 2/8/77	
emw031579 MAKING NOTES		FWP 03-15-79
REMARKS		

TOTAL WGT. 6053#

AME: KROLOR® YELLOW - MEDIUM

NON-BLEEDING

INSTRUCTIONS

-PRESSING-

RECORD

AT						PRESSLOAD	1ST	2ND	3RD	4TH	5TH
ATE						STARTED					
IME						CAKES USED					
ELEASED BY						WATER ON					
RESS	96					HRS. WASHED					
O. OF CAKES	72					OHMS					
RESS With						HRS. WASHED					
ASH TO 2000						OHMS					
EST AFTER 3						HRS. WASHED					
OAD on 10 cars						OHMS					
						CAKE CONDITION					
						NO. CARS LOADED					
						EXPLAIN LOSSES					

MPLES 8oz Jar

ELIVER TO CTL for color

SAMPLED BY

RELEASED BY

Dry on first stage only. Reset every 5 hrs til dry.

24 HOURS AT 180 °F LUMP: - OK - WET - SALTS - CONTAMINATE

NOTE: If dried in 12-23, 80-97, or 138-159 sections:

- dry for 24 hrs at 180°F
- record sections
- fill in additional hrs required if any.

ADDITIONAL DRYING HOURS REQUIRED

MPLES
LIVER TO

NO. CARS PULLED
SAMPLED BY

NO. DRUMS
LUMP WGT.
RELEASED BY

-GRINDING-

LL 939 HSP 1/8" RP SCREEN 3500 RPM
MAX. TEMP. 170°F

SCREEN RPM
MAX. TEMP. °F

EXPLAIN LOSSES

MPLE / WITHOUT MIXING
MPLES 1 ENV & IPT CAN
LIVER TO C.T.L

DATE MIXED

SAMPLED BY

RELEASED BY

DUP050105500

V-243

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 58" (2980 G)
 CP 19 RECORD PH 9.6. ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 20 SIPHON INTO SV. RECORD: PH 11.7 ASSUME 50% 18 721-D 18
 20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8
 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

13/46 (30 MIN)

PH RANGE

TIME

14/47 (60 MIN)

9.4 9.0-10.0

4:20

15/48 (2 HRS)

9.5 9.0-10.0

4:50

16/49 (3 HRS)

9.4 9.0-10.0

5:50

16/49 (4 HRS)

9.4 9.0-10.0

6:50

17/50 (FINISH)

8.2 7.5-8.5

8:35

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

DRUM 28 WEIGH INTO 55 GAL DRUM

ASSUME 50%

50

7-D

28

6 29 FILL WITH WATER & STIR 2 MIN

28

721-D

30 SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.

SV 31 SP STEP 23/53 - RECORD: PH 3.5 (3.3-3.7)

SP 32 IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7

& RECORD: PH

CP NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140

7 *F IN DRUM. USE 30 GAL WATER TO 50% N-15-A.

STIR 5 MIN AFTER EACH ADDITION.

33 SIFT IN

150

128-A

150

34 SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR
5 MIN

35 RECORD: PH 4.2 (4.0-4.2) & IF NECESSARY ADJ TO

PH 4.0-4.2 & RECORD: PH

ASSUME 77%

27-D

(DILUTE 10 TO 1 WITH WATER)

ASSUME 50%

7-D

SIPHON N-7-D INTO SV

36 OPERATOR STEP PB

37 SP STEP 24/54 - POUR IN & STIR 15 MIN

22

978-A

22

38 OPERATOR STEP PB

39 SP STEP 60 - BATCH COMPLETE

40 OPERATOR STEP PB

PUMP TO V-240

START
TIME SP STEP

11:30

7:00A

FINISH
TIME SP STEP

7:00A

9:30A

OPTR

126

235+244