

MAY -0-81-Σ1020

STANDARD HRS.

TIME _____ M

JOB NAME: 03KY908DME

CG	CODE	FR	LOT	LBS
14	YC003B	93	13669	2000
14	YC003B	93	14025	600
14	YC003B	93		

Homog #3 - 1st Pass

TOTAL EST'D WGT 3549

Loss of Color
Hose Busted

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	NCODE	ACCT LBS
203	1 RUN 60" (990 GAL) WATER INTO V-203			
	2 RUN AGITATOR ON HIGH SPEED			
205	3 WEIGH SODIUM SILICATE INTO DRUM & POUR IN	345	32-D	345
	4 DUMP IN CHROME YELLOW & STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START 1:28 A.M.	2000		
	FIN 2:45 A.M.	600		
	5 ADJUST TO 75" (1275 GAL)			
	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. 44" & ADJUST TO 60" (2100 GAL)			
	9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	10 RUN 2" (200 GAL) WATER INTO V-208, START			
	AGITATOR & INSTALL TEMP CHART			
SV	11 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 10:13 P. TOTAL MINUTES 1:00			
2	12 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
104	13 WHEN V-205 MT, RUN IN 5" (240 GAL) WATER & PUMP			
	THRU HOMOG AT 4800-5200 PSI INTO SV			
349	14 WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
	15 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
384	16 WEIGH INTO V-384 & PUMP TO V-349	1215	32-D	1215
	17 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
	18 ADJ V-349 TO 14" (662 GAL) & STIR 15 MIN			
	19 RECORD DENSITY: 1.063 G/ML (1.063-1.065)			
SV	20 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 11" (2420 GAL)			
	RECORD: PH 9.7 & ADJ TO 11.0-11.2 WITH CAUSTIC			
4	21 AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	50	7-D	25
	22 SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	23 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 192°F			
	& RECORD: 192°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON			
	ON COMPLETION OF HEATING			
124	24 WHILE HEATING SV, RUN 31" (850 GAL) WATER INTO V-345			
343	25 METER IN SULFURIC ACID FROM V-384			
	MK 12 10585 G/GAL 165 GAL			
386	26 STIR 15 MIN OR LONGER		27-D	180
5	27 RECORD: DENSITY 1.016 G/ML (1.014-1.016)			

25	WHEN S 20 HEATING COMPLETE, RECORD: PH <i>9.8</i>			
26	SET V-343 ACID PUMP AT 56 SETTING (180 MIN)			
27	SET V-349 SILICATE PUMP AT 49 SETTING (145 MIN)			
28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
SV	RECORD: START FINISH MINUTES			
	V-343 <i>3:40 AM</i> <i>7:05 AM</i> <i>3.85</i>			
	V-349 <i>6:00 AM</i> <i>7:38</i>			
	V-343 V-349 SV NORMAL			
	TIME INCHES INCHES PH PH			
	AT 20 MIN <i>400A</i> (28) (12) <i>9.6</i> (9.3-10.0)			
	40 MIN <i>420A</i> (24) (10) <i>9.6</i> (9.3-10.0)			
6	1 HR <i>440A</i> (21) (8) <i>9.6</i> (9.3-10.0)			
	2 HR <i>540A</i> (10) (3) <i>9.6</i> (9.3-10.0)			
	FINISH <i>640A</i> (0) (0) <i>7.16</i> (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	7 RUN 27" (210 G) WATER INTO V-385 & HEAT TO 135-140°F			
132	DUMP IN & STIR TO DISSOLVE FOR S-60	415	15-A	415
302	133 ADD 24" (294 G) WATER TO V-302			
8	134 ADD & STIR FOR 2 MIN FOR S 62 ASSUME 50%	100	7-D	50
PT	135 DURING STRIKE PUMP INTO PT	312	169-A	312
9	136 PUMP IN	36	155-A	36
	137 PUMP IN	36	160-A	36
	138 STIR 10 MIN WITH LIGHTENING MIXER FOR S 42			
	139 DURING STRIKE RUN 14" (244 G) WATER INTO V-356			
	140 TURN ON STEAM			
356	141 ADJ. TO 18" (317 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			

V-262

- 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
- 161 RECORD: PH. 3.1 (3.3-3.7)
- 162 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH. 3.1
- 163 RUN IN N-7-D FROM S-34 IN 4-6 MIN & STIR 5 MIN
- 164 RECORD: PH. 3.6 (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
- 165 DO NOT STOP AGITATOR

	START	FINISH	OPERATOR
	12:25 P	3:00 P	235-244
	11:00 P	2:00 A	257-301
	2:00 A	9:00 AM	235-244
STEP	V-262 (20 RPM)	V-243, 244, 246, 247	
9	2"	4"	
18	24"	47"	

27-D
7-D

44

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