

CG 03 CODE KY-787-D

PROCESSES

APPROVED BY

OCT-30-80 27641

( ) KY-787-D (R) FWP 9/18/80

Est'd Wgt 932 LBS

( ) ( ) (XDB-17: 3/4

STANDARD HRS. 10.6 TIME 12:4 M

( ) ( ) N-32-D &amp; 240

( ) ( ) MIN STRIKE)

TYPED BY: FWP 9/18/80

| CG | CODE   | PQ | LOT   | LBS  |
|----|--------|----|-------|------|
| 14 | YC002B | 93 | 13198 | 2100 |
| 14 | YC002B | 93 | 13182 | 300  |
| 14 | YC002B | 93 |       |      |

TOTAL EST'D WGT 3332

NON-BLEEDING

| EQUIP | NAME : "KROLOR" YELLOW MEDIUM                                                                   | USE<br>LBS | NCODE  | ACCT<br>LBS |
|-------|-------------------------------------------------------------------------------------------------|------------|--------|-------------|
| 203   | 1 RUN 60" (990 GAL) WATER INTO V-203. RUN AGITATOR ON HIGH SPEED.                               |            |        |             |
| 203   | 2 WEIGH SODIUM SILICATE INTO DRUM & POUR IN                                                     | 240        | 32-D   | 240         |
| 203   | 3 DUMP IN CHROME YELLOW & STIR 5 MIN                                                            | 48X50      | YC-2-B | 2400        |
| 1     | RECORD: START 3:15 PM LOT 13198                                                                 | 2100       |        |             |
| 1     | FIN 4:15 AM 13182                                                                               | 300        |        |             |
| 1     | 4 ADJUST TO 75" (1275 GAL)                                                                      |            |        |             |
| 1     | 5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-203                  |            |        |             |
| 1     | 6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2400-2600 PSI INTO V-203           |            |        |             |
| 1     | 7 RECORD: V-205 VOL. 58" & ADJUST TO 60" (2100 GAL)                                             |            |        |             |
| 1     | 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY                                                   |            |        |             |
| 203   | 9 RUN 4" (200 GAL) WATER INTO V-203. START AGITATOR & INSTALL TEMP CHART                        |            |        |             |
| SV    | 10 PUMP V-203 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:14 AM TOTAL MINUTES 450 |            |        |             |
| 2     | NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205      |            |        |             |
| 11    | 11 WHEN V-203 MT, RUN IN 5" (240 GAL) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV          |            |        |             |
| 349   | 12 WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349                                               |            |        |             |
| 349   | 13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F                                               | 1380       | 32-D   | 1380        |
| 384   | 14 WEIGH INTO V-384 & PUMP TO V-349                                                             |            |        |             |
| 3     | 15 RUN 1000# WATER INTO V-384 & PUMP TO V-349                                                   |            |        |             |
| 3     | 16 ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN                                                     |            |        |             |
| 3     | 17 RECORD DENSITY: 1.059 G/ML (1.059-1.060)                                                     |            |        |             |
| SV    | 18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 42" (2420 GAL)                                           |            |        |             |
| 4     | 19 RECORD: PH 9.9 & ADJ TO 11.1-11.3 WITH CAUSTIC AT 5% (10 PARTS WATER TO 1 PART N-7-D)        |            |        |             |
| 4     | 20 ASSUME 50% SIPHON N-7-D INTO SV & RECORD: PH 11.3                                            | 18         | 22-D   | 18          |
| 4     | 21 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 19.5°F                                              |            |        |             |
| 4     | & RECORD: 19.5°F                                                                                |            |        |             |
| 4     | NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON ON COMPLETION OF HEATING                            |            |        |             |
| 343   | 22 WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343 & METER IN SULFURIC ACID FROM V-386    |            |        |             |
| 343   | 23 MK 1.275 G/GAL 1.014                                                                         |            |        |             |
| 343   | 24 STIR 15 MIN OR LONGER                                                                        |            |        |             |
| 5     | 25 RECORD: DENSITY G/ML (1.013-1.014) 1.014                                                     |            |        |             |

124 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0

125 SET V-343 ACID PUMP AT 49 SETTING (285 MIN)

126 SET V-349 SILICATE PUMP AT 38 SETTING (240 MIN)

127 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV

SV AT 190-194°F DURING STRIKE

128 RECORD: START FINISH MINUTES

|       |      |       |           |
|-------|------|-------|-----------|
| V-343 | 9:20 | 7:45  | 2:35      |
| V-349 |      | 7:45  | 2:45      |
| V-343 |      | V-349 | SV NORMAL |

TIME INCHES INCHES PH

|           |      |      |      |            |
|-----------|------|------|------|------------|
| AT 20 MIN | (37) | (16) | 9.9  | (9.3-10.0) |
| 40 MIN    | (34) | (14) | 10.0 | (9.3-10.0) |
| 1 HR      | (31) | (13) | 10.0 | (9.3-10.0) |
| 2 HR      | (23) | (9)  | 9.9  | (9.3-10.0) |
| 3 HR      | (15) | (4)  | 9.9  | (9.3-10.0) |
| 4 HR      | (6)  | (0)  | 9.9  | (9.3-10.0) |
| FINISH    | (0)  |      | 7.3  | (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%

27-D

330 129 RUN 20" (392 GAL) WATER INTO V-330 & HEAT TO 80-100°F

130 ADD DRESINATE "X" IN 7-8 MIN

131 STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)

132 STIR 20 MIN OR LONGER FOR S-45

350 530-A 350

385 133 RUN 40" (368 GAL) WATER INTO V-385 & HEAT TO 135-140°F

134 DUMP IN ALUM & STIR TO DISSOLVE FOR S-41

160 15-A 160

302 135 ADD 30" (360 GAL) WATER TO V-302

9 136 ADD & STIR 2 MIN FOR S-43 ASSUME 50%

90 128-D 90

SV 137 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING

10 138 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR

139 TURN OFF STEAM

140 SIFT IN BLANC FIXE

141 RUN IN V-385 FROM S 34 & STIR 5 MIN

142 RECORD: PH 3.4 (3.7-4.2)

143 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN

144 RECORD: PH 9.4 (9.0-9.5) & IF NECESSARY ADJ TO PH 9.0-9.5. RECORD: PH \_\_\_\_\_ ASSUME 77%

DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%

STIR N-7-D INTO SV

145 RUN IN V-330 THRU 20 MESH SCREEN & STIR 20 MIN

27-D 7-D

313 146 RUN 10" (128 GAL) WATER INTO V-313

11 147 DUMP IN CALCIUM CHLORIDE & STIR 5 MIN FOR S-46

135 20-A 135

SV 148 RUN V-313 INTO SV IN 15-20 MIN

12 149 STIR 15 MIN & RECORD: PH 9.4 (9.0-10.0)

150 STOP AGITATOR (DO NOT STOP AGITATOR IN V-262)

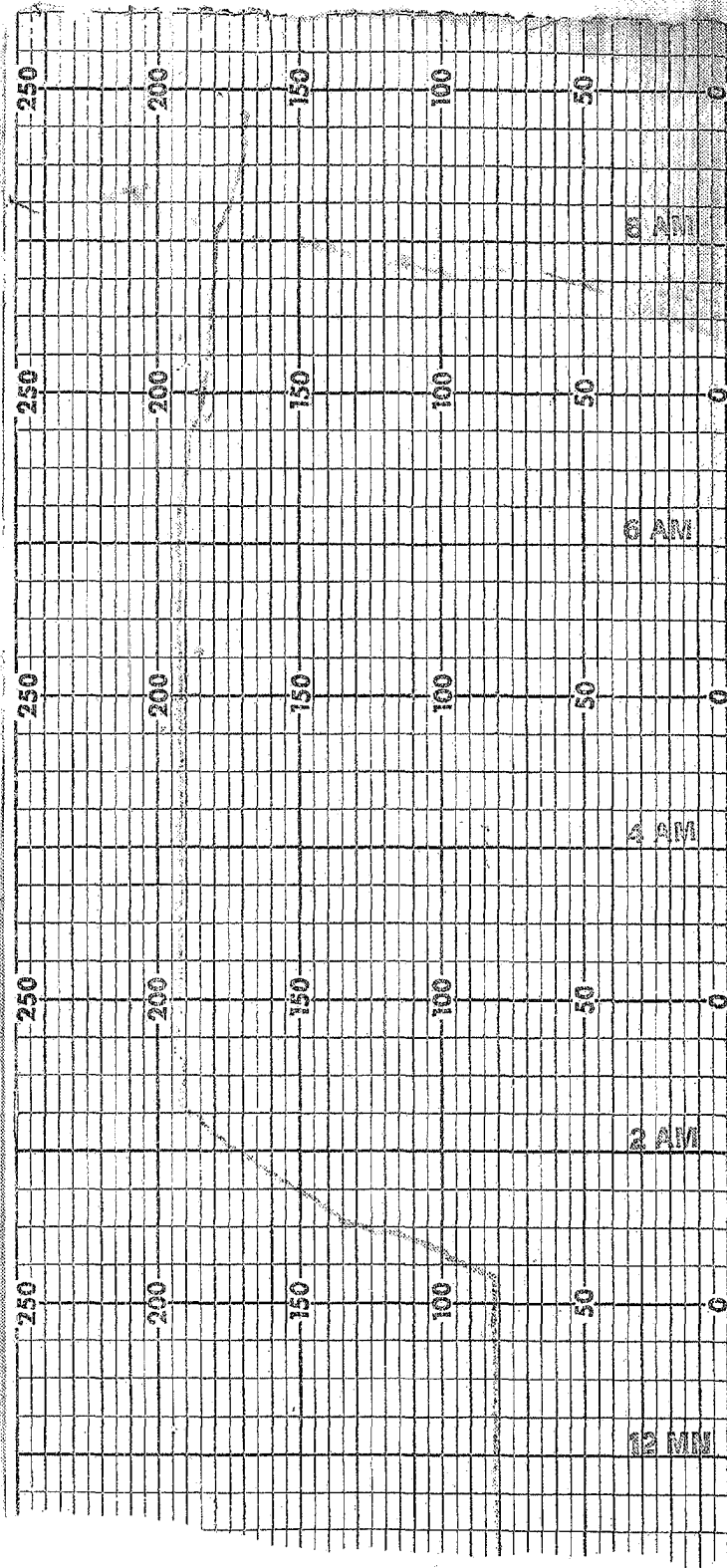
|          |         |          |
|----------|---------|----------|
| START    | FINISH  | OPERATOR |
| 11:00 AM | 2:44 PM | 282-243  |
| 7:00 AM  | 4:15 PM | 120-301  |
| 2:00 PM  |         | 37-244   |

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

9 2" 4"

18 24" 42"





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