

F2H67

MAY 26 1982

STANDARD HRS.

TIME

2 P M.

PROCESSES

APPROVED BY

() KY-908-D (F)

FWP 03/26/82

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JOB NAME: 03KY908DMF

CG	CODE	PQ	LOT	LBS
14	YC-3-B	93	14274	2600
14	YC-3-B	93	D2D09	2000
14	YC-3-B	93		

EST. WT. 6110* LBS.

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	NCODE	ACCT LBS
	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
203	1 RUN 60" (990 GAL) WATER INTO V-203			
	2 RUN AGITATOR ON HIGH SPEED			
V-263	3 WEIGH SODIUM SILICATE INTO DRUM & POUR IN	610	32-D	610
	4 DUMP IN CHROME YELLOW & STIR 5 MIN	92X50	YC-3-B	4600
	RECORD: START 6:30 PM 14274	2600		
	FIN 8:30 PM D2D09	2000		
	5 ADJUST TO 75" (1275 GAL) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	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-263			
	8 RECORD: V-263 VOL. 42" & ADJUST TO 60" (2100G)			
V-263	9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	10 RUN 4" (200 GAL) WATER INTO V-246 START			
	11 AGITATOR & INSTALL TEMP CHART.			
SV	12 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 10:25 AM TOTAL MINUTES 130			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	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	2150	32-D	2150
	17 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	18 ADJ V-349 TO 20" (944 GAL) & STIR 15 MIN			
	19 RECORD DENSITY: 1.077/ML (1.077-1.080)			
SV	20 WHEN S-11 HOMOG COMPLETE, ADJ SV TO 48" (2420G)			
	21 RECORD: PH 9.8 & ADJ TO 11.0-11.2 WITH CAUSTIC			
4	22 AT 5% (1.0 PARTS WATER TO 1 PART N7D) ASSUME 50%	44	7-D	22
	23 SIPHON N-7-D INTO SV & RECORD: PH 11.2			
	24 HEAT TO 190-194°F IN 55-65 MIN & REC: HT ____ °F			
	& RECORD: ____ °F NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

JUN 3 1982

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LOT

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EQUIP MENT	PAGE 2 CG 03 KY-908-D COMTYP JOB NAME: 03KY908DMF	USE LBS	N- CODE	ADCT LBS
343	WHILE HEATING SV, RUN 45" (1237G) WATER INTO V343			
&	METER IN SULFURIC ACID FROM V-386			
386	MK 17 10.384/GAL, 30.8 GAL		27-D	318
5	STIR 15 MIN OR LONGER			
	RECORD: DENSITY 1.016 G/ML (1.015-1.016)			
	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.5			
	SET V-343 ACID PUMP AT 64 SETTING (225 MIN)			
	SET V-349 SILICATE PUMP AT 57 SETTING (180 MIN)			
SV	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
	AT 190-194°F DURING STRIKE			
	RECORD: START FINISH MINUTES			
	V-343 4:35 6:35 7:40			
	V-349 7:40 7:40 1:15			
	V-343 V-349 SV NORMAL			
	TIME INCHES INCHES PH PH			
	AT 20 MIN 4:55 (42) 43 (18) 19 9.4 (9.3-10.0)			
	40 MIN 5:15 (38) 39 (15) 15 9.4 (9.3-10.0)			
	1 HR 5:35 (34) 35 (13) 13 9.4 (9.3-10.0)			
	2 HR 6:55 (22) 23 (6) 6 9.5 (9.3-10.0)			
	3 HR 7:35 (11) 12 (0) 1 9.4 (9.3-10.0)			
	FINISH 8:20 (0) 0 (0) 0 7.1 (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%			
	SIFT IN	50	27-D	128-A 50
385	ADD 42" (320 G) WATER TO V-385			
7	ADD & STIR FOR 2 MIN FOR S 61	ASSUME 50%	160	7-D 80
	DURING STRIKE CHECK LEVEL IN V-387			
387	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-37			
8	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING			
	THAT LOW LEVEL FEG IN VAT IS ABOVE SURFACE			
	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW			
	STEARATE MAKE-UP PROCEDURE.			
	RUN IN 32" (317 GAL). DO NOT MAKE UP THIS			
388	SOLUTION MORE THAN 30 MINUTES IN ADVANCE.			
9	DELAY BETWEEN END OF STEP 43 HEAT-UP AND			
	START OF STEP 52 HOMOGENIZATION SHOULD BE			
	LESS THAN 30 MINUTES.			
	TURN ON STEAM & AGITATOR			
	ADJ TO 42" (403 G) AT 178-182°F			
	SET BADGER METER FOR 698±			
	PUMP IN FROM V-387 THRU UNDERSURFACE	570	169-A	570
	DISTRIBUTORS AS FAST AS POSSIBLE	64	155-A	64
		64	160-A	64
	SHUT OFF PUMP			
	STIR 30 MIN AT 178-182°F FOR S 52			
	DO NOT SHUT OFF AGITATOR			
SV	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &			
10	SET PUMP AT ZERO SETTING			
	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &			
	TURN OFF PUMP MOTOR			

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EQUIP	PAGE 3	CG 03	KY-908-D	USE	N-	ACCT
MENTI	COMTYP	JOB NAME:	03KY908DMF	LBS	CODE	LBS

47	HEAT TO 198-200°F IN 5-10 MIN			
48	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
SV 49	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP			
10	INLET			
50	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			
51	WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE TO SV & CLOSE VALVE TO SEWER			
52	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
53	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
54	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
55	TURN OFF HOMOG & STEARATE PUMP			
56	STIR 5 MIN AT 198-200°F			
57	SHUT OFF STEAM			
58	RUN IN ALUM USING BADGER METER	830	115-D	415
59	FLUSH ALUM LINE WITH WATER			
60	RECORD PH <u>3.2</u> (3.3-3.7). IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD PH			
	NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION.			
			115-D	
61	RUN IN N-7-D FROM S-32 IN 4-6 MIN & STIR 5 MIN			
62	RECORD: PH <u>3.6</u> (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH <u>4.2</u> ASSUME 78% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%	96	27-D	48
	SIPHON N-7-D INTO SV.		7-D	
63	DO NOT STOP AGITATOR			

START

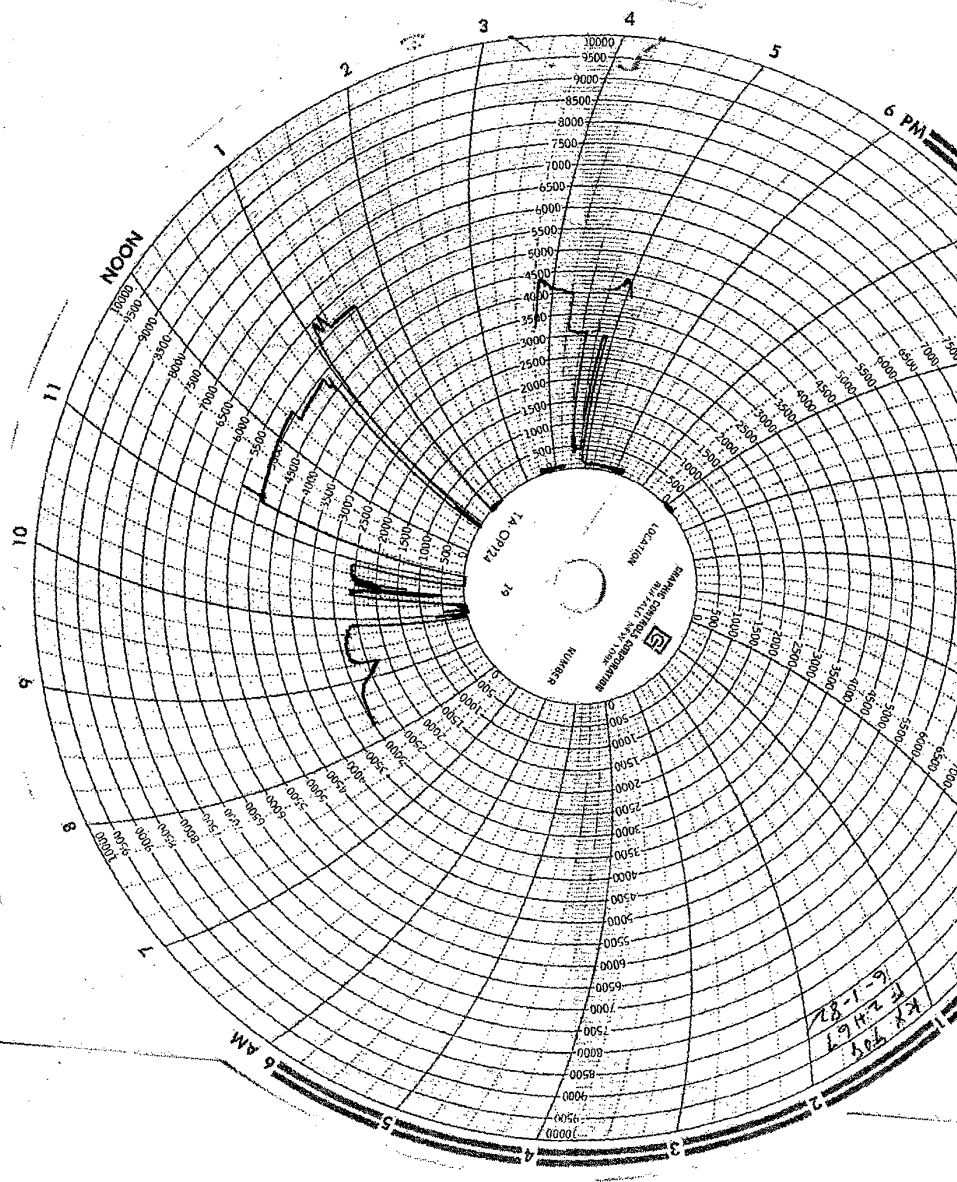
11:00 AM
7 AM

FINISH

7:20 PM

OPERATOR

3/26/82
120-144



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