

CG 18 CODE GC-1-A PKO.

→ NOV 13 80 37957

EST. WGT. 2166 LBS.

STD. HRS. TIME 3: P M

| PROCESSES   |        | APPROVED BY |             |
|-------------|--------|-------------|-------------|
| (C)         | GC-1-A | ( )         | AJC 1-10-78 |
| ( )         |        | ( )         | OCG 1-13-78 |
| ( )         |        | ( )         | MTW 3-6-78  |
| ( )         |        | ( )         |             |
| TYPED BY    |        |             |             |
| NSA 3-14-78 |        |             |             |

## NON-BLEEDING

| EQUIPMENT | NAME: MONASTRAL® GREEN G                                                                                       | USE LBS. | N CODE | ACCT. LBS. |
|-----------|----------------------------------------------------------------------------------------------------------------|----------|--------|------------|
| PREP 1    | 1 Install Temp & Amps Charts Daily                                                                             |          |        |            |
|           | 2 Weigh GC-1-A Borax Sludge for S-5 + 11. Record Wgt. in S-23 per Calc S-3                                     |          |        |            |
|           | NOTE: Total Wgt Includes Liquid. After Weighing, Dipper Off Excess Liquid & Pour Into V-291 Thru Classifier    |          |        |            |
|           | 3 Calc For S-10, 12 & 23<br>500# - (0.7 x # Sludge, S-2) = # N-972-A<br>720 #                                  |          |        |            |
| HF Mill 2 | 4 Start agitator with cooling water off                                                                        |          |        |            |
|           | 5 Dump in 1 buggy of sludge from S-2 & add                                                                     | 18       | 567-R  | 0          |
|           | 6 Dump in & stir 10-15 min to uniformity                                                                       | 150      | 8000-A | 0          |
|           | NOTE: Turn on water sprays when mill temp reaches 120°F<br>Omit S-7-9 on 1st charge of 1st batch of a campaign |          |        |            |
| CLASS 3   | 7 During S-6 stir, backwash lines from classifier to V-391 & place cart under sludge discharge                 |          |        |            |
| 391 4     | 8 Adj to 36" (420 G) & turn on agitator                                                                        |          |        |            |
| 291 5     | 9 Run V-391 at 3.0-3.5 GPM (120-140 Min) thru classifier into V-291                                            |          |        |            |
| HF-Mill 6 | 10 During S-9 dump in all but 50# N-972-A Calc in S-3                                                          |          | 972-A  | 0          |
|           | 11 Add 2nd buggy of sludge from S-2 & stir 3-6 min to uniformity                                               |          |        |            |
|           | 12 Add 50# N-972-A from S-10 & Adj to 27-32 AMPS with N-972-A or water                                         |          | 972-A  | 0          |
|           | 13 When 27-32 AMPS reached with 15" Vortex Stir for 3 Hrs at 27-32 AMPS & below 130°F                          |          |        |            |
|           | A. Add N-972-A water or ice to maintain 27-32 AMPS below 130°F                                                 |          |        |            |
|           | B. Record all N-Code ingredients used in table S-23                                                            |          |        |            |
|           | C. Record data in table S-40                                                                                   |          |        |            |
|           | 14 When S-13 stir completed, add 5-10 Gal water avoiding overflowing HF-Mill                                   |          |        |            |
|           | 15 Stop agitator & Cooling water sprays                                                                        |          |        |            |
|           |                                                                                                                |          |        |            |
| CLASS 7   | 16 When S-9 complete & V-391 MTW Close Classifier Feed Valve & backwash line to V-391 for 30 secs.             |          |        |            |
|           | 17 Open feed valve & drain V-391 to classifier<br>NOTE: DO NOT WASH IN V-391                                   |          |        |            |
|           | 18 Stop V-391 agitator & close classifier feed valve                                                           |          |        |            |

| EQUIPMENT   | PAGE                                                                                                                               | 2 CG                                                                                                                | CODE GC-1-A | EST. WGT. | 2166         | LBS.   | USE LBS.        | N CODE | ACCT. LBS. |      |
|-------------|------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|-------------|-----------|--------------|--------|-----------------|--------|------------|------|
| 391<br>8    | 19                                                                                                                                 | When S-15 done turn on agitator & pump in charge from HF-Mill continuously diluting mill charge with #100 Gal water |             |           |              |        |                 |        |            |      |
|             | 20                                                                                                                                 | Wash in Mill & flush pumping lines into V-391                                                                       |             |           |              |        |                 |        |            |      |
| 180<br>9    | 21                                                                                                                                 | Pump V-291 to V-180                                                                                                 |             |           |              |        |                 |        |            |      |
|             | NOTE: V-382 May Be Used As An Auxiliary Collection Vat Up to 10 Charges. If Used Heat V-382 to 150-160°F before Running Into V-180 |                                                                                                                     |             |           |              |        |                 |        |            |      |
| MISC.<br>10 | 22                                                                                                                                 | Repeat S 1-21 until 15 charges are collected in V-180                                                               |             |           |              |        |                 |        |            |      |
|             | 23                                                                                                                                 | Charge out raw materials in Table 1 below:                                                                          |             |           |              |        |                 |        |            |      |
| TABLE 1     |                                                                                                                                    |                                                                                                                     |             |           |              |        |                 |        |            |      |
| CHGE NO     | N-567-B LBS                                                                                                                        | REC SLUDGE #AS IS                                                                                                   | 100%        | #S3       | N-972-A #S13 | #TOTAL | N-8000-A LOT NO | #      | OPTR       |      |
| 1           | 18                                                                                                                                 | 775                                                                                                                 | 543         | 177       | -            | 177    | 820             | 150    | 114        |      |
| 2           | 18                                                                                                                                 | 650                                                                                                                 | 455         | 265       | -            | 265    | 828             | 150    | 114        |      |
| 3           | 18                                                                                                                                 | 710                                                                                                                 | 532         | 188       | -            | 188    | 837             | 150    | 88         |      |
| 4           | 18                                                                                                                                 | 670                                                                                                                 | 469         | 251       | -            | 251    | 837             | 150    | 211        |      |
| 5           | 18                                                                                                                                 | 700                                                                                                                 | 490         | 230       | -            | 230    | 834             | 150    | 211        |      |
| 6           | 18                                                                                                                                 | 760                                                                                                                 | 532         | 188       | 12           | 200    | 835             | 150    | 105        |      |
| 7           | 18                                                                                                                                 | 730                                                                                                                 | 511         | 209       | -            | 209    | 834             | 150    | 109        |      |
| 8           | 18                                                                                                                                 | 850                                                                                                                 | 595         | 185       | -            | 125    | 884             | 150    | 109        |      |
| 9           | 18                                                                                                                                 | 770                                                                                                                 | 539         | 181       | -            | 181    | 837             | 150    | 166        |      |
| 10          | 18                                                                                                                                 | 757                                                                                                                 | 530         | 190       | -            | 190    | 835             | 150    | 101        |      |
| 11          | 18                                                                                                                                 | 823                                                                                                                 | 576         | 144       | -            | 144    | 835             | 150    | 101        |      |
| 12          | 18                                                                                                                                 | 780                                                                                                                 | 546         | 174       | -            | 174    | 835             | 150    | 105        |      |
| 13          | 18                                                                                                                                 | 745                                                                                                                 | 522         | 198       | -            | 198    | 834             | 150    | 88         |      |
| 14          | 18                                                                                                                                 | 870                                                                                                                 | 609         | 111       | -            | 111    | 836             | 150    | 211        |      |
| 15          | 18                                                                                                                                 | 860                                                                                                                 | 605         | 115       | -            | 115    | 830             | 150    | 322        |      |
| TOTALS      | 270                                                                                                                                |                                                                                                                     |             |           |              | 2758   |                 | 2250   |            |      |
| 24          | Enter Total Lbs of R/Ms in Acct Lbs column                                                                                         |                                                                                                                     |             |           |              |        |                 | 0      | 567-B      | 270  |
|             | NOTE: Enter Chge. No. Being Milled. Extra Spaces Included In Table For Use If More Than 1-Lot N-8000-A Used In A Chge.             |                                                                                                                     |             |           |              |        |                 | 0      | 972-A      | 2758 |
|             |                                                                                                                                    |                                                                                                                     |             |           |              |        |                 | 0      | 8000-A     | 2250 |
| 180<br>11   | 25                                                                                                                                 | Turn on agitator & install Temp Chart                                                                               |             |           |              |        |                 |        |            |      |
|             | 26                                                                                                                                 | Run in from V-386 M 68 67.11 % 1565                                                                                 |             |           |              |        |                 |        | 27-D       | 1050 |
|             | 27                                                                                                                                 | Record: pH 1.3 (1.0-2.0)                                                                                            |             |           |              |        |                 |        |            |      |
|             | 28                                                                                                                                 | If necessary Adj to pH 1.0-2.0 Assume 78%                                                                           |             |           |              |        |                 |        | 27-D       | -    |
|             | 29                                                                                                                                 | Record: pH -                                                                                                        |             |           |              |        |                 |        |            |      |
|             | 30                                                                                                                                 | Heat to 178-182°F in 40-45 Min                                                                                      |             |           |              |        |                 |        |            |      |

| EQUIPMENT | PAGE | CG                                                      | 18 | CODE | GC-1-A | EST. WGT. | 2166 | LBS. | USE  | N     | ACCT. |
|-----------|------|---------------------------------------------------------|----|------|--------|-----------|------|------|------|-------|-------|
|           |      |                                                         |    |      |        |           |      |      | LBS. | CODE  | LBS.  |
| 384       | 120  | Run in 2250# water into V-384                           | 3  | 3    | 100    | 100       | 100  | 100  | 100  | 28-D  | 31    |
| 12        | 121  | Weigh in Acid-Drum & pour in                            | 3  | 3    | 10     | 3635      | 100  | 100  | 100  | 28-D  | 54    |
| 303       | 122  | Turn on agitator & steam                                | 3  | 3    |        |           |      |      |      |       |       |
|           | 123  | Weigh & Add in 3-5 min                                  | 3  | 3    | Lot    | 100       | 100  | 100  | 100  | 365-B | 180   |
|           | 124  | Heat to 130-140°F & stir to dissolve for S-35           | 3  | 3    |        |           |      |      |      |       |       |
| 180       | 135  | When S-29 Complete Run V-384 at 130-140°F into V-180 at | 3  | 3    |        |           |      |      |      |       |       |
| 13        | 136  | 178-182°F in 10-15 min                                  | 3  | 3    |        |           |      |      |      |       |       |
|           | 137  | Stir 30 Min at 178-182°F                                | 3  | 3    |        |           |      |      |      |       |       |
|           | 138  | Record: Spot Test (+) (-)                               | 3  | 3    |        |           |      |      |      |       |       |
|           | 139  | If (-), Contact Supervisor                              | 3  | 3    |        |           |      |      |      |       |       |
|           | 140  | Flood to 86" (9159 G) at 178-182°F                      | 3  | 3    |        |           |      |      |      |       |       |
|           | 141  | Stop Agitator                                           | 3  | 3    |        |           |      |      |      |       |       |
|           |      | NOTE: DURING PRESSING, REHEAT SV TO 178-182°F           | 3  | 3    |        |           |      |      |      |       |       |
|           |      | AT THE START OF EACH SHIFT                              | 3  | 3    |        |           |      |      |      |       |       |
| MISC      | 40   | Record Data while milling (once each charge)            | 3  | 3    |        |           |      |      |      |       |       |
| 14        |      |                                                         | 3  | 3    |        |           |      |      |      |       |       |

| CHGE NO | DATE     | TIME    |         | MILL HRS | TIME    | ACCURACY AMPS |     | °F  |
|---------|----------|---------|---------|----------|---------|---------------|-----|-----|
|         |          | START   | FIN     |          |         | AMMETER       | REC |     |
| 1       | 11-13-80 | 12:45A  | 3:45A   | 3        | 3AM     | 28            | 27  | 120 |
| 2       | 11-13-80 | 6:30A   | 9:30A   | 3        | 7:30AM  | 28            | 27  | 118 |
| 3       | 11-14-80 | 4:30PM  | 7:30PM  | 3        | 6:15PM  | 31            | 30  | 113 |
| 4       | 11-14-80 | 12:30AM | 3:30AM  | 3        | 2:00AM  | 29            | 29  | 118 |
| 5       | 11-17-80 | 8:30AM  | 11:30AM | 3        | 10:30AM | 29            | 29  | 123 |
| 6       | 11-17-80 | 4:30P   | 7:30P   | 3        | 6:00P   | 28            | 28  | 120 |
| 7       | 11-17    | 1:30AM  | 4:30AM  | 3        | 3:20AM  | 31            | 31  | 116 |
| 8       | 11-17    | 6:45AM  | 9:45AM  | 3        | 8:15    | 30            | 30  | 108 |
| 9       | 11-18-80 | 4:45AM  | 7:45AM  | 3        | 6:00PM  | 27            | 27  | 110 |
| 10      | 11-19-80 | 9:15A   | 12:15A  | 3        | 11:15A  | 30            | 30  | 115 |
| 11      | 11-19-80 | 2:30P   | 5:30P   | 3        | 4:30P   | 29            | 29  | 115 |
| 12      | 11-19    | 7:30P   | 10:30P  | 3        | 9:00P   | 29            | 29  | 118 |
| 13      | 11-19    | 12:11M  | 3:11M   | 3        | 1:30AM  | 30            | 30  | 112 |
| 14      | 11-20    | 12:28M  | 3:28M   | 3        | 2:30M   | 30            | 30  | 118 |
| 15      | 11-20    | 5:30M   | 8:30P   | 3        | 7:15M   | 28            | 28  | 113 |
| 16      |          |         |         |          |         |               |     |     |
| 17      |          |         |         |          |         |               |     |     |
| 18      |          |         |         |          |         |               |     |     |
| 19      |          |         |         |          |         |               |     |     |
| 20      |          |         |         |          |         |               |     |     |
| 21      |          |         |         |          |         |               |     |     |

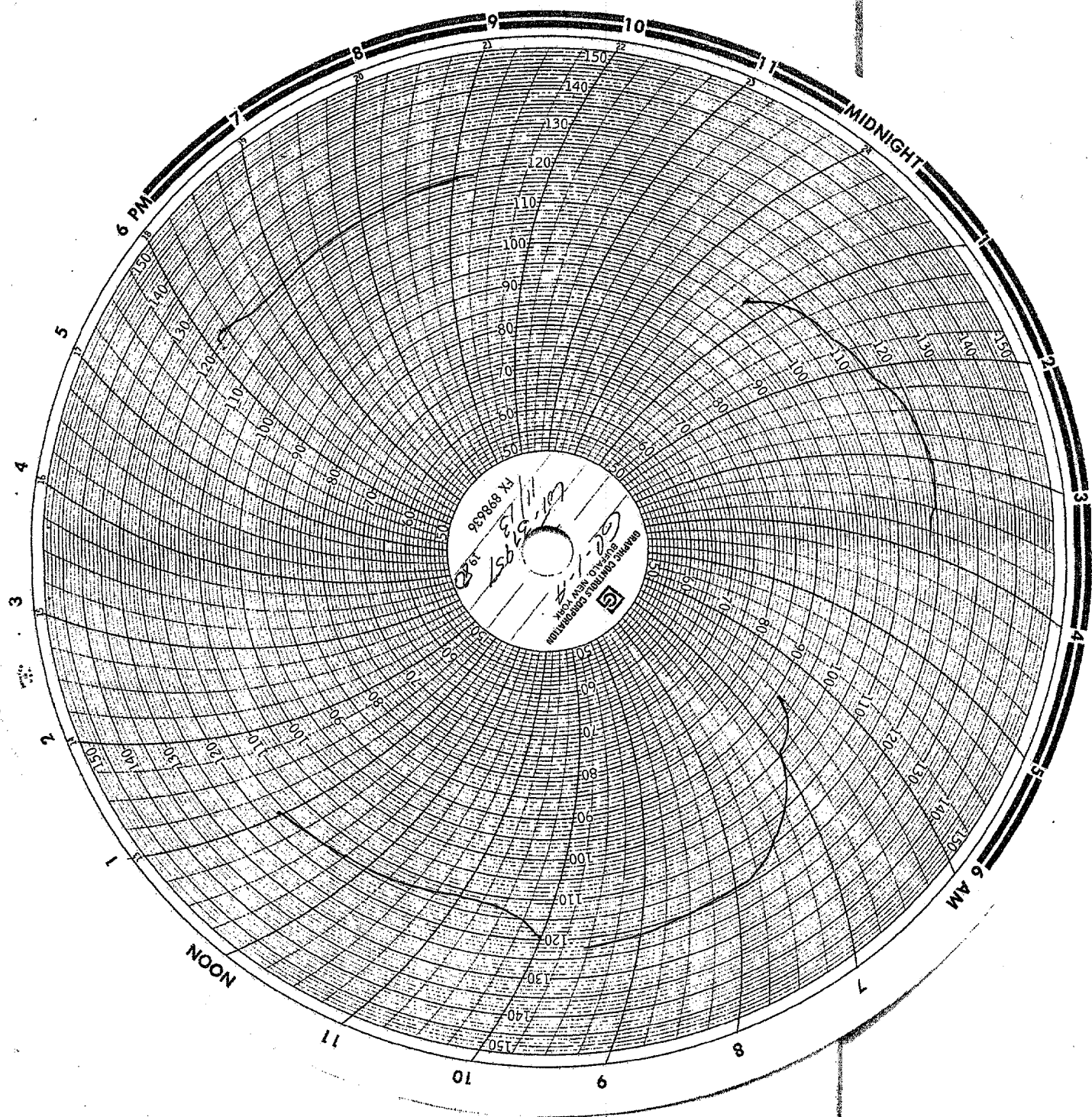
  

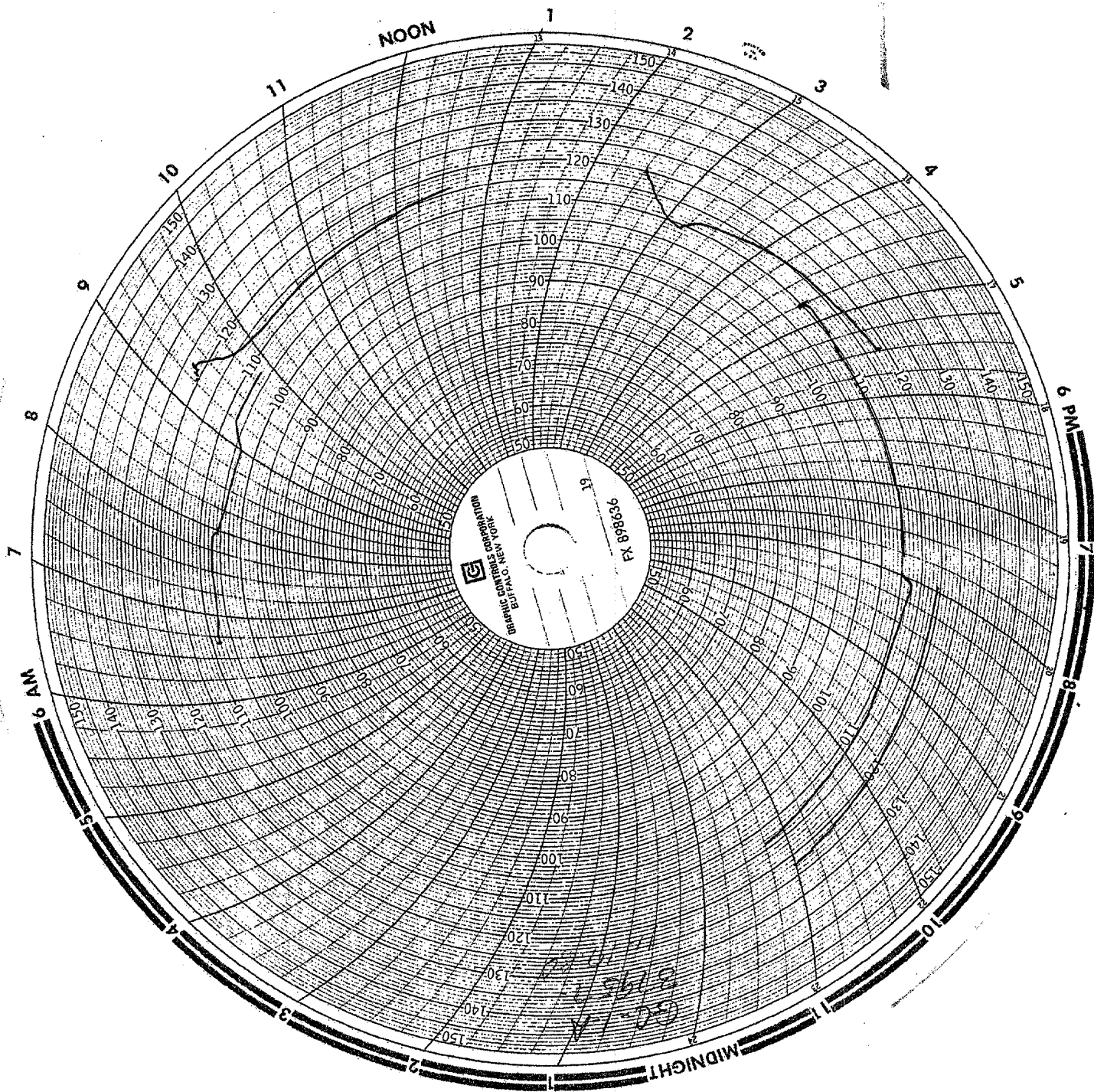
| START | FIN   | OPTR |
|-------|-------|------|
| 7A.M. | 2P.M. | 114  |

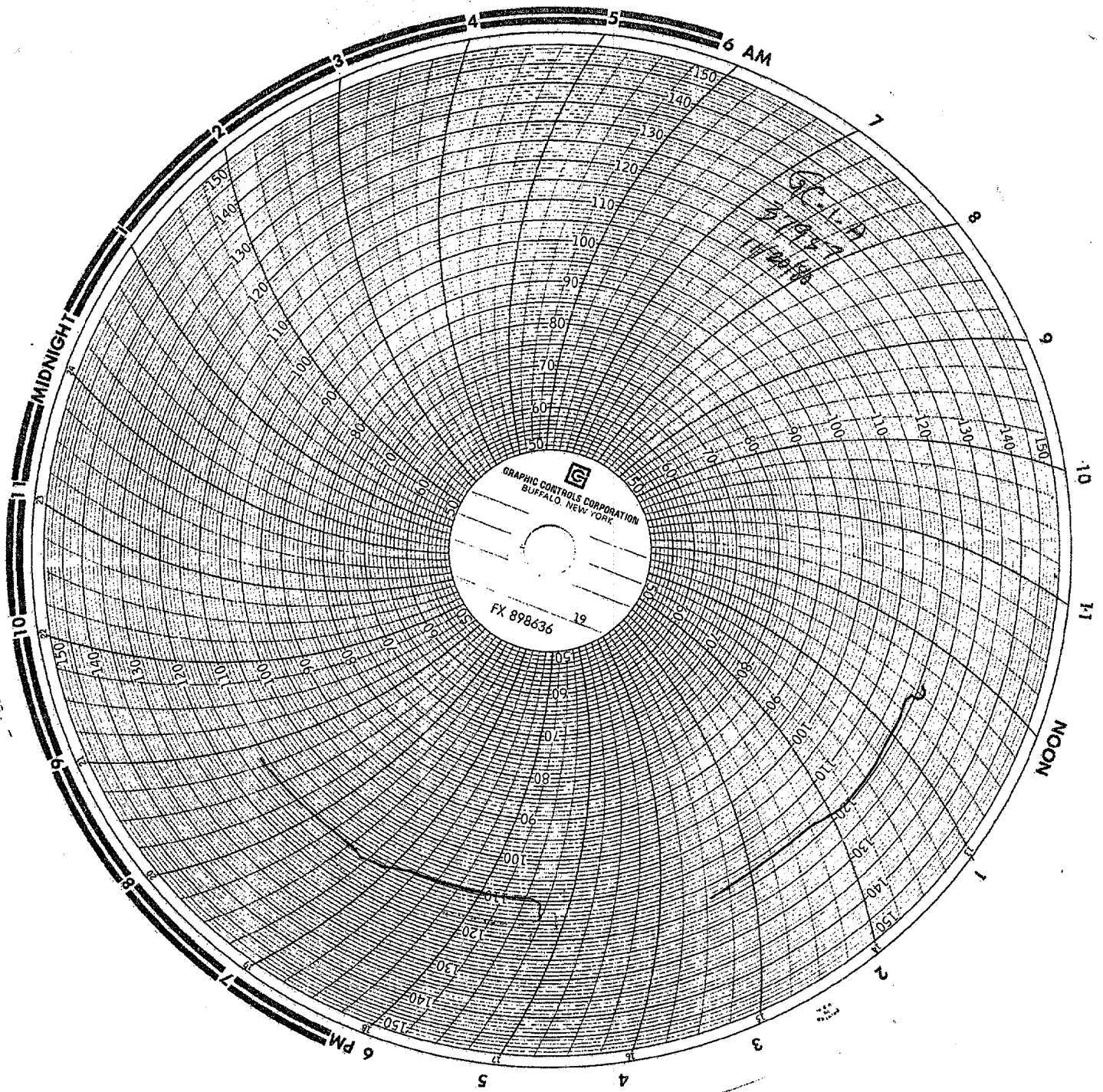
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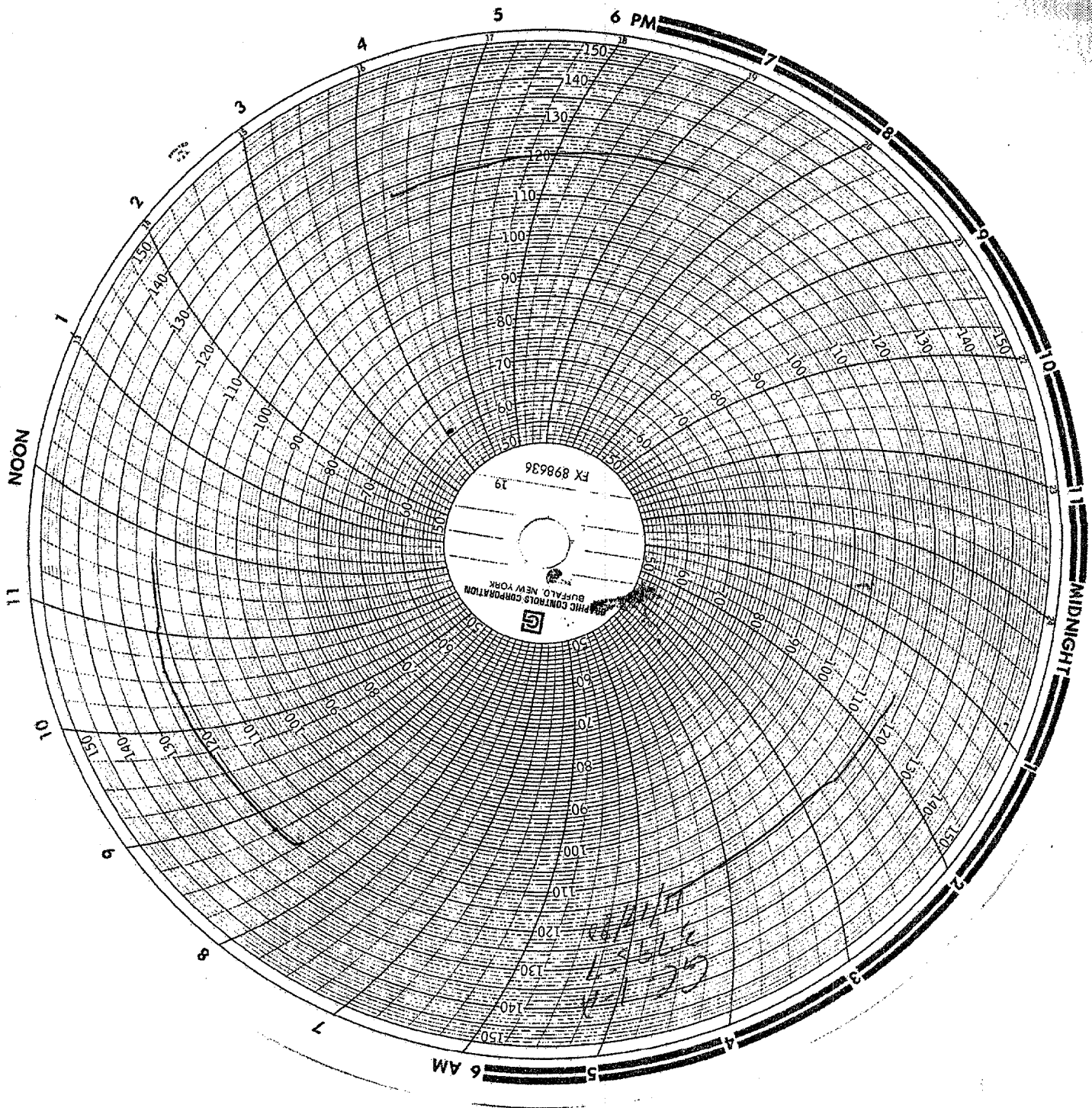


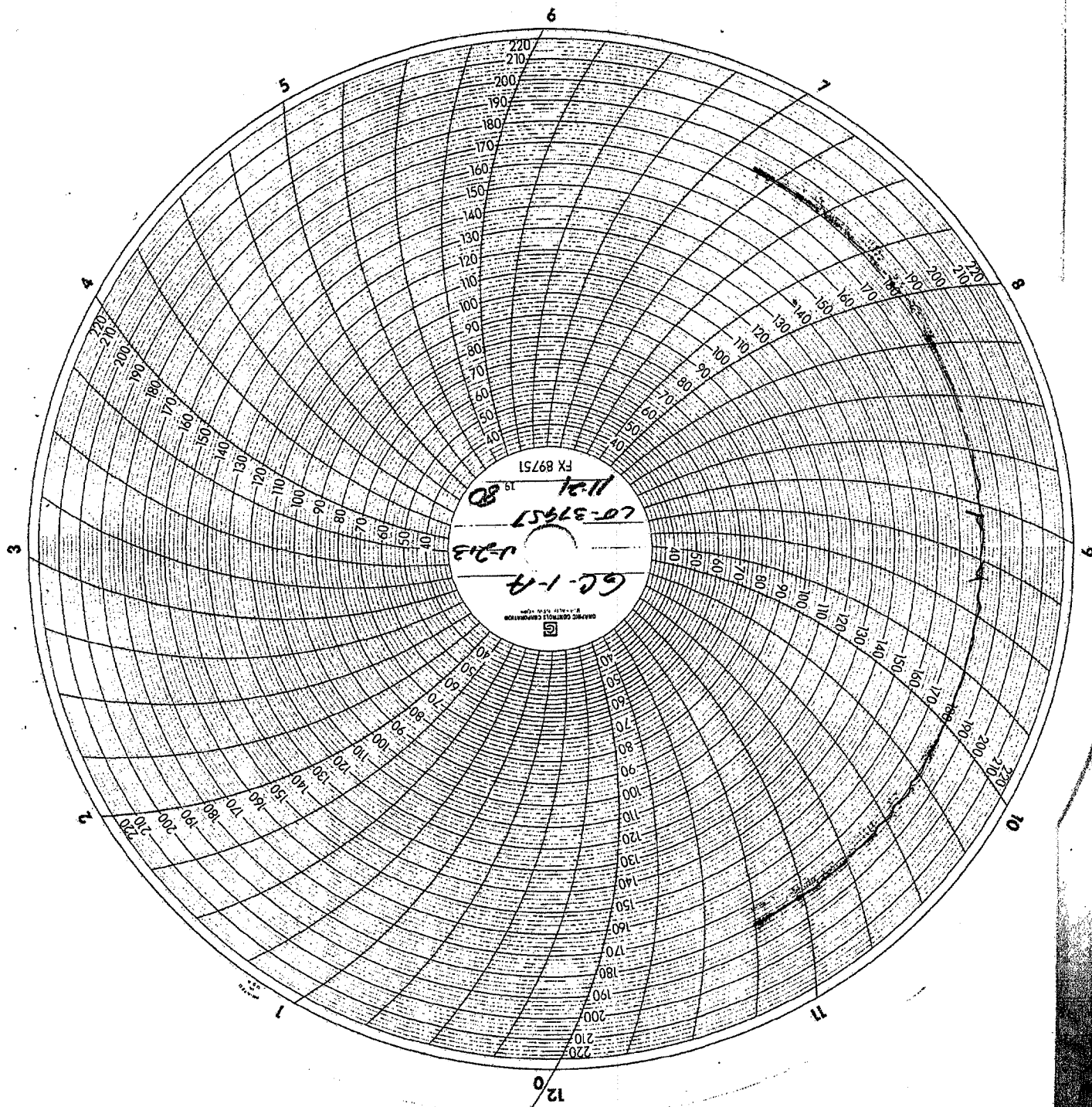


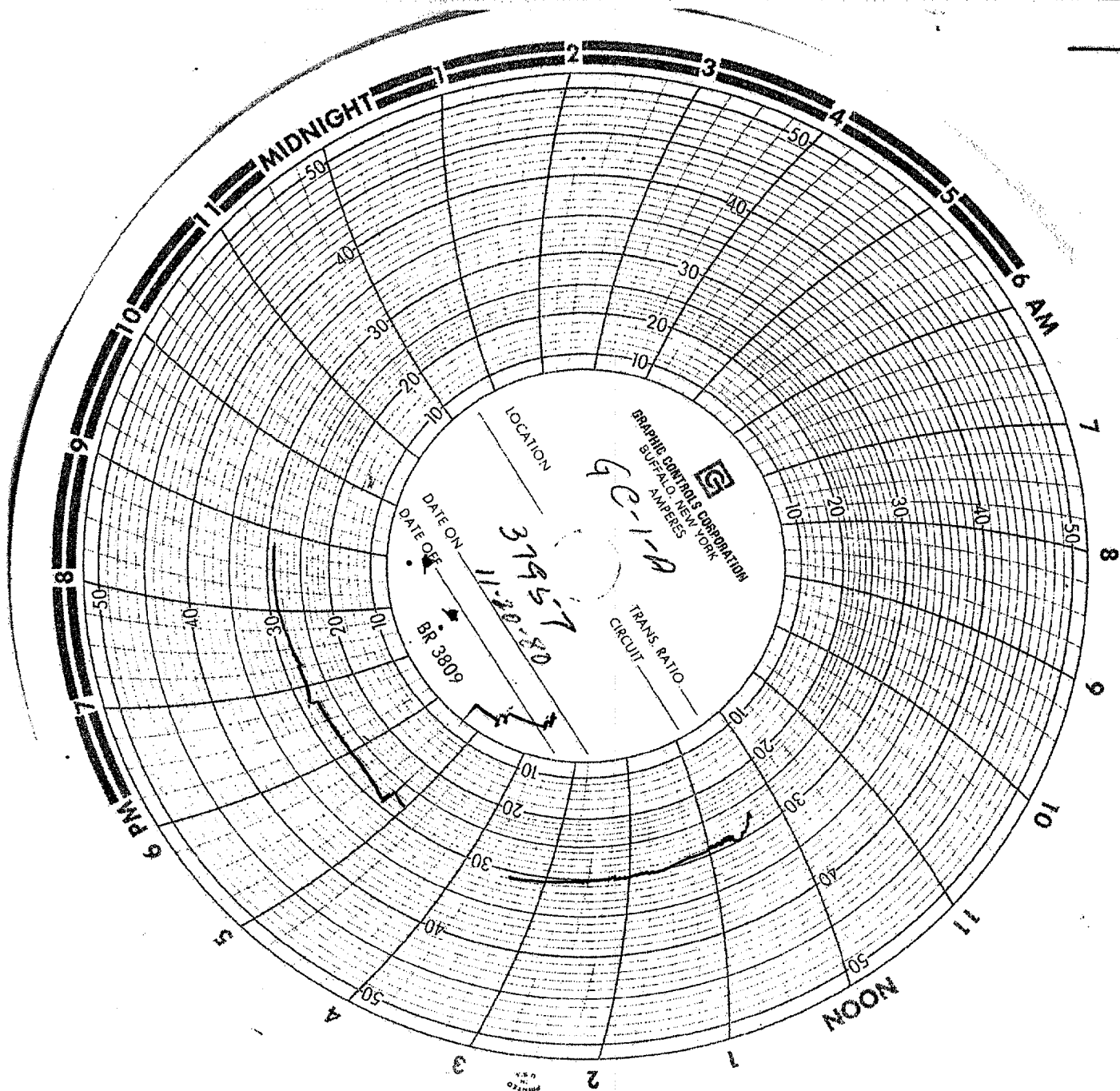












650  
600  

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1250  
430  

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820  
1  

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5410

