

OCT-16 80 37476

( ) KY-907-D (F) FWP 10/8/80

STANDARD HRS.

TIME 11A M

( ) ( )

( ) ( )

( ) ( )

TYPED BY: FWP 10/8/80

| CG | CODE   | PQ | LOT   | LBS  |
|----|--------|----|-------|------|
| 14 | YC002B | 93 | 13085 | 2400 |
| 14 | YC002B | 93 |       |      |
| 14 | YC002B | 93 |       |      |

(JN)

O/R

Homog #4-2nd Pass

TOTAL EST'D WGT 6053

NON-BLEEDING

| EQUIP | NAME : "KROLOR" YELLOW MEDIUM                              | USE<br>LBS  | NCODE  | ACCT<br>LBS |
|-------|------------------------------------------------------------|-------------|--------|-------------|
| 203   | 1 RUN 60" (990 GAL) WATER INTO V-203 & ADD CAUSTIC         | 40          | 7-D    | 20          |
| &     | 2 RUN AGITATOR ON HIGH SPEED                               |             |        |             |
| 205   | 3 WEIGH SODIUM SILICATE INTO DRUM & POUR IN                | 320         | 32-D   | 320         |
|       | 4 DUMP IN CHROME YELLOW & STIR 5 MIN                       | 48X50       | YC-2-B | 2400        |
| 1     | RECORD: START <u>4:00 PM</u> <u>13085</u>                  | <u>2400</u> |        |             |
|       | FIN <u>5:10 PM</u>                                         |             |        |             |
|       | 5 ADJUST TO 75" (1275 GAL)                                 |             |        |             |
| V-203 | 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 <u>valve 3</u> & ADJUST TO 60" (2100 GAL)  |             |        |             |
|       | 9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY              |             |        |             |
|       | 10 RUN 4" (200 GAL) WATER INTO V-205, START                |             |        |             |
| &     | AGITATOR & INSTALL TEMP CHART                              |             |        |             |
| SV    | 11 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV          |             |        |             |
| V-205 | RECORD: TIME START <u>5:50 AM</u> TOTAL MINUTES <u>170</u> |             |        |             |
| 2     | NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,              |             |        |             |
|       | 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205               |             |        |             |
|       | 12 WHEN V-205 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  |      |      |      |
| &   | 13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F  |      |      |      |
| 384 | 14 WEIGH INTO V-384 & PUMP TO V-349                | 3220 | 32-D | 3220 |
|     | 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: <u>1.142</u> G/ML (1.138-1.142) |      |      |      |

|    |                                                              |           |     |          |
|----|--------------------------------------------------------------|-----------|-----|----------|
| SV | 18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO <u>47"</u> (2420 GAL) |           |     |          |
|    | 19 RECORD: PH <u>10.8</u> & ADJ TO 11.1-11.3 WITH CAUSTIC    |           |     |          |
| 4  | AT 5% (10 PARTS WATER TO 1 PART N-7-D)                       |           |     |          |
|    | ASSUME 50%                                                   | <u>12</u> | 7-D | <u>6</u> |
|    | 20 SIPHON N-7-D INTO SV & RECORD: PH <u>11.3</u>             |           |     |          |
|    | HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>198</u> °F       |           |     |          |
|    | & RECORD: <u>196</u> °F                                      |           |     |          |
|    | NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON                  |           |     |          |
|    | ON COMPLETION OF HEATING                                     |           |     |          |

|      |                                                          |  |      |     |
|------|----------------------------------------------------------|--|------|-----|
| V-21 | 21 WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343 |  |      |     |
| 343  | 22 METER IN SULFURIC ACID FROM V-386                     |  |      |     |
| &    | MK <u>63</u> , <u>8.834</u> #/GAL, <u>5</u> GAL          |  |      |     |
| 386  | 23 STIR 15 MIN OR LONGER                                 |  | 27-D | 481 |
| 5    | 24 RECORD: DENSITY <u>1.032</u> G/ML (1.030-1.033)       |  |      |     |

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|     |     |                                                                            |     |       |     |
|-----|-----|----------------------------------------------------------------------------|-----|-------|-----|
| SV  | 25  | WHEN S 20 HEATING COMPLETE, RECORD: PH <u>10.1</u>                         |     |       |     |
|     | 26  | SET V-343 ACID PUMP AT 57 SETTING (225 MIN)                                |     |       |     |
|     | 27  | SET V-349 SILICATE PUMP AT 48 SETTING (180 MIN)                            |     |       |     |
|     | 28  | IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV                            |     |       |     |
|     | 29  | AT 190-194°F DURING STRIKE                                                 |     |       |     |
|     | 30  | RECORD: START FINISH MINUTES                                               |     |       |     |
|     |     | V-343 <u>11:15-01</u>                                                      |     |       |     |
|     |     | V-349                                                                      |     |       |     |
|     |     | V-343 V-349 SV NORMAL                                                      |     |       |     |
|     |     | TIME INCHES INCHES PH PH                                                   |     |       |     |
|     |     | AT 20 MIN <u>12:10</u> (36) <u>36</u> (15) <u>15</u> <u>9.9</u> (9.3-10.0) |     |       |     |
|     |     | 40 MIN <u>12:50</u> (33) <u>33</u> (13) <u>13</u> <u>9.9</u> (9.3-10.0)    |     |       |     |
| 6   |     | 1 HR <u>1:25</u> (30) <u>29</u> (11) <u>11</u> <u>9.8</u> (9.3-10.0)       |     |       |     |
|     |     | 2 HR <u>1:50</u> (29) (6) <u>6</u> <u>9.6</u> (9.3-10.0)                   |     |       |     |
|     |     | 3 HR <u>2:50</u> (28) (0) <u>0</u> <u>9.6</u> (9.3-10.0)                   |     |       |     |
|     |     | FINISH <u>3:35</u> (0) (0) <u>0</u> <u>10.2</u> (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  | 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  |
|     | 375 | 35 DURING STRIKE PUMP INTO PT                                              | 558 | 169-A | 558 |
| PT  | 376 | 36 PUMP IN                                                                 | 62  | 155-A | 62  |
| 9   | 377 | 37 PUMP IN                                                                 | 62  | 160-A | 62  |
|     | 38  | 38 STIR 10 MIN WITH LIGHTENING MIXER FOR S 42                              |     |       |     |
|     | 375 | 39 DURING STRIKE RUN 18" (317 G) WATER INTO V-356                          |     |       |     |
|     | 376 | 40 TURN ON STEAM                                                           |     |       |     |
| 356 | 41  | 41 ADJ TO 23" (403 G) AT 81-82°C                                           |     |       |     |
| 10  | 42  | 42 PUMP PT MIXTURE FROM S 38 THRU UNDERSURFACE                             |     |       |     |
|     |     | DISTRIBUTORS AS FAST AS POSSIBLE                                           |     |       |     |
|     | 43  | 43 RINSE PT WITH HOT WATER FROM HOT WATER MIXER                            |     |       |     |
|     |     | & PUMP IN                                                                  |     |       |     |
|     | 44  | 44 SHUT OFF PUMP                                                           |     |       |     |
|     | 45  | 45 STIR 30 MIN AT 81-82°C FOR S 54                                         |     |       |     |
|     | 46  | 46 DO NOT SHUT OFF AGITATOR                                                |     |       |     |

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- 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 3.0 (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 3.3 (4.2-4.4) & IF NECESSARY, ADJ  
TO PH 4.2-4.4 & RECORD: PH 4.3 ASSUME 78%  
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 75%  
SIPHON N-7-D INTO SV
- 64 DO NOT STOP AGITATOR

|      | START          | FINISH               | OPERATOR |
|------|----------------|----------------------|----------|
|      | 7:00P          | 11:00P               | 201-301  |
|      | 11:00P         | 2:00P                | 235-244  |
|      | 3:00PM         | 6:00PM               | 301-54   |
| STEP | V-262 (20 RPM) | V-243, 244, 246, 247 |          |
| 9    | 2"             |                      |          |
| 18   | 24"            |                      |          |

27-D  
21-D

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