

S.V. 244, 247

C.V.

APR 20 1980 D.V.

MAKING INSTRUCTIONS: BATCH UNIT

CG 04 CODE K0789D PKG PROCESSES APPROVED BY
 EST'D WGT 1032 LBS MAY-1 35594 () K0789D (1) FWP 4/28/80
 STANDARD HRS. 10.8 TIME 4 M. () ()
 TYPED BY: FWP 4/28/80

CG CODE PQ LOT LBS
 01 YC016B 93 34654 1200
 01 YC016B 93 34710 3000
 01 YC016B 93

BUNCHED & CHECKED

MAY - 5 1980

TOTAL EST'D WGT 5332 5232 REQ. NO. () NON-BLEEDING

EQUIP	NAME	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MINS. LOT	84X50	YC16B	4200
	RECORD: START 8:45 PM			
	FIN 10:30 PM	34654		1200
		34710		3000
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU			
	6 HIMOGL AT 2800-3200 PSI INTO V-208			
	7 WHEN V-211 MTY, WASH COLOR THRU HOMOGL WITH MIN			
	8 OF HOT WATER AT 2800-3200 PSI INTO V-208			
	RECORD: V-208 VOL. " & ADJUST TO 54" (1890G)			
	9 INSPECT HOMOGL STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V-208 & START			
	AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOGL AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START TOTAL MINUTES			
	NOTE: IF HOMOGL PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
	11 WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP			
	THRU HOMOGL AT 4800-5200 PSI INTO SV			
349	12 WHILE HOMOGL, RUN 6" (284 G) 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	2545	32-D	2545
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.086 G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOGL COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH 10.7 & ADJ TO 11.1-11.3 USING N-7-D			
4	DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	SEPHON N-7-D INTO SV & RECORD: PH 11.15 ASSUME 50%	10	7-D	5
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 19.5°F			
	& RECORD: 19.5°F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

21 WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343
 22 METER IN FROM V-386 M 31, 11,10# / GAL, 35.1 GAL
 23 STIR 15 MIN OR LONGER
 24 RECORD: DENSITY 1.018 GM/ML (1.018-1.020)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1
 26 SET V-343 ACID PUMP AT 65 SETTING (255 MIN)
 27 SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)
 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE.

29 RECORD: START FINISH MINUTES
 V-343 8:15 11:20 A 2:05
 V-349 12:30 AM 2:15
 TIME V-343 V-349 SV NORMAL
 9 1/2 INCHES INCHES PH PH
 AT 20 MIN 9.5 (49) (20) 9.9 (9.3-10.0)
 40 MIN 9.5 (45) (18) 9.9 (9.3-10.0)
 1 HR 9.5 (41) (16) 9.9 (9.3-10.0)
 2 1/4 HR 11:25 2.6 (8) 9.9 (9.3-10.0)
 3 1/2 HR 12:25 (9) 10+ (0) 9.9 (9.3-10.0)
 FINISH 12:30 (0) 8.7 (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 & RECORD: 8.3 PH

ASSUME 77%

12 27-D

120 RUN 33" (238 G) WATER INTO V-356 & HEAT TO 135-140°F

121 DUMP IN & STIR TO DISSOLVE

530

15-A 530

302 132 ADD 42" (514 G) WATER TO V-302
 133 ADD & STIR 2 MIN

330

7-D

165

V 134 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING.

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

136 STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM
 RECORD: START 11:25 AM

137 RUN IN V-356 FROM S 31 & STIR 5 MIN

138 RECORD: PH 3.55 (3.4-3.8) & IF NECESSARY ADJ (DOWN ONLY) TO 3.4-3.8 & RECORD: PH

NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140°F IN DRUM, USE 30 GAL WATER TO 50# N-15-A. STIR SV 5 MIN AFTER EACH ADDITION

139 RUN IN N-7-D FROM S 33 IN 10-12 MIN & STIR 5 MIN

140 RECORD: PH 7.0 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4 & RECORD: PH 6.4

ASSUME 77%

18

27-D

DILUTE N-7-D 10 TO 1 WITH WATER

ASSUME 50%

7-D

SIPHON N-7-D INTO SV

141 POUR IN STIR 15 MIN

50

978-A

50

142 STOP AGITATOR

START 11:00 P

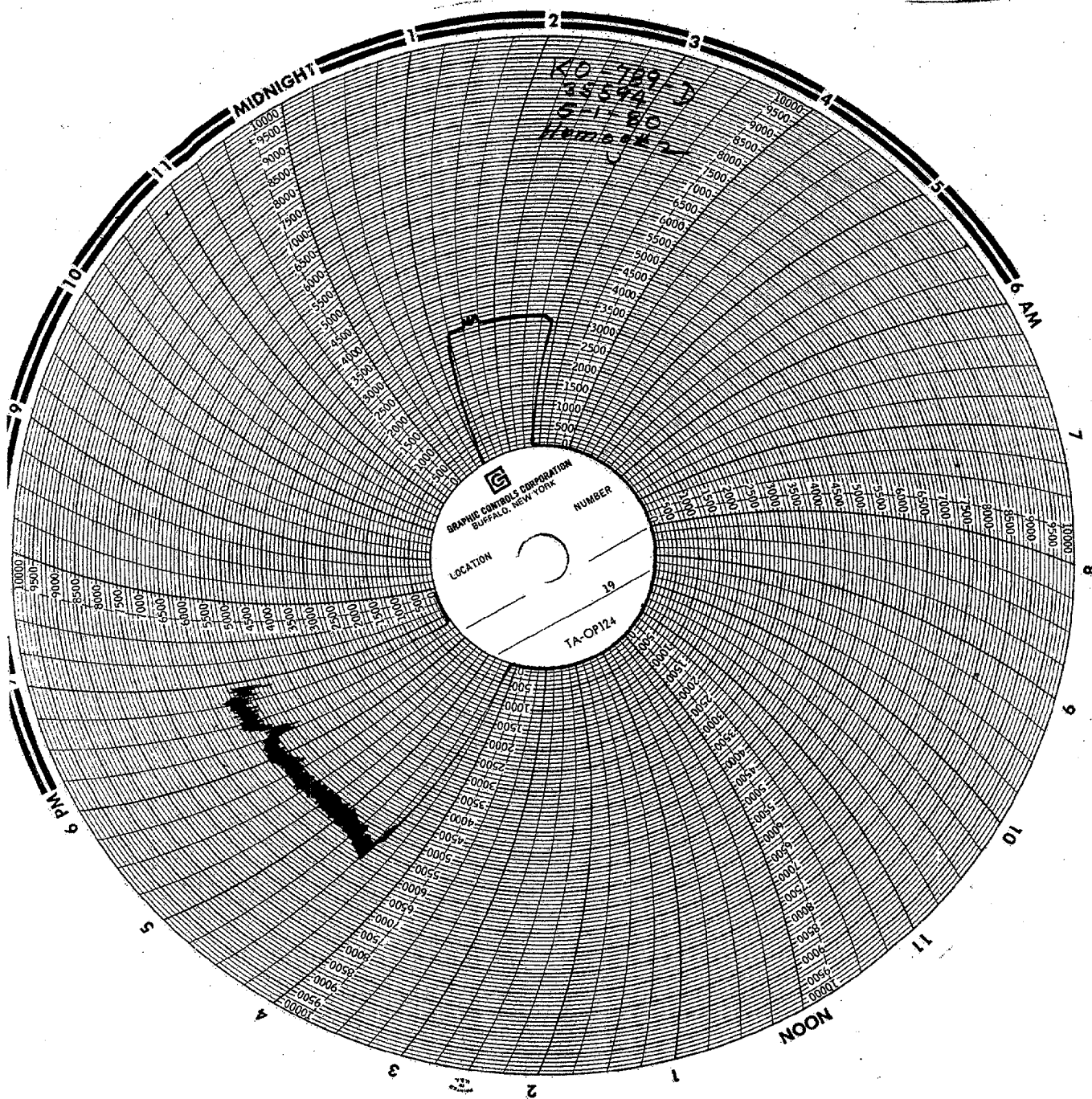
FINISH 7:00 AM

OPERATOR 235

11:00 P

3100 AM

235



N32378.01

DUP050457772

V-245-

245

