

CG 15 CODE Y-539-D PKG

EST. WT. 17574* LBS.

PROCESSES

APPROVED BY

() Y-539-D (L)

FWP, 10/16/81

~~5/1/82~~~~6/2/82~~

TYPED BY: DAJ

(DATE)

(LOT NUMBER)

EQUIP MENT	NAME: ZINC YELLOW	USE LBS	N-CODE	ACCT LBS
T-22A	1 RUN 57" (5473 G) WATER INTO T-22A			
1	2 WEIGH IN PAIL & POUR IN ASSUME 50%	46	7-D	23
	3 ADJ TO 62" (5990 G) AT 70-74°F.			
	4 ADD IN 70-80 MIN. START TOT. MIN. 80	7000	713-B	7000
	5 STIR 15 MIN.			
	6 ADD IN 25-30 MIN.	3700	936-B	3700
	7 STIR 15 MIN.			
21A	8 PUMP T-22A THRU ZINC DISPERSAL PUMP & 1.5"			
21B	9 VALVE AT 80 PSI INTO T-21- 1.6760			
2	10 WASH IN T-22A, HEEL TO BE USED IN NEXT BATCH			
	10 STRIKE T-11 INTO T-21A/21B M345 68.48 X 17523		8-D	12600
	11 ON THE SURFACE IN 20-25 MIN TIME START			
	11 RUN IN T-13 IMMEDIATELY IN 15-20 MIN			
	12 ASSUME 31.64%	4520	28-D	1430
	12 STIR 5 MIN & RECORD PH 6.2 (5.8-6.2)			
	13 STIR 2 HRS RECORD TIME START 1.00 PM			
	A. AFTER STIRRING 1 HR, RECORD PH 6.6			
	(6.2-6.7)			
	B. IF NECESSARY ADJ TO PH 6.4-6.8			
	ASSUME 50% & RECORD PH		7-D	
	C. RECORD TOTAL MIN			
	14 DURING S13, WHEN SCHEDULED DUMP IN		Y-539-D	
	RECORD: #SSS & #CLEANOUT			
	15 RECORD: PH (6.4-6.8)			
	VOL 83 (82"-86")			
T-60	16 PUMP SV AT 4500#/HR (MAX) TO T-60 (+/-22"/HR)			
3	IN SV MAINTAINING VOL OF 40"-50" IN T-60			
	RECORD: TIME START PUMP'G FROM SV			
	RECORD: (SV EMPTY) TOTAL MIN			
	17 RUN THRU ROTA-14 INTO T-60	6	260-A	6
	(0.017#/MIN) / (0.013#/G) / 1.00 FACTOR =			
	1.31 ROTA-14 SETTING			
CENT	18 PUMP T-60 (AT 40"-50") AT 4500#/HR MAX TO			
4	CENT-66			
	19 WHEN CENTRIFUGING COMPLETED WASH IN SV			
	20 RECORD CENT RATE IN STEP 38 TABLE			
	21 REPULP CENT-66 INTO T-70			
	22 RUN THRU ROTA-11 INTO T-70	6	260-A	6
	(0.017#/MIN) / (0.013#/G) / 1.00 FACTOR =			
	1.31 ROTA-11 SETTING			
	23 RUN THROUGH ROTA-9 INTO T-70 ON SURFACE	254	978-A	254
	(1.06#/MIN) / (0.4#/G) / 1.60 FACTOR =			
	1.66 ROTA-9 SETTING	20	979-A	20
	24 PUMP T-70 INTO CENT-67			
	25 REPULP CENT-67 INTO T-71 MAINTAINING T-71			
	AT 75-80°F			
	26 PUMP T-71 INTO CENT-68			
	27 COUNTER CURRENT WASH AS FOLLOWS:			
	A. RUN CENT-66 EFFLUENT TO SEWER			

JUN 3 1982

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EQUIP MENT		PAGE 2 OF 2 CG 15 CODE Y-539-D (L)	USE LBS	N-CODE	ACCT LBS																																																																
⑦		B. PUMP 15 GPM EFFLUENT FROM CENT-67 INTO CENT-66 THRU 67-EFFLUENT ROTA & REMAINDER TO SEWER C. PUMP CENT-68 EFFLUENT INTO CENT-66 WASH PORT D. RUN 40 GPM CITY & -10 GPM DC WATER INTO T-71																																																																			
FIN DRUM 5	28	SET PASTE & REPASTE ROLL STEAM PRESSURE AT 120 PSI																																																																			
	29	SET FINNED DRUM STEAM AT 80 PSI & SPEED AT 1 REV/65 SEC																																																																			
	30	ADJUST TO OBTAIN 25-26% STICK MOISTURE																																																																			
DRY 6	31	SET DRYER BELT SPEED AT 36 MIN BELT RETENTION TIME (TIME/6 BELT SECTIONS = 2 MIN 48 SEC)																																																																			
	32	SET DRYER: SECT 1 275°F, 2 280°F, 3 290°F, 4 290°F																																																																			
	33	ADJ DRYER SECTIONS TO OBTAIN MOISTURE (0.2 TO 0.4%) NOTE: TURN ON HP WASH ON INSIDE & OUTSIDE OF BELT.																																																																			
MISC 7	34	WHEN SCHEDULED, DRY BLEND "SSS" THRU FEEDER AT ____#/HR.																																																																			
	35	WHEN SCHEDULED, DRY BLEND CLEANOUT/PURGE AT ____#/HR.		Y-539-D																																																																	
	36	MAINTAIN 70 GPM MIN WATER TO DC. USE RECIRCULATED DC WATER PLUS MIN FRESH WATER TO MAINTAIN LEVEL IN DC BASIN. DO NOT OVERFLOW BASIN.																																																																			
PULV 8	37	"VORTAC" INSTRUCTIONS: MAGNEHELIC READING.....0.30-0.35 MILL AIR GATE.....4" PULSAIRE AIR GATE.....WIDE OPEN PULSAIRE PRESSURE DROP.....5" WATER MAX TANGENT PLATE AIR PRESSURE.....60-70 PSI RECYCLE TUBE AIR PRESSURE.....80-90 PSI BLOWBACK AIR PRESSURE.....90-100 PSI NOTE: CLEAN RECYCLE TUBES AT LEAST ONCE PER SHIFT & RECORD IN LOGBOOK																																																																			
MISC 9	38	<table border="1"> <thead> <tr> <th>TIME</th> <th>TANK</th> <th colspan="2">DIFFERENTIAL</th> <th>TIME</th> <th>TANK</th> <th colspan="2">DIFFERENTIAL</th> </tr> <tr> <th></th> <th>INCH</th> <th>MIN</th> <th>INCH</th> <th></th> <th>INCH</th> <th>MIN</th> <th>INCH</th> </tr> </thead> <tbody> <tr> <td>10:40</td> <td>83</td> <td>30</td> <td></td> <td>11:10 AM</td> <td>49</td> <td>20</td> <td>5</td> </tr> <tr> <td>11:10</td> <td>75</td> <td>20</td> <td>10</td> <td>11:40 AM</td> <td>45</td> <td>4</td> <td>4</td> </tr> <tr> <td>11:40</td> <td>65</td> <td></td> <td>8</td> <td>12:10 PM</td> <td>40</td> <td>4</td> <td>5</td> </tr> <tr> <td>12:10</td> <td>59</td> <td></td> <td>6</td> <td>12:25 PM</td> <td>37</td> <td>15</td> <td>3</td> </tr> <tr> <td>12:40</td> <td>54</td> <td></td> <td>5</td> <td>1:30</td> <td>35</td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td>5:00</td> <td>6:00</td> <td>30</td> <td></td> <td>5</td> </tr> </tbody> </table>	TIME	TANK	DIFFERENTIAL		TIME	TANK	DIFFERENTIAL			INCH	MIN	INCH		INCH	MIN	INCH	10:40	83	30		11:10 AM	49	20	5	11:10	75	20	10	11:40 AM	45	4	4	11:40	65		8	12:10 PM	40	4	5	12:10	59		6	12:25 PM	37	15	3	12:40	54		5	1:30	35						5:00	6:00	30		5			
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	39	RECORD: _____ # "SSS" ADDED (SS 14 & 34) # "CLEANOUT" ADDED (SS 14 & 35) START 3:00 p.m. FIN 11:00 p.m. OPR 12:12 11 PM 11 212																																																																			