CG 03 CODE KY-908-D PKG

JAN 7 1982 — A2H99

DATE — LOT NUMBER

PROCESSES — APPROVED BY

( ) KY-908-D (D) FWP 12/17/81

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STANDARD HRS. TIME _____ M JOB NAME: 03KY908DMD

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	14876	93	2600	14	YC-3-B	_____	93	_____
14	YC-3-B	_____	93	_____	14	YC-3-B	_____	93	_____
14	YC-3-B	_____	93	_____	14	YC-3-B	_____	93	_____

EST. WT. 3495* LBS. NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N-CODE	ACCT LBS
203 & 205	1	RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	345	32-D	345
	3	DUMP IN AND STIR 5 MIN LOT	52X50	YC-3-B	2600
	4	RECORD: START 7301PM 14876	2600		
		FIN 830 AM			
	5	ADJUST TO 75" (1275 G) *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~~ 263			
	7	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-~~205~~ 263			
	8	RECORD: V-~~205~~ 263 VOL ____" & ADJ TO 60" (2100 G)			
	9	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
~~205~~ 263 SV -2	10	RUN 10" (514 G) WATER INTO V-263 & START AGITATOR			
	11	PUMP V-~~205~~ 263 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 1115A TOTAL MINUTES 120			
	12	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 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
CP & CP 3	14	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 7 (V-243) OR POSITION 8 (V-244)			
	15	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194*F)	JAN 14		
	16	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: 1. 11LG 14 X PRESET #2 78 GAL		115-A	416
E.C.	17	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: SFC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM		27-D	180
		SFC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
		SFR10 (N-27-D/WATER) RATIO 0.8			
		SFC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM		32-D	1215
		SFC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
		SFC20 (N-32-D WATER) IN REMOTE			
		SFR10 (N-32-D/WATER) RATIO 1.1			

EQUIPMENT		PAGE 2 CG 03 KY-908-D COMPTP JOB NAME: 03KY908DMD	USE LBS	N-CODE	ACCT LBS
	16	OPERATOR STEP PB			
320 SV SP CP 4	17	RECORD LEVEL 2LG 77 % IF <35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
	18	ADJUST SV TO 47" (2400 G)			
	19	RECORD PH 9.8. ADJ TO 11.0-11.2 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	20	SIPHON INTO SV. RECORD: PH 11.2. ASSUME 50%	30	7-D	15
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7.			
SV SP 5	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	23	OPERATOR STEP PB			
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD: 5:40 AM SP STEP V-243/V-244 PH RANGE TIME 13/46 (30 MIN) 9.6 9.3-10.0 6:10 AM 14/47 (60 MIN) 9.6 9.3-10.0 6:40 15/48 (2 HRS) 9.5 9.3-10.0 7:40 16/49 (2 HRS, 25 MIN) 9.5 9.3-10.0 8:05 17/50 (FINAL 3 HRS) 8.4 7.5-8.5 8:40 NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5. & RECORD: PH ___. ASSUME 77%	____	7-D	____
	28	SIFT IN	50	128-A	50
385 6	29	ADD 42" (320 G) WATER TO V-385			
	30	ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	160	7-D	80
387 7	31	DURING STRIKE CHECK LEVEL IN V-387.			
	32	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
	33	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	34	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			
388 8	35	PUMP IN 25" (244 GAL)			
	36	TURN ON STEAM & AGITATOR			
	37	ADJUST TO 32" (317 GAL) AT 178-182*F			
	38	SET BADGER METER FOR 384#			
	39	PUMP IN FROM V-387 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE	312 36 36	169-A 155-A 160-A	312 36 36
	40	SHUT OFF PUMP			
	41	STIR 30 MIN AT 178-182*F FOR S 48			
	42	DO NOT SHUT OFF AGITATOR			
SV SP 9	43	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN			
	44	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
	45	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
	46	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2800-3100 PSI TO SEWER			

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EQUIPMENT		PAGE 3 CG 03 KY-908-D	USE LBS	N-CODE	ACCT LBS
SV & SP 9 CONT	47	WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG DISCHARGE VALVE TO SV AND CLOSE VALVE TO SEWER			
	48	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200*F.			
	49	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
	50	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
	51	WHEN S50 COMPLETE TURN OFF HOMOG & STERATE PUMP			
	52	STIR 5 MIN AT 198-200*F			
	53	SHUT OFF STEAM			
	54	WHEN S53 COMPLETE, OPERATOR PB			
	55	SP STEP 23/53 RECORD PH 2.8 (3.3-3.7)			
	56	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH____.			
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%		115-A	
	57	RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN			
	58	RECORD: PH 3.3. (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH 4.3. ASSUME 50%	100	7-D	50
		(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%		27-D	
		SIPHON N-7-D INTO SV			
	59	OPERATOR STEP PB			
	60	OPERATOR STEP PB			
	61	SP STEP 60 - BATCH COMPLETE			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPERATOR
8:00PM		11:00PM		409-27
1:00AM		7:00AM		348-381
7:00AM		11:05AM		37

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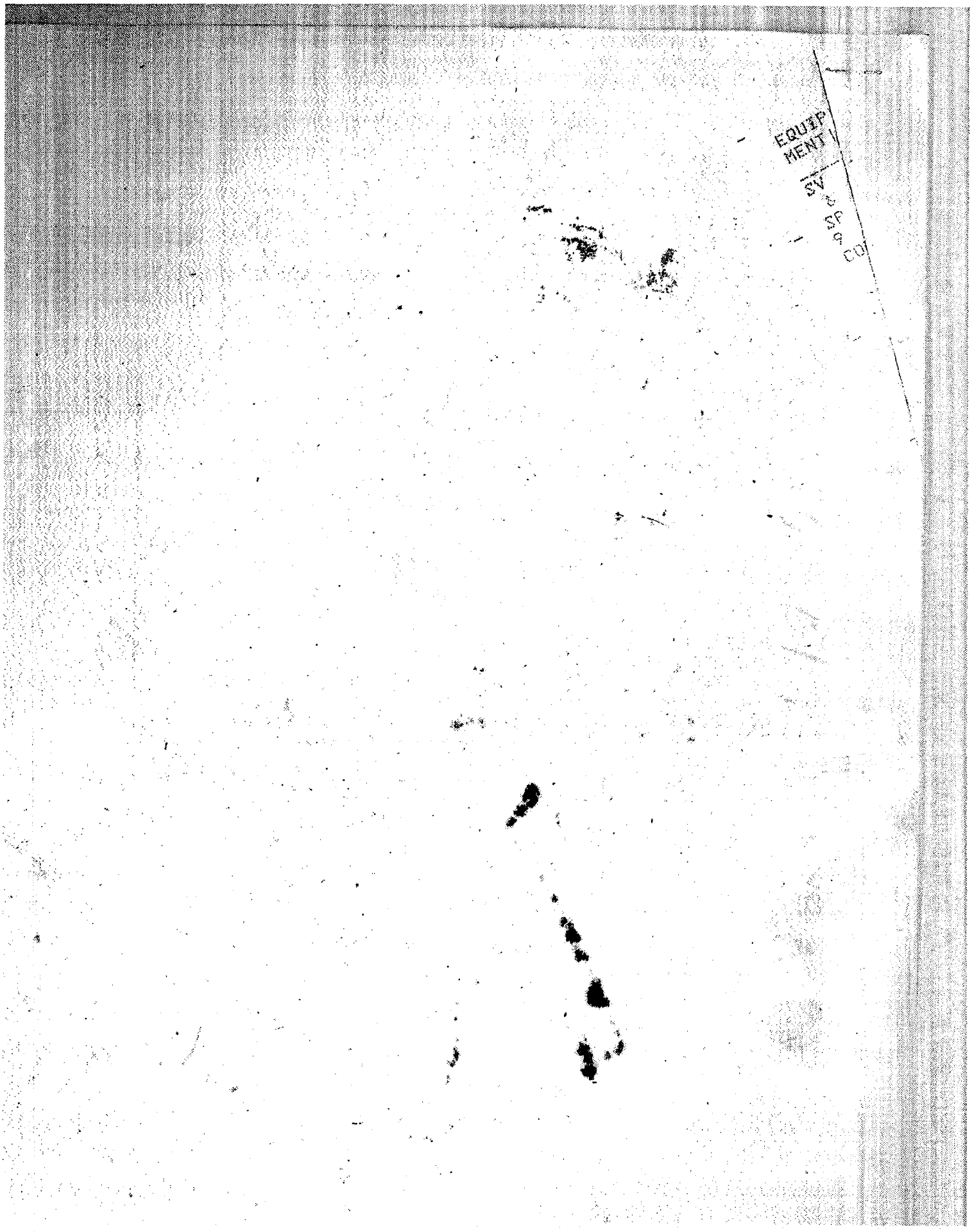

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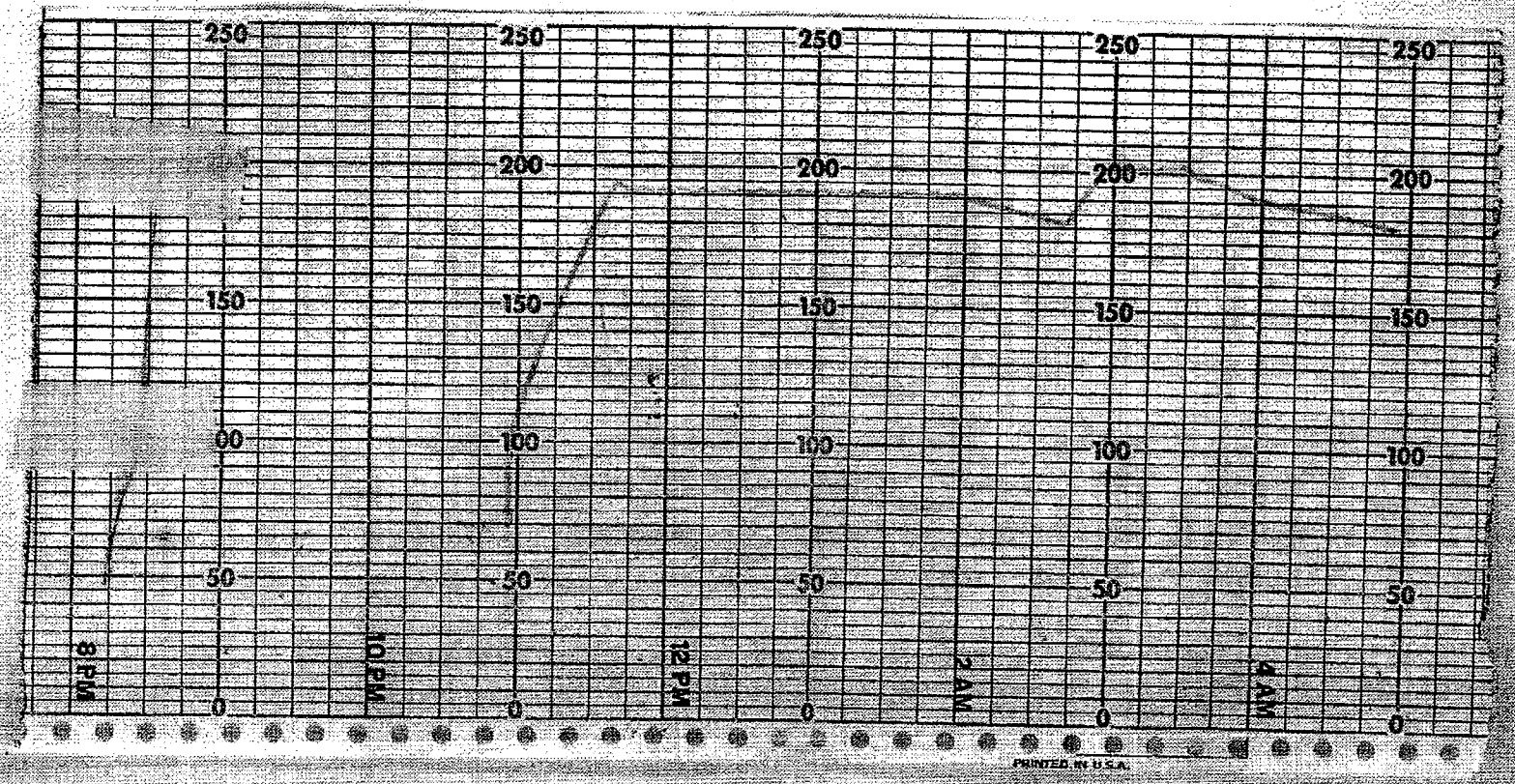

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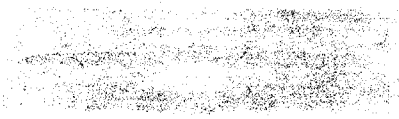

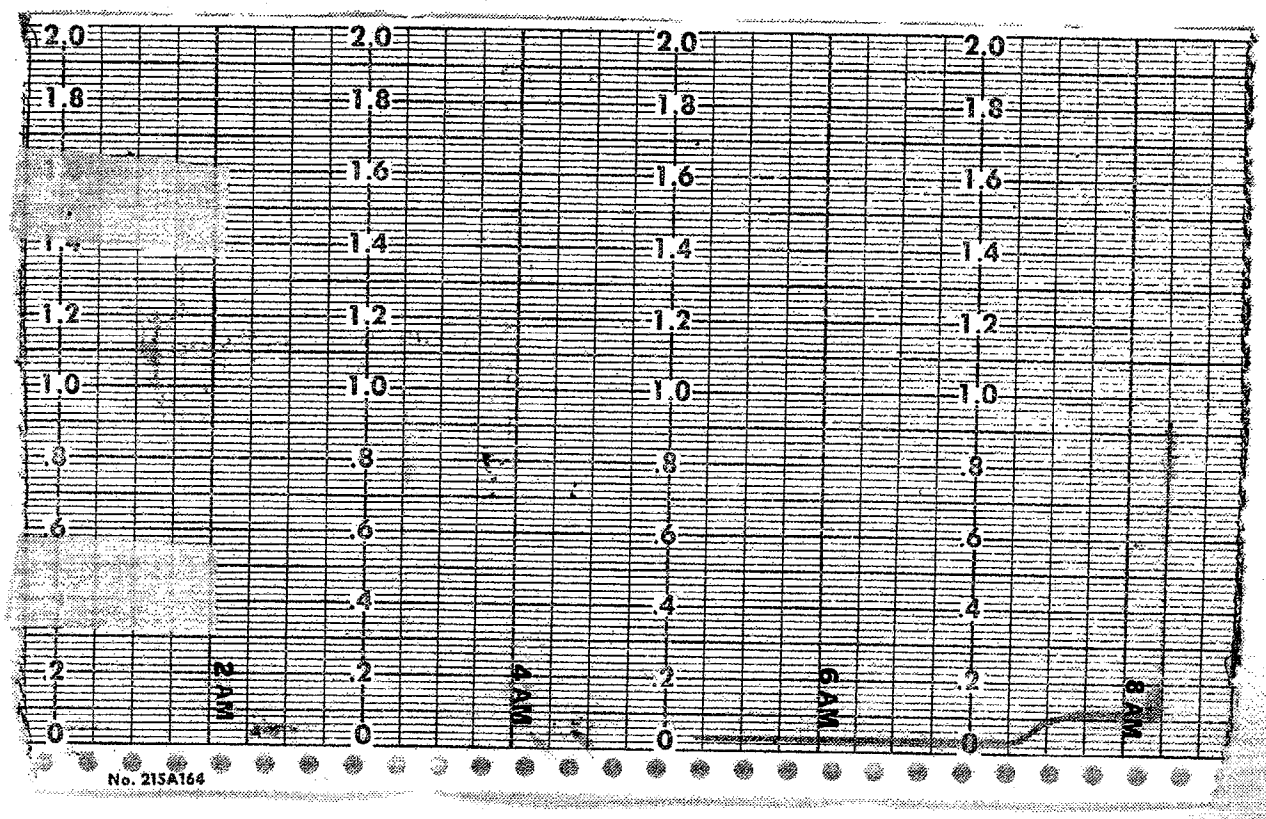

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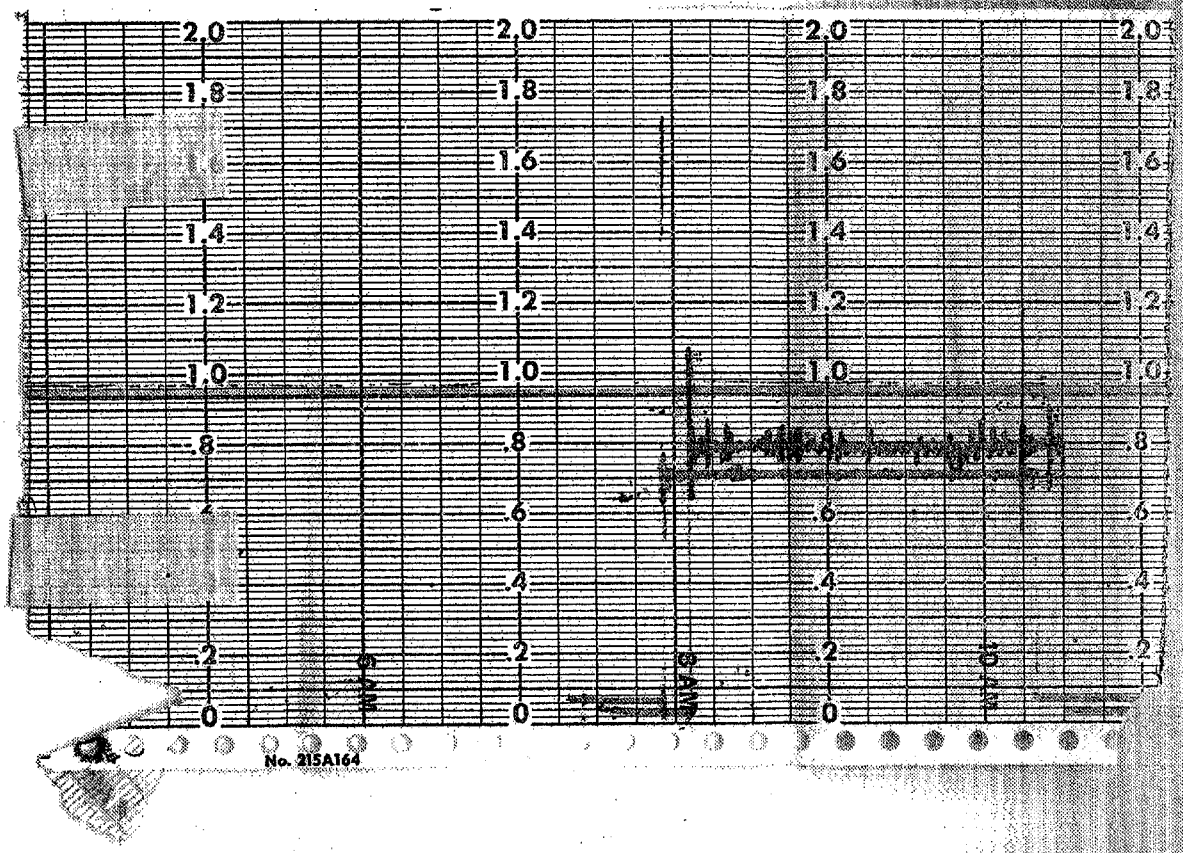

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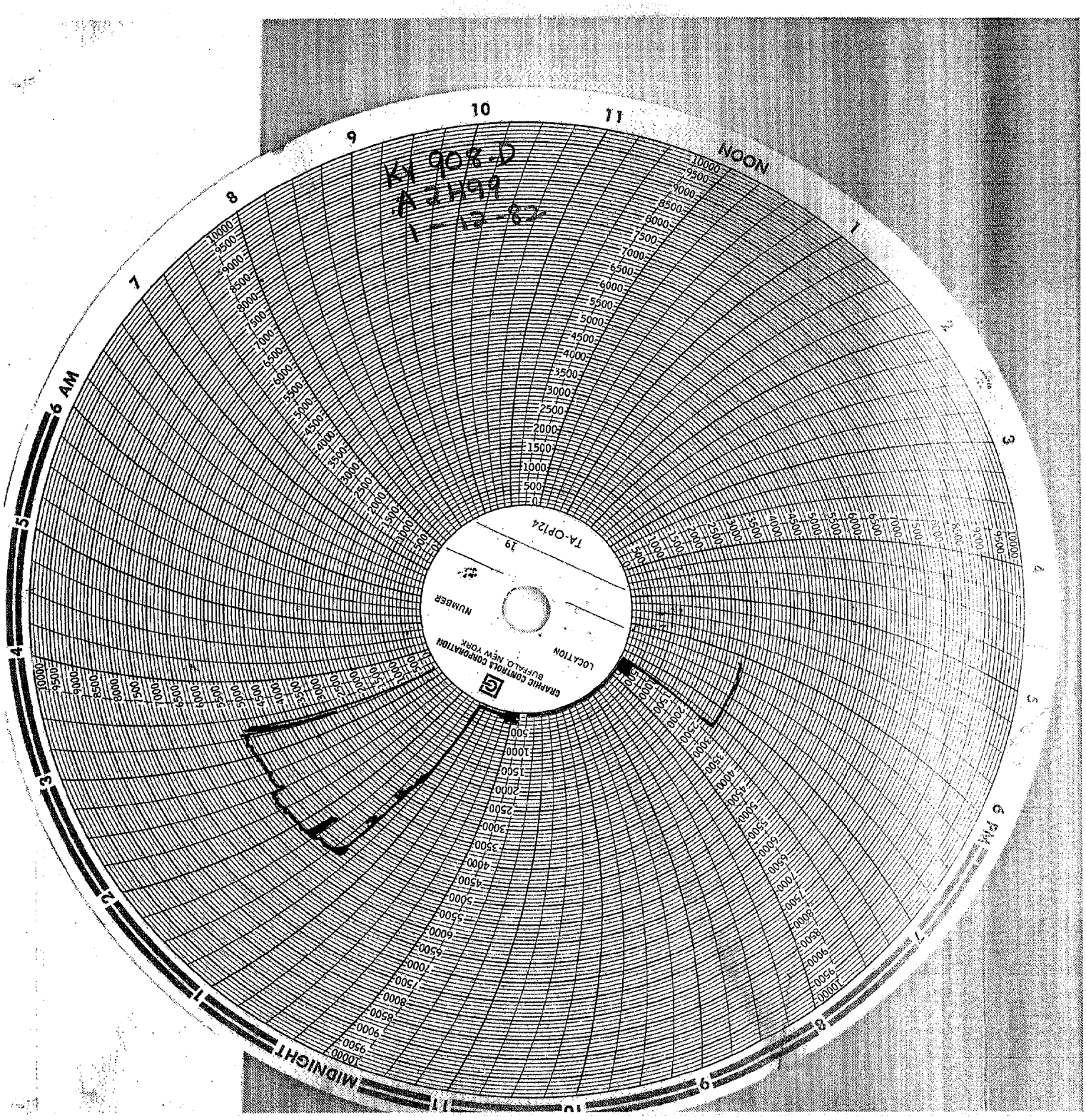

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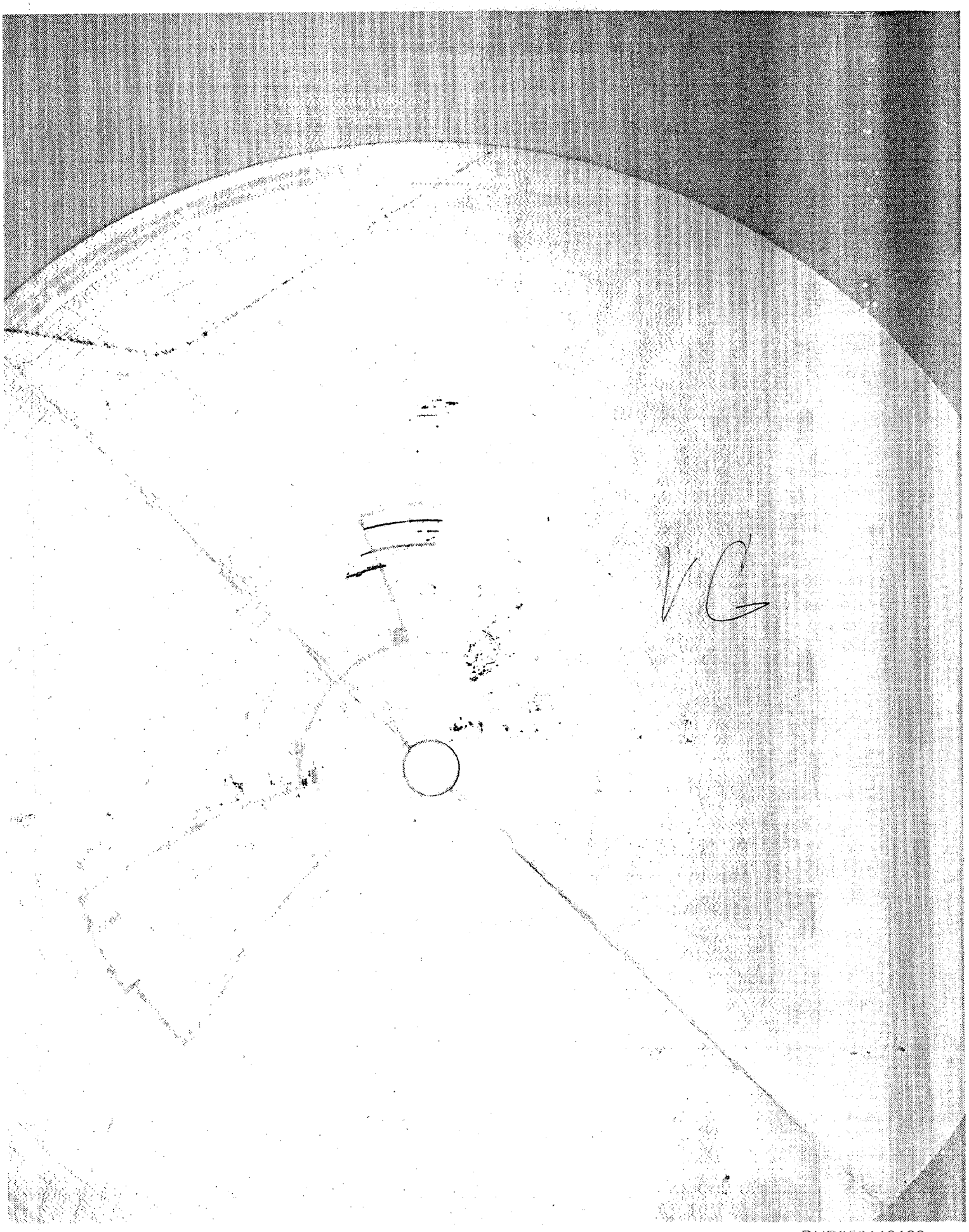

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