S.V. 243, 244 (AUTOMATED) DATE PRINTED: 3/26/82

CG 03 CODE KY-908-D PKG

MAY 27 19--
DATE

F2H68
LOT NUMBER F

PROCESSES
( ) KY-908-D (G) ( )
( ) ( )
( ) ( )
( ) ( )

APPROVED BY FWP 03/26/82

STANDARD HRS. TIME _____ M JOB NAME: 03KY908DMG

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	2016	93	2000	14	YC-3-B		93	
14	YC-3-B	14277	93	1050	14	YC-3-B		93	
14	YC-3-B	2032	93	100	14	YC-3-B		93	

EST. WT. 4221* LBS. (1) NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N-CODE	ACCT LBS
		BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF.			
203 & 205 263	1	RUN 60*(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	420	32-D	420
	3	DUMP IN AND STIR 5 MIN LOT	63X50	YC-3-B	3150
1		RECORD: START 12:30PM 2016	2000		
		FIN 1:45AM 21030	100		
		14277	1050		
	4	ADJUST TO 75* (1275 G) *NOTE: VOLUMES HIGHER THAN 75* MAY CAUSE DUSTING IN EXHAUST HOOD.			
	5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	6	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	7	RECORD: V-[redacted] VOL ____* & ADJ TO 60* (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 263 SV	9	RUN 40* (514 G) WATER INTO V-243 & START AGITATOR			
	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 12:45 TOTAL MINUTES 180			
2		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	11	WHEN V-205 MT, RUN IN 5* (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP & CP 3	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
	13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194*F)	JUN 3 1982		
	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 40% PRESET #2 95 GAL		115-D	504
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		8FC10 (N-27-D CONTROLLER) IN MANUAL 0.65 GPM		27-D	218
		8FC20 (N-27-D WATER) IN MANUAL LOCAL 5.2 GPM			
		8FR10 (N-27-D/WATER) RATIO 0.8			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.87 GPM		32-D	1476
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.8 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.1			

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EQUIP MENT		PAGE 2 CG 03 KY-908-D COMTYP JOB NAME: 03KY908DMG V-243	USE LBS	N-CODE	ACCT LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 90% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 47" (2400 G)			
CP	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)			
4		SIPHON INTO SV. RECORD: PH 11.2. ASSUME 50%	60	7-D	30
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8.			
SV	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	23	OPERATOR STEP PB			
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	26	OPERATOR STEP PB 5:50 PM			
	27	DURING STRIKE RECORD:			
		SP STEP V-243/V-244 PH RANGE TIME 13/46 (30 MIN) 9.3 9.3-10.0 6:20 PM 14/47 (60 MIN) 9.3 9.3-10.0 6:50 15/48 (2 HRS) 9.3 9.3-10.0 7:50 16/49 (2 HRS, 25 MIN) 9.3 9.3-10.0 8:15 17/50 (FINAL 3 HRS) 8.3 7.5-8.5 8:50 PM 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%	___	27-D	___
	28	SIFT IN	50	128-A	50
385	29	ADD 42" (320 G) WATER TO V-385			
6	30	ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	260	7-D	130
	31	DURING STRIKE CHECK LEVEL IN V-387.			
387	32	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	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.			
	35	RUN IN 25" (244 GAL). DO NOT MAKE UP THIS SOLUTION MORE THAN 30 MINUTES IN ADVANCE. DELAY BETWEEN END OF STEP 41 HEAT-UP AND START OF STEP 48 HOMOGENIZATION SHOULD BE LESS THAN 30 MINUTES.			
388	36	TURN ON STEAM & AGITATOR			
8	37	ADJUST TO 32"-(317 GAL) AT 178-182*F			
	38	SET BADGER METER FOR 466#			
	39	PUMP IN FROM V-387 THRU UNDERSURFACE	378	169-A	378
		DISTRIBUTORS AS FAST AS POSSIBLE	44	155-A	44
			44	160-A	44
	40	SHUT OFF PUMP			
	41	STIR 30 MIN AT 178-182*F FOR S 48			
	42	DO NOT SHUT OFF AGITATOR			

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EQUIPMENT	PAGE 3 CG 03 KY-908-D JOB NAME: 03KY908DMG	USE LBS	N-CODE	ACCT LBS
SV & SP 9	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN			
	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI, TO SEWER			
	WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG DISCHARGE VALVE TO SV AND CLOSE VALVE TO SEWER			
	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200*F.			
	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
	WHEN S50 COMPLETE TURN OFF HOMOG & STEARATE PUMP			
	STIR 5 MIN AT 198-200*F			
	SHUT OFF STEAM			
	WHEN S53 COMPLETE, OPERATOR PB			
	SP STEP 23/53 RECORD PH 3.6 (3.3-3.7)			
	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH____.			
	NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%	~	115-D	~
	RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN			
	RECORD: PH 5.0 (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH____. ASSUME 50%	~	7-D	~
	(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%	10	27-D	7
	SIPHON N-7-D INTO SV			
	OPERATOR STEP PB			
	OPERATOR STEP PB			
	SP STEP 60 - BATCH COMPLETE			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPERATOR
3:00 PM		10:15 PM		237-223

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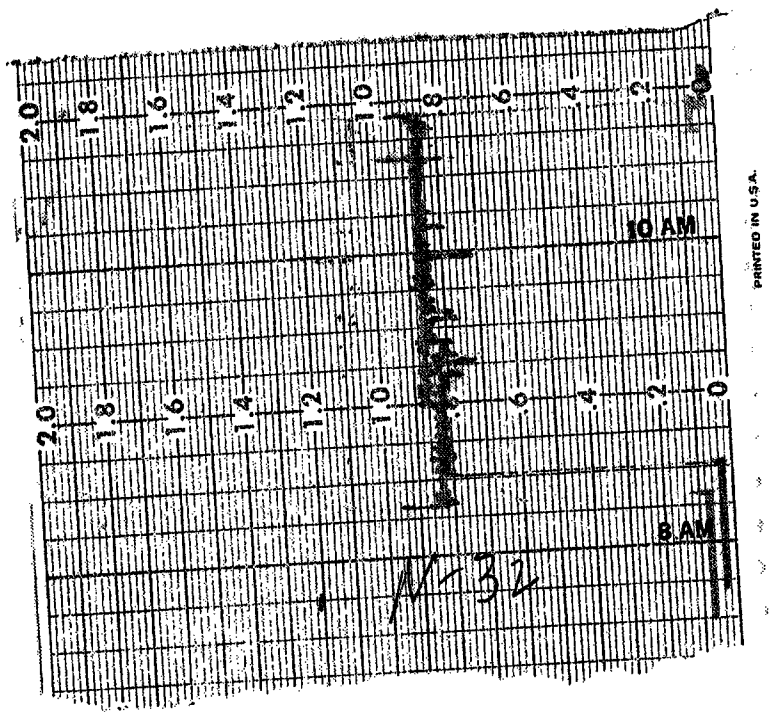
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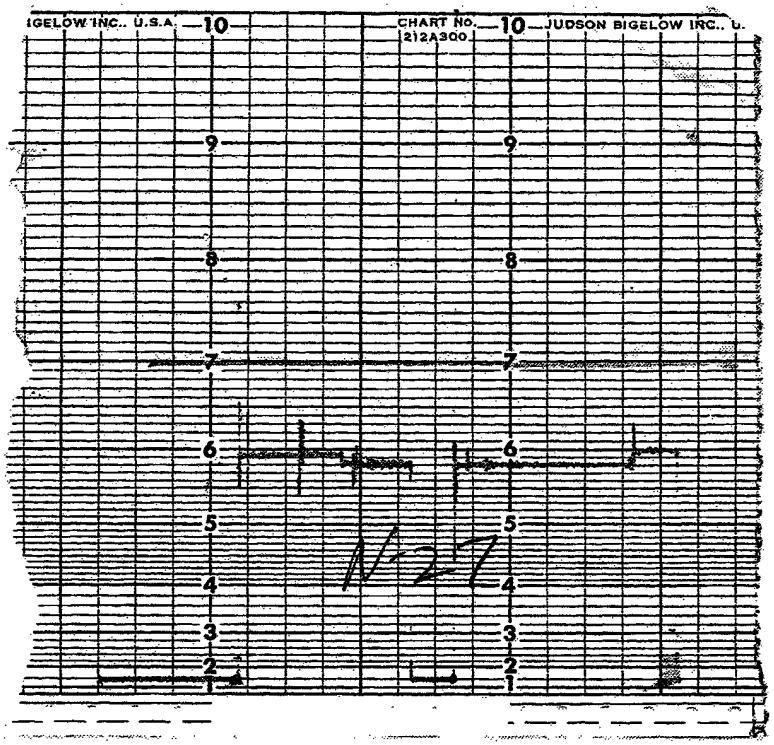

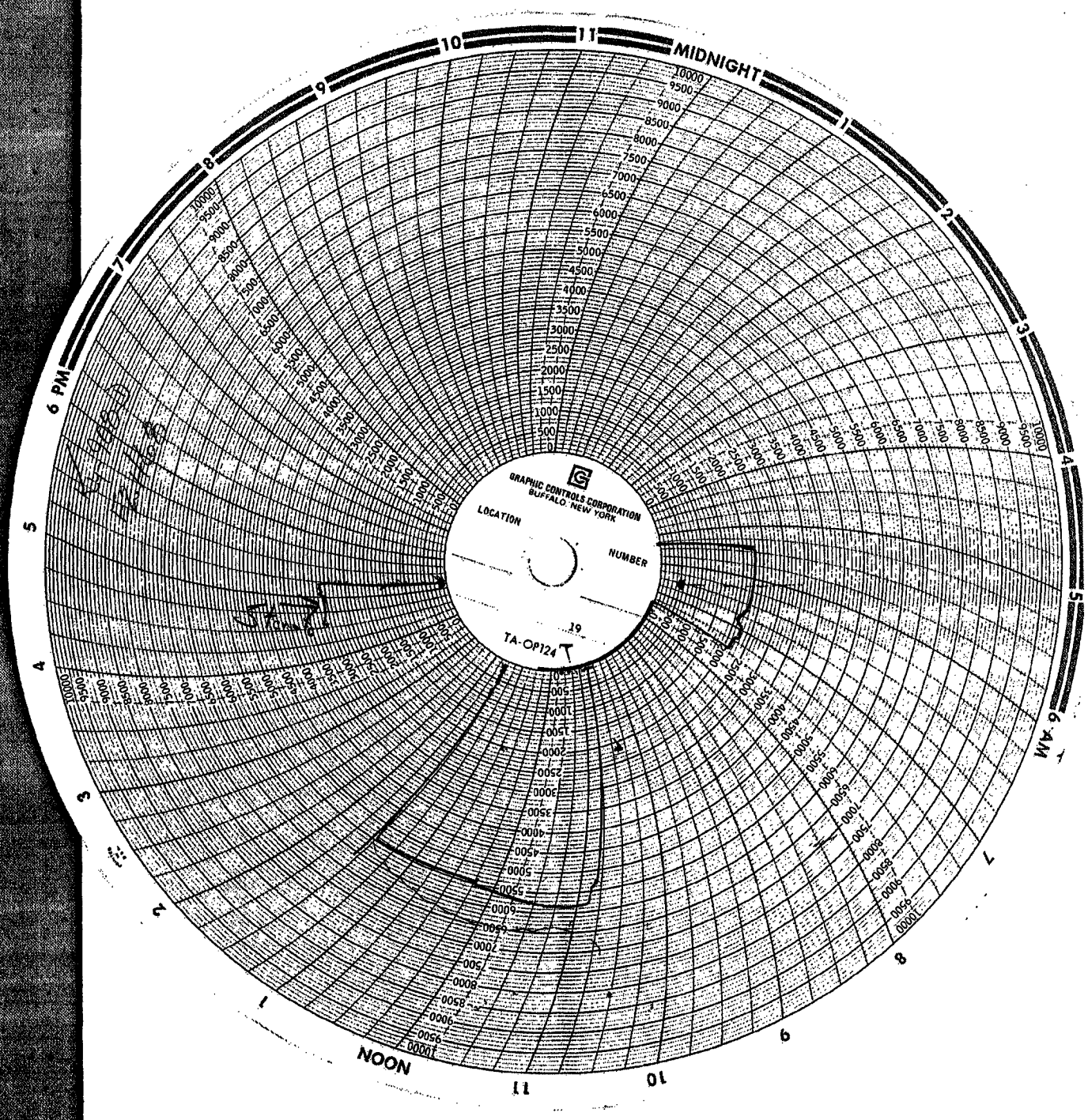

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