

CG 03

CODE KY-787-D

PKG

PROCESSES

APPROVED BY:

K2K03

3404# 3444
(EST WGT)

() KY-787-D (T)

FWP 09/27/82

COMTYP JOB NAME: 03KY787DMT

-10/12/82
(DATE)

(LOT)

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
		YC-2-D		J2D43	2000	100.00				
				J2D33	500	100.00				
						100.00				

BLEND BACK FOR STEP 43: KY-787-D, G2J99, 150 # ON 6-3 OR GET FROM R/M.
NOT FOR V-203

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
	"KROLOR" YELLOW-MEDIUM			
203 & 205	"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF".			
1	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
2	WEIGH IN DRUM & POUR IN (SODIUM SILICATE)	250	32-D	250
3	DUMP IN AND STIR 5 MIN (CHROME YELLOW MEDIUM)	50X50	YC-2-B	2500
1	RECORD: START 4:AM. LOT J2D43	2000		
	FIN 5:AM. J2D33	500		
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-205 VOL 57" & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 11:00 AM TOTAL MINUTES 105			
11	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP & CP	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
3	PRESS SV CAM RESET PB - SET 22 TO IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 80% PRESET #1 32 GAL (LIQUID ALUM)	115-D		168
	B. 13LG 48% PRESET #6 141 GAL (CALCIUM CHLORIDE 77%)	115-D		141
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D -SULFURIC ACID 60%- CONTROLLER) IN MANUAL 0.64 GPM	27-D		213
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.31			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.84 GPM	32-D		1425
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.76			
14	OPERATOR STEP PE			

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EQUIP PAGE 2 CG 03 KY-787-D V-244 USE N- USE
MENTI LBS CODE LBS

320 17 RECORD LEVEL 2LG 12% IF BELOW 35% FOLLOW SOLN
SV MAKE-UP PROCEDURE FOR N-27-D
SP 18 ADJUST SV TO 49° (2470 G)
CP 19 RECORD PH 10.5 ADJ TO 11.1-11.3 WITH N-7-D
(CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1
4 PART N-7-D)
4 SIPHON INTO SV. RECORD: PH 14.3 ASSUME 50% 50 7-D 25
20 OPERATOR STEP PB

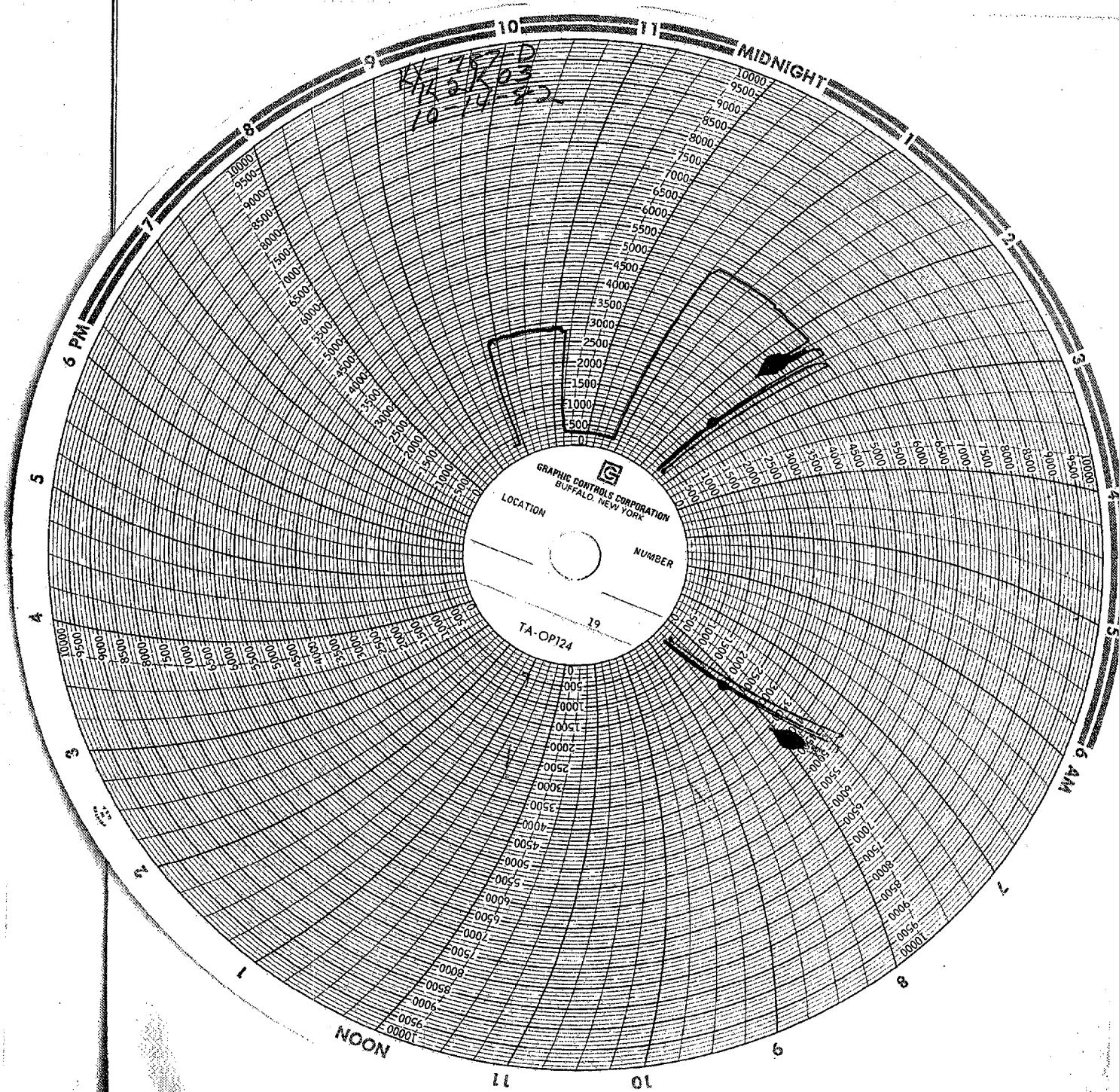
21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0
SV 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 23 OPERATOR STEP PB
24 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 25 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
26 OPERATOR STEP PB 5:20
27 DURING STRIKE RECORD:
SP STEP
V-243/V-244
PH RANGE TIME
13/46 (30 MIN) 9.7 9.0-10.0 5:50
14/47 (60 MIN) 9.7 9.0-10.0 6:20
15/48 (2 HRS) 9.6 9.0-10.0 7:20
16/49 (2 HRS, 25 MIN) 9.6 9.0-10.0 7:45
17/50 (FINAL 3 HRS) 7.7 7.5-8.5 8:20
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

128 WHILE STRIKING RUN 30° (234 G) WATER INTO V-339
129 ADD IN 7-8 MIN. (DRESINATE X) CHECK FOR DRAFT 365 530-A 365
IN VENT STACK BEFORE DUMPING.
339 130 ADJ TO 49° (382 G) AT 80-100°F
6 131 STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)
132 STIR 15 MIN OR LONGER FOR SP STEP 26
133 RECORD: VOL 42 * & CALC 42 * X 0.78 = 38.2 GAL
134 SET PRESET #8 TO 38.2 GAL FROM S 33

385 135 RUN 47° (360 G) WATER INTO V-385
7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

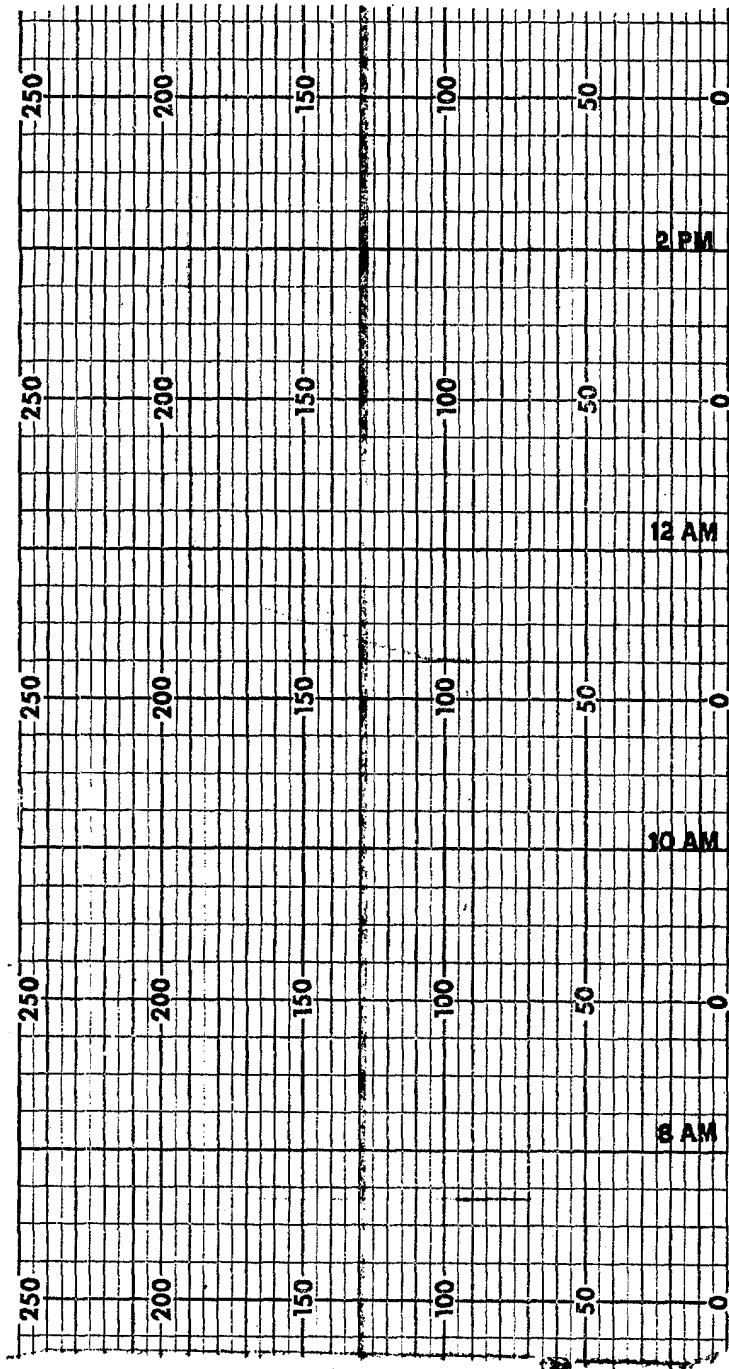
137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
138 SIFT IN (BLANC FINE N) 110 128-A 110
SV 139 SP STEP 23/53. RECORD: PH 3.8 (3.7-4.2)
SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
8 141 RECORD: PH 8.9 (9.0-9.5). ADJ IF NECESSARY &
RECORD: PH 9.1 ASSUME 77%
(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 10 27-D
(SIPHON N-7-D INTO SV) 7-D 5
142 OPERATOR STEP PB
143 SIFT IN BLEND BACK: KY-787-D, 612599, 150V
144 SP STEP 29/58. RECORD: PH 9.0 & TIME 9:45 AM
145 OPERATOR STEP PB
146 SP STEP 60. BATCH COMPLETE.

7:00 START 7:45 FINISH 5:20 OPT
TIME SP STEP TIME SP STEP 3:20 3:20
7:00 PM 7:45 PM 5:20 PM

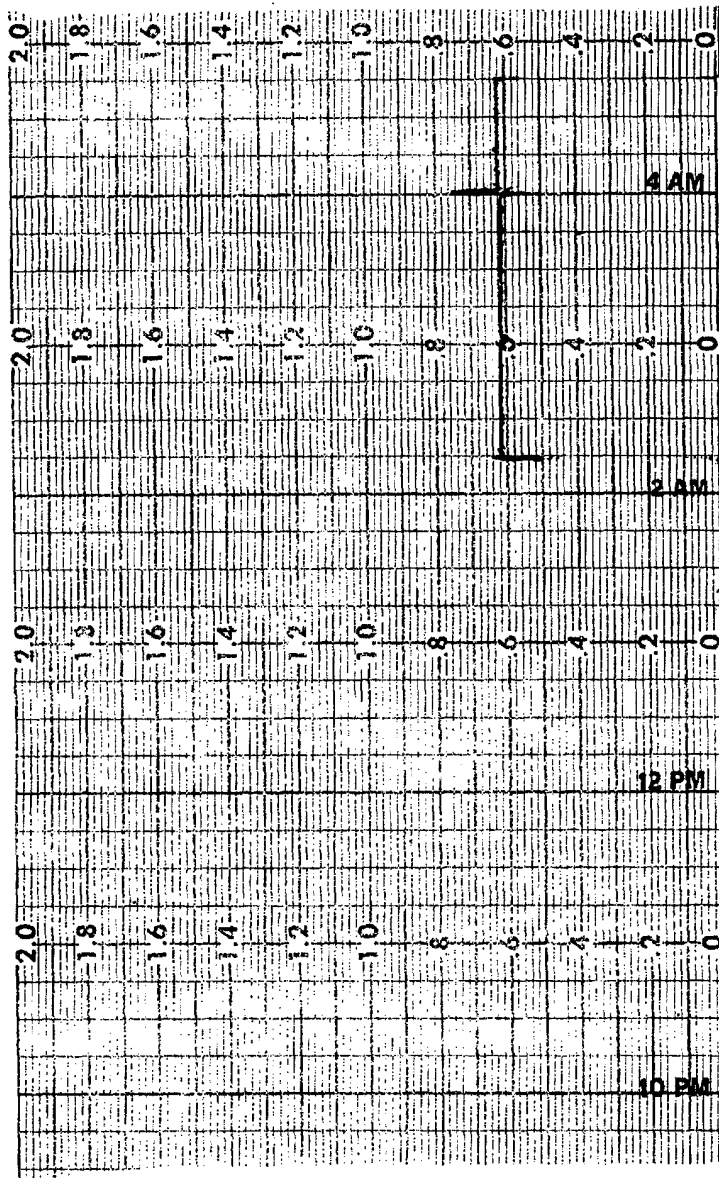


11/10

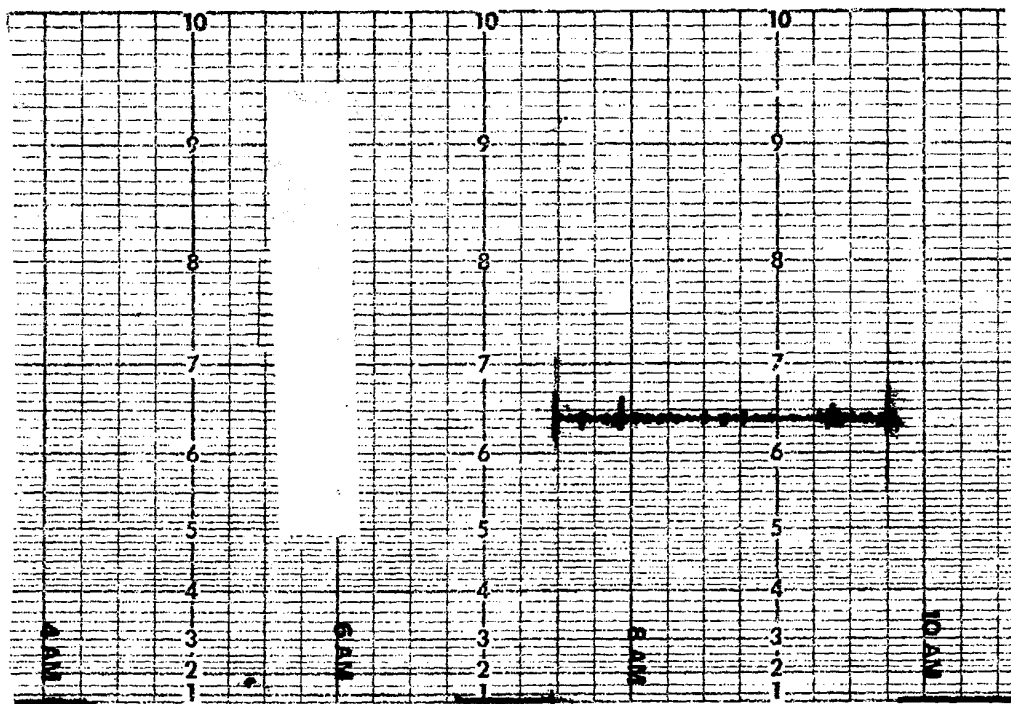
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