

OCT 20 1982

L2H86

4226*

() KY-908-D (G) FWP 10/05/82

COMTYP JOB NAME: 03KY908DMG

(DATE)

(LOT)

(EST WGT)

STANDARD HRS.

TIME _____ M

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	==	=====	==	=====	=====	=====	=====	=====	=====	=====
	14	YC-3	93	<u>D2008</u>	<i>JP</i>		<u>40</u>	<u>50</u>	<u>2000</u>	
	14	YC-3	93	<u>J2B08</u>			<u>23</u>	<u>50</u>	<u>1150</u>	
	14	YC-3	93							
	14	YC-3	93							

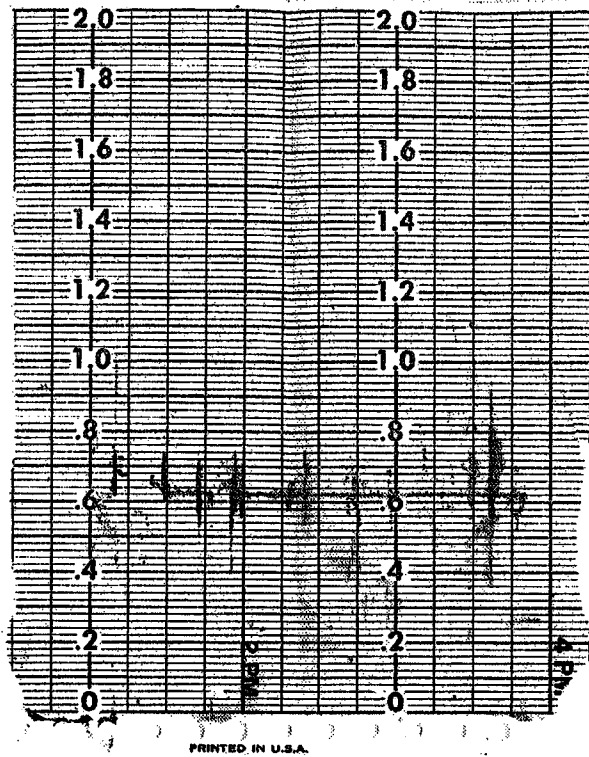
EQUIP MENT		NON-BLEEDING				
		NAME	USE LBS	N- CODE	ACCT LBS	
		"KROLOR" YELLOW-LIGHT				
		"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO- CHLORIC ACID) IF ANY IS BLANKED OFF."				
203	1	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.				
205	2	WEIGH IN DRUM & POUR IN (SODIUM SILICATE)	420	32-D	420	
	3	DUMP IN AND STIR 5 MIN (CHROME YELLOW)	63X50	YC-3-B	3150	
1		RECORD: START <u>7:00 AM</u> LOT <u>D2008</u> FIN <u>9:30 AM</u> <u>J2B08</u>	<u>2000</u> <u>1150</u>			
		ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.				
		WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205				
		WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205				
		RECORD: V-205 VOL <u>47</u> & ADJ TO 60" (2100 G)				
		INSPECT HOMOG STRAINER & CLEAN IF NECESSARY				
205	7	RUN 10" (514 G) WATER INTO V- 200 START AGITATOR				
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V.				
		RECORD: TIME START <u>1:51 PM</u> TOTAL MINUTES <u>96</u>				
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	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION				
&		2 (V-243) OR POSITION 7 (V-244)				
CP	13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO				
		REMOTE (TEMP IS SET AT 190-194°F)				
3	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:				
		A. 11LG <u>72</u> % PRESET #2 95 GAL				
		(LIQUID ALUM)				
15		SET STRIKE FLOW CONTROLLERS AS FOLLOWS:				
		3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%)				
		IN MANUAL 0.65 GPM				
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.2 GPM				
		3FR10 (N-27-D/WATER) RATIO 0.8				
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.87 GPM				
		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				

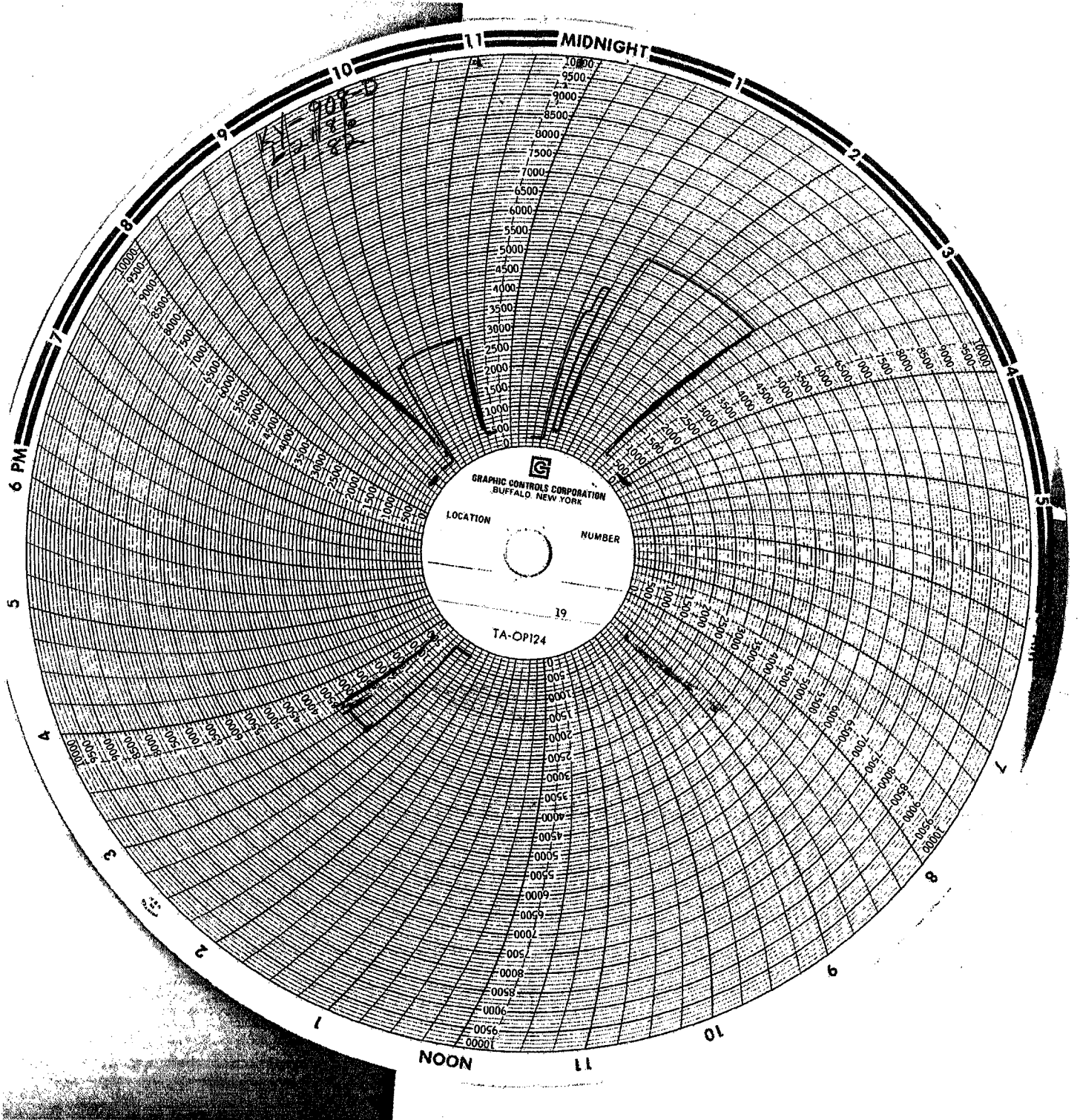
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EQUIP MENT	PAGE 2 CG 03 KY-908-D	USE LBS	N- CODE	ACCT. LBS
	<i>V-240</i>			
320	16 OPERATOR STEP PB			
SV	17 RECORD LEVEL 2LG ____% IF (35% FOLLOW SOLUTION			
SP	18 MAKE-UP PROCEDURE FOR N-27-D			
CP	18 ADJUST SV TO 47" (2400 G)			
	19 RECORD PH <u>10.0</u> ADJ TO 11.0-11.2 WITH N-7-D			
	(CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1			
	PART N-7-D)			
4	20 SIPHON INTO SV. RECORD: PH <u>11.1</u> ASSUME 50%	<u>24</u>	7-D	<u>12</u>
	20 OPERATOR STEP PB			
SV	21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.5</u>			
SP	22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	23 OPERATOR STEP PB			
5	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:			
	SP STEP			
	V-243/V-244			
	13/46 (30 MIN)	PH RANGE TIME		
	14/47 (40 MIN)	<u>9.3</u> 9.3-10.0 <u>7:10/PM</u>		
	15/48 (2 HRS)	<u>9.3</u> 9.3-10.0 <u>7:40/PM</u>		
	16/49 (2 HRS, 25 MIN)	<u>9.5</u> 9.3-10.0 <u>8:40/PM</u>		
	17/50 (FINAL 3 HRS)	<u>9.4</u> 9.3-10.0 <u>9:10/PM</u>		
		<u>7.3</u> 7.5-8.5 <u>9:40/PM</u>		
	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%			
385	28 SIFT IN (BLANC FIXE N)	<u>55</u>	27-D	<u>55</u>
6	30 ADD 42" (320 G) WATER TO V-385			
	30 ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	260	7-D	130
387	31 DURING STRIKE CHECK LEVEL IN V-387.			
7	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	35 RUN IN 25" (244 GAL). DO NOT MAKE UP THIS			
8	36 SOLUTION MORE THAN 30 MINUTES IN ADVANCE.			
	36 TURN ON STEAM & AGITATOR			
	37 ADJUST TO 32" (317 GAL) AT 178-182°F			
	38 SET BADGER METER FOR 466±			
	39 PUMP IN FROM V-387 THRU UNDERSRFACE DISTRIBUTORS	378	169-A	378
	AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL	44	155-A	44
	STEARATE, EMCOL P-10-59)	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			

EQUIP MENT	PAGE 3 CG 03 KY-908-D	USE LBS	N- CODE	ACCT LBS
SV 143	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN			
SP 144	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
145	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
146	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI, TO SEWER			
147	WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG DISCHARGE VALVE TO SV AND CLOSE VALVE TO SEWER			
148	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.			
149	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP			
150	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER			
151	WHEN S50 COMPLETE TURN OFF HOMOG & STEARATE PUMP			
152	STIR 5 MIN AT 198-200°F			
153	SHUT OFF STEAM			
154	WHEN S53 COMPLETE, OPERATOR PB			
155	SP STEP 23/53 RECORD PH <u>3.4</u> (3.3-3.7)			
156	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%			
157	RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN			
158	RECORD: PH <u>9.0</u> (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH <u>4.35</u> ASSUME 50% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%			
	SIPHON N-7-D INTO SV			
159	OPERATOR STEP PB			
160	OPERATOR STEP PB			
161	SP STEP 60 - BATCH COMPLETE			
	START FINISH OPERATOR			
	TIME SP STEP TIME SP STEP			
	<u>10:20 AM</u> <u>11:00 AM</u> <u>11:00</u>			
	<u>11:00 AM</u> <u>11:46 AM</u> <u>11:46</u>			
		<u>54</u>		
		<u>409-438</u>		
		<u>409-438</u>		

NOTE
N-115-D WILL NOT GO INTO
VAT AUTOMATICALLY, STEP 52.
ADDED TO VAT MANUALLY.





V-240