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

CG 03 CODE KY-908-D PKG

MAY 27 1982 F2H70

DATE LOT NUMBER

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	14276	93	2000	14	YC-3-B	_____	93	_____
14	YC-3-B	D2D37	93	500	14	YC-3-B	_____	93	_____
14	YC-3-B	14277	93	200	14	YC-3-B	_____	93	_____

EST. WT. 4221* LBS. NOTE- Sv. Steam Out Steps #5 Non-Homog. Pass. 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~~ V-263 1	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
		RECORD: START 4:20 P 14276	2000		
		FIN 5:16 P D2D37	500		
		14277	200		
	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~~ 263			
	6	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-~~205~~ 263	JUN 7	1982	
V-263	7	RECORD: V-~~205~~ VOL 42" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
~~205~~	9	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR 263			
SV 4 & 2	10	PUMP V-~~205~~ THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:50 PM TOTAL MINUTES 225			
		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)			
	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 76 % PRESET #2 95 GAL		115-D	504
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		~~3~~FC10 (N-27-D CONTROLLER) IN MANUAL 0.65 GPM		27-D	218
		~~3~~FC20 (N-27-D WATER) IN MANUAL LOCAL 5.2 GPM			
		~~3~~FR10 (N-27-D/WATER) RATIO 0.8			
		~~8~~FC10 (N-32-D CONTROLLER) IN MANUAL 0.87 GPM		32-D	1476
		~~8~~FC20 (N-32-D WATER) IN MANUAL LOCAL 4.8 GPM			
		~~8~~FC20 (N-32-D WATER) IN REMOTE			
		~~8~~FR10 (N-32-D/WATER) RATIO 1.1			

LOT 2449 DATE PRINTED: 3/26/82

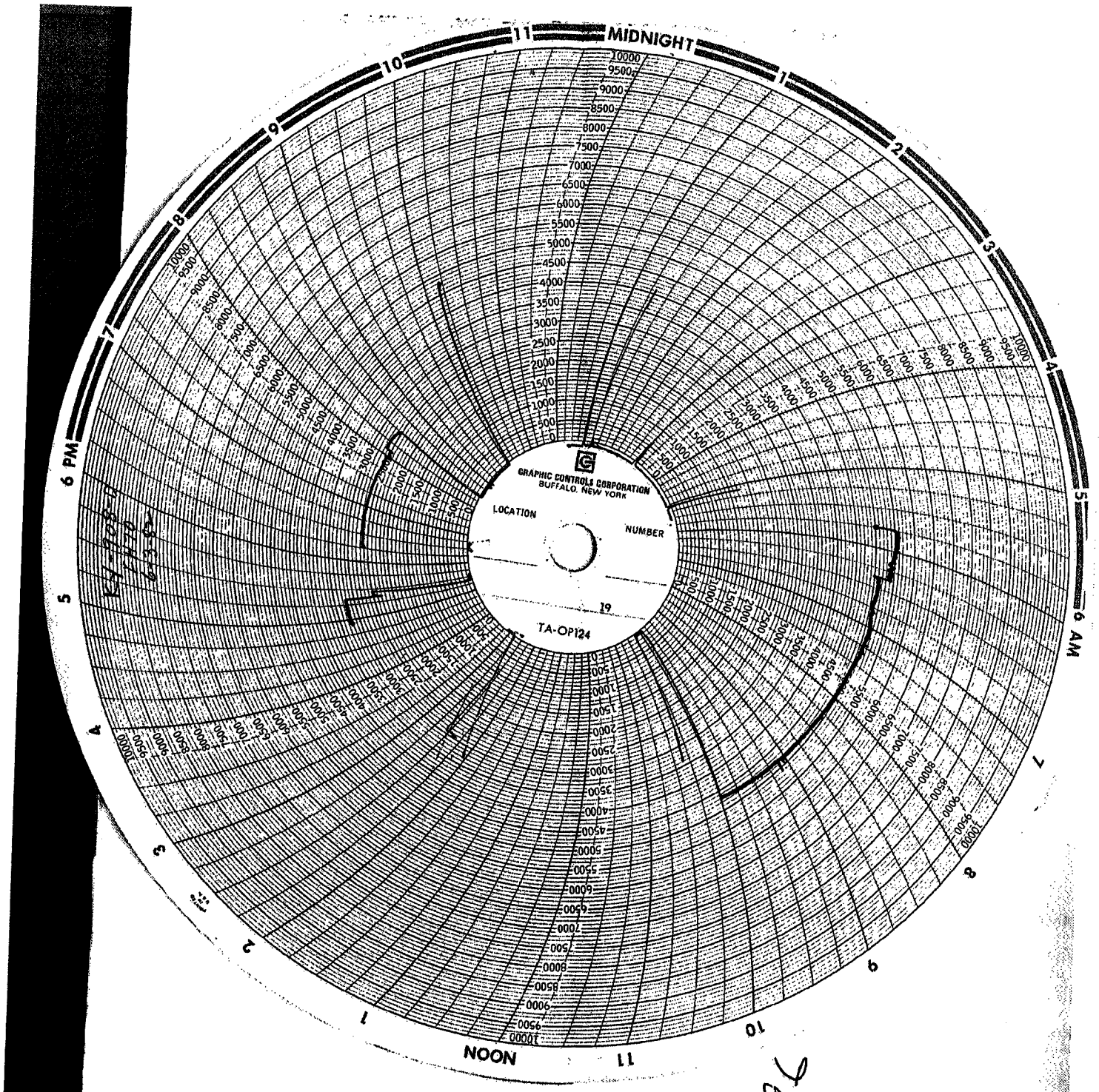
EQUIPMENT		PAGE 2 CG 03 KY-908-D COMTYP JOB NAME: 03KY908DMG	USE LBS	N-CODE	ACCT LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 88% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 47" (2400 G)			
CP	19	RECORD PH 9.3. ADJ TO 11.0-11.2 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.0. ASSUME 50%	40	7-D	20
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.2			
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			
	27	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.4 9.3-10.0 1-40			
		14/47 (60 MIN) 9.4 9.3-10.0 2-40			
		15/48 (2 HRS) 9.4 9.3-10.0 3-40			
		16/49 (2 HRS, 25 MIN) 9.4 9.3-10.0 3-05			
		17/50 (FINAL 3 HRS) 6.7 7.5-8.5 3-40			
		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%	____	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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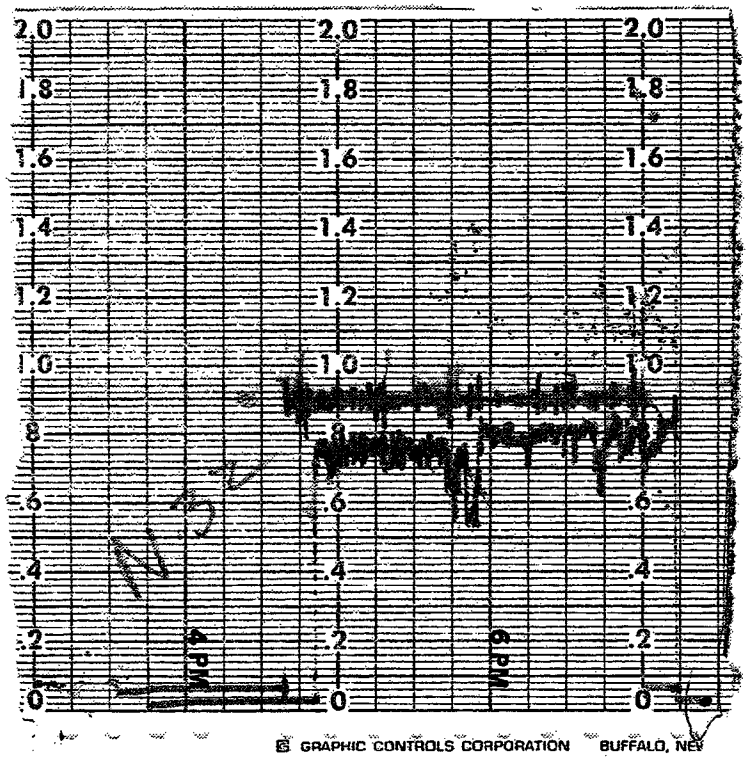
LOT V-244 DATE PRINTED: 3/26/82

EQUIPMENT		PAGE 3 CG 03 KY-908-D JOB NAME: 03KY908DMG	USE LBS	N-CODE	ACCT LBS
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 2900-3100 PSI, TO SEWER			
	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 & STEARATE 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 3.6 (3.3-3.7)			
	56	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	____
	57	RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN			
	58	RECORD: PH 7.0 (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH 4.4. ASSUME 50% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78% SIPHON N-7-D INTO SV	35	7-D 27-D	27
	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
11:00 AM		7:00 AM		37-201
3:00 PM		6:00 PM		237



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