

NOV 3, 1982

L2J-6

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							
	14	YC-3	93	62324	3150					
	14	YC-3	93							
	14	YC-3	93							

EQUIP MENT	NAME : "KROLOR" YELLOW-LIGHT	NON-BLEEDING USE LBS	N- CODE	ACCT LBS
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203	✓	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF.		
205	✓	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.		
1	✓	WEIGH IN DRUM & POUR IN (SODIUM SILICATE)	420	32-D
	✓	DUMP IN AND STIR 5 MIN (CHROME YELLOW)	63X50	YC-3-B
		RECORD: START <u>1:00 PM</u> LOT <u>62324</u>	3150	3150
		FIN <u>2:10 AM</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>48</u> & ADJ TO 60" (2100 G)		
	✓	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 <u>11:15 PM</u> TOTAL MINUTES <u>90</u>		
		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		

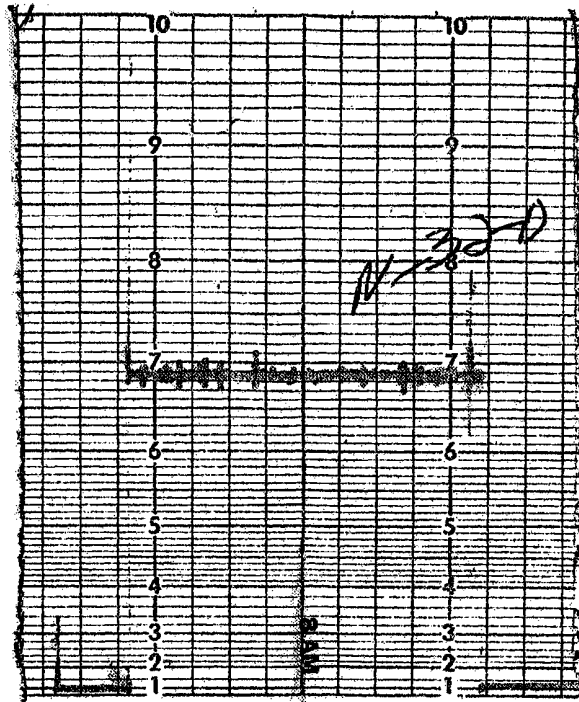
SP	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION		
	2	(V-243) OR POSITION 7 (V-244)		
CP	13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO		
		REMOTE (TEMP IS SET AT 190-194°F)		
3	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:		
		A. 11LG <u>52%</u> PRESET #1 95 GAL	115-D	504
		(LIQUID ALUM)		
15		SET STRIKE FLOW CONTROLLERS AS FOLLOWS:		
		3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%)		
		IN MANUAL 0.65 GPM	27-D	218
		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	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		

NOV 5 1982

11/4/82

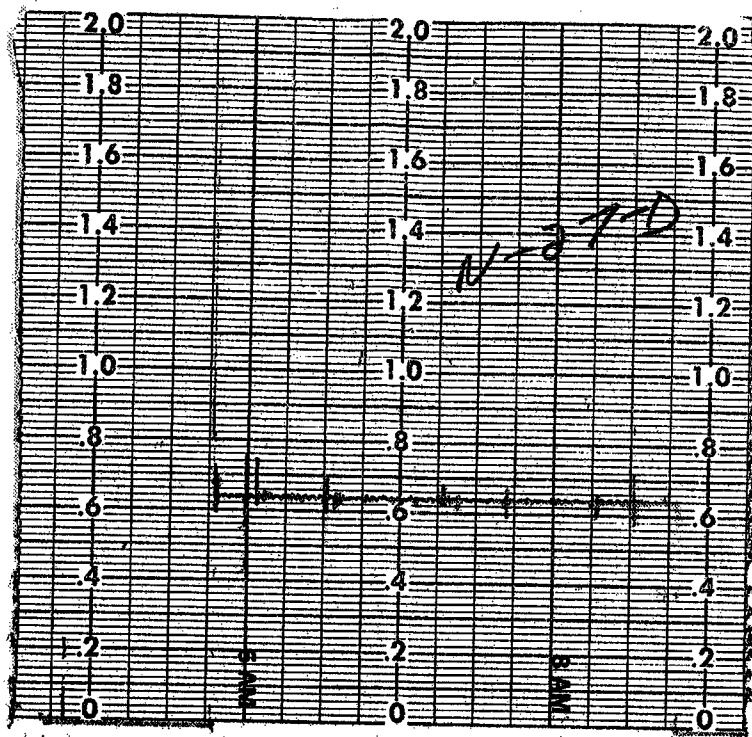
EQUIP MENT	PAGE 2 CG 03 KY-908-D <i>V-244</i>	USE LBS	N- CODE	ACCT. LBS
320	16 OPERATOR STEP PB			
SV	17 RECORD LEVEL 2LG <i>82</i> % IF (35% FOLLOW SOLUTION			
SP	18 MAKE-UP PROCEDURE FOR N-27-D			
CP	19 ADJUST SV TO 47° (2400 G)			
	20 RECORD PH <i>9.8</i> ADJ TO 11.0-11.2 WITH N-7-D (CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4	21 SIPHON INTO SV. RECORD: PH <i>11.2</i> ASSUME 50%	60	7-D	30
	22 OPERATOR STEP PB			
SV	23 SP STEP 06/39. AFTER HEAT-UP RECORD: PH <i>9.7</i>			
SP	24 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	25 OPERATOR STEP PB			
5	26 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
	27 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	28 OPERATOR STEP PB			
	29 DURING STRIKE RECORD: SP STEP V-243/V-244			
	PH RANGE TIME			
	13/46 (30 MIN) <i>9.5</i> 9.3-10.0 <i>5:25/P</i>			
	14/47 (60 MIN) <i>9.5</i> 9.3-10.0 <i>5:55/P</i>			
	15/48 (2 HRS) <i>9.5</i> 9.3-10.0 <i>6:55/P</i>			
	16/49 (2 HRS, 25 MIN) <i>9.4</i> 9.3-10.0 <i>7:20/P</i>			
	17/50 (FINAL 3 HRS) <i>7.5</i> 7.5-8.5 <i>7:55</i>			
	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%			
28	30 SIFT IN (BLANC FIXE N)	55	27-D 128-A	55
385	31 ADD 42° (320 G) WATER TO V-385			
6	32 ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	260/60	7-D	130/80
	33 DURING STRIKE CHECK LEVEL IN V-387.			
387	34 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	35 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	36 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			
	37 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	38 TURN ON STEAM & AGITATOR			
8	39 ADJUST TO 32° (317 GAL) AT 178-182°F			
	40 SET BADGER METER FOR 466±			
	41 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
	42 SHUT OFF PUMP			
	43 STIR 30 MIN AT 178-182°F FOR S 48			
	44 DO NOT SHUT OFF AGITATOR			

EQUIP MENT	PAGE 3 CG 03 KY-908-D	USE LBS	N- CODE	ACCT LBS																									
SV-43	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN																												
&	5 TO 10 MIN																												
SP-44	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE																												
9	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 <u>3.0</u> (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 <u>3.2</u> (4.2-4.4) & IF NECESSARY, ADJ																												
	TO PH 4.2-4.4 & RECORD: PH <u>4.3</u> ASSUME 50%	80	7-D	40																									
	(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																												
<table> <tr> <td colspan="2">START</td><td colspan="2">FINISH</td><td>OPERATOR</td></tr> <tr> <td>TIME</td><td>SP STEP</td><td>TIME</td><td>SP STEP</td><td></td></tr> <tr> <td><u>7:00 PM</u></td><td></td><td><u>7:30 PM</u></td><td></td><td><u>37-8-12</u></td></tr> <tr> <td><u>3:12 PM</u></td><td></td><td><u>10:30 PM</u></td><td></td><td><u>54-120</u></td></tr> <tr> <td></td><td></td><td></td><td></td><td></td></tr> </table>					START		FINISH		OPERATOR	TIME	SP STEP	TIME	SP STEP		<u>7:00 PM</u>		<u>7:30 PM</u>		<u>37-8-12</u>	<u>3:12 PM</u>		<u>10:30 PM</u>		<u>54-120</u>					
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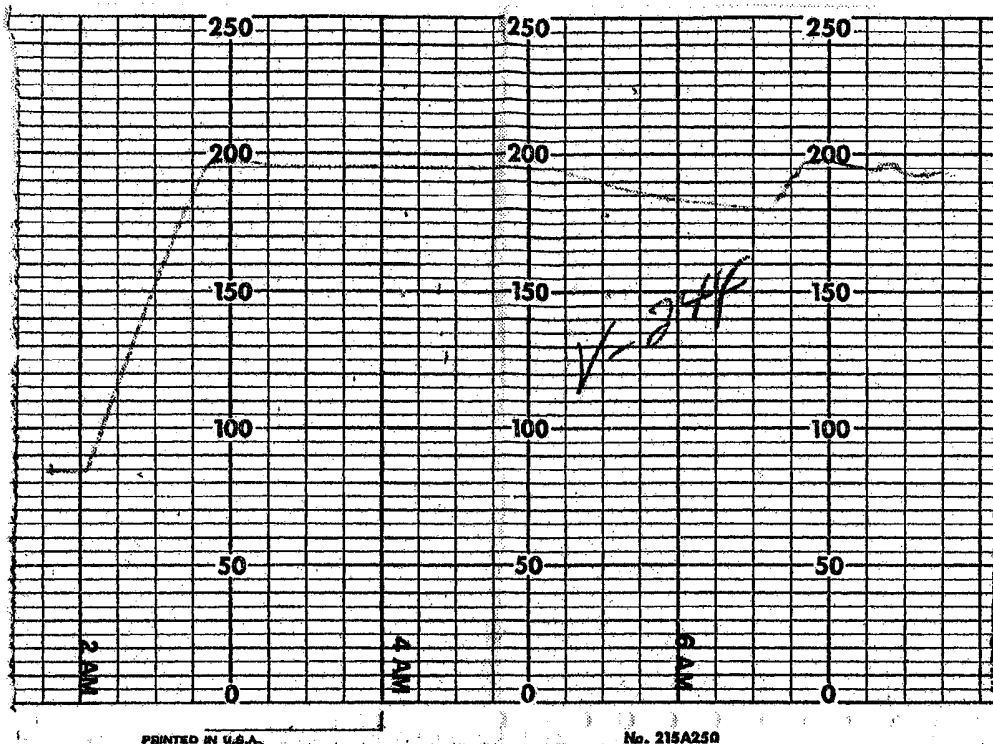


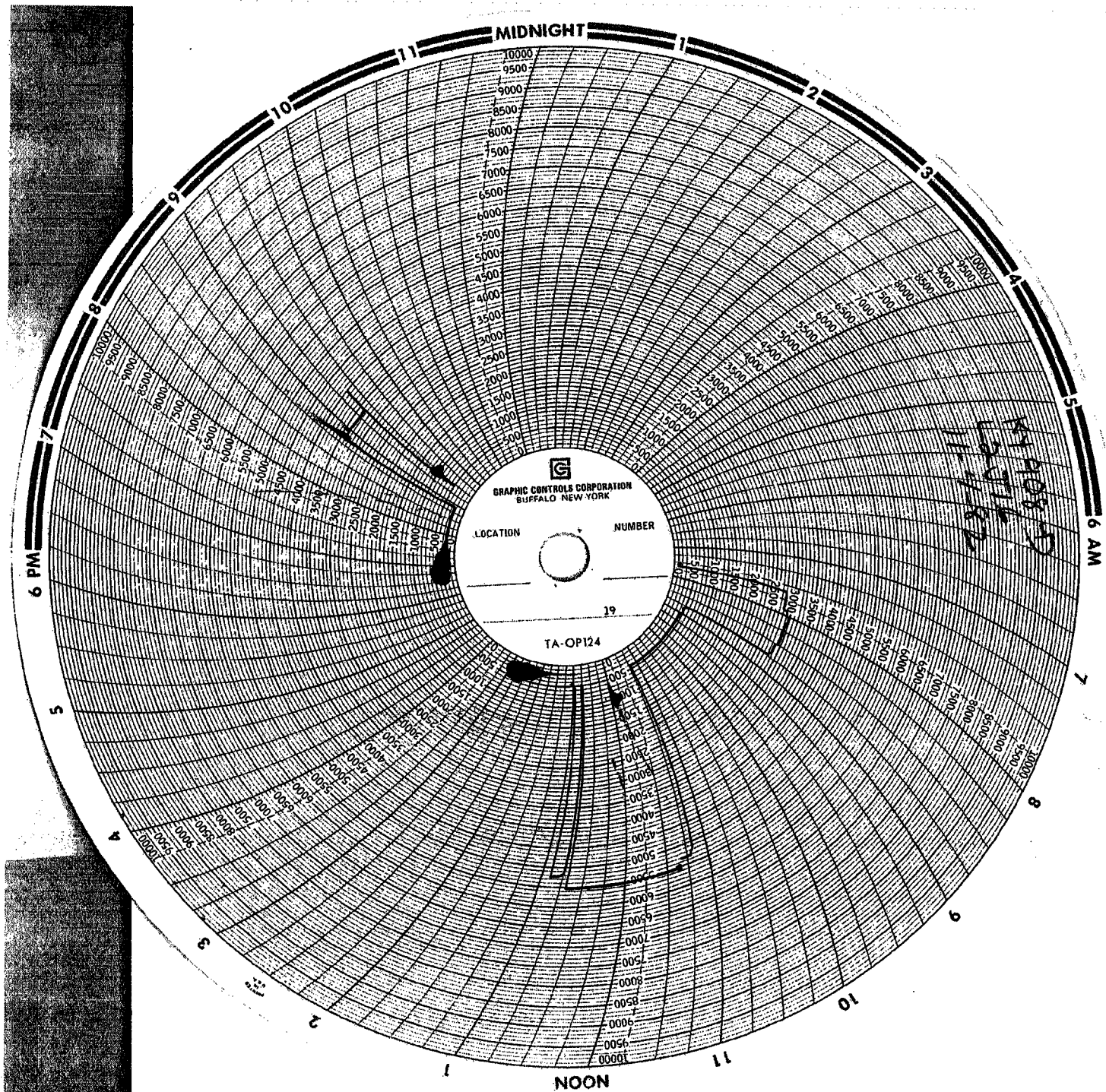
JEFFALO, NEW YORK

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