

NOV 1, 1982

L2J10

4226*

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

("DATE")

("LOT")

("EST WGT")

COMTYP JOB NAME: 03KY908DMG

STANDARD HRS.

TIME _____ H

LDCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	14	YC-3	93	K2B03	2000					
	14	YC-3	93	K2B02	850					
	14	YC-3	93	J2B08	300					
	14	YC-3	93							

EQUIP MENT		NON-BLEEDING			
		NAME	USE LBS	N- CODE	ACCT LBS
		"KROLOD" 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>1:PM</u> LOT <u>K2B03</u> FIN <u>2:PM</u> <u>K2B02</u> <u>J2B08</u>	<u>2000</u> <u>850</u> <u>300</u>		
	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 <u>50</u> & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9	RUN 10" (514 G) WATER INTO V-240 START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>8:52</u> TOTAL MINUTES <u>110</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>74</u> % PRESET <u>1</u> 95 GAL		115-D	504
		(LIQUID ALUM)			
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%)		27-D	218
		IN MANUAL 0.65 GPM			
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.2 GPM			
		3ER10 (N-27-D/WATER) RATIO 0.8			
		8EC10 (N-32-D CONTROLLER) IN MANUAL 0.87 GPM		32-D	2476
		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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Jep 11/3

EQUIP MENT	PAGE 2 CG 03 KY-908-D	USE LBS	N- CODE	ACCT. LBS
320	16 OPERATOR STEP PB			
SV	17 RECORD LEVEL 2LG 84% IF (35% FOLLOW SOLUTION 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 (CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4	20 SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50%	50	7-D	25
	21 OPERATOR STEP PB			
SV	22 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.6			
SP	23 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	24 OPERATOR STEP PB			
	25 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	26 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	27 OPERATOR STEP PB			
	28 DURING STRIKE RECORD: SP STEP V-243/V-244			
	13/46 (30 MIN) PH 10.0 RANGE 9.3-10.0 TIME 1.55			
	14/47 (60 MIN) PH 10.0 RANGE 9.3-10.0 TIME 2.25			
	15/48 (2 HRS) PH 10.0 RANGE 9.3-10.0 TIME 3.25			
	16/49 (2 HRS, 25 MIN) PH 10.0 RANGE 9.3-10.0 TIME 3.50			
	17/50 (FINAL 3 HRS) PH 8.3 RANGE 7.5-8.5 TIME 4.25			
	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%			
128	29 SIFT IN (BLANC FIXE N)	55	27-D 128-A	55
385	30 ADD 42" (320 G) WATER TO V-385			
6	31 ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	260	7-D	130
	32 DURING STRIKE CHECK LEVEL IN V-387.			
387	33 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	34 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	35 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			
	36 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	37 TURN ON STEAM & AGITATOR			
8	38 ADJUST TO 32" (317 GAL) AT 178-182°F			
	39 SET BADGER METER FOR 466+			
	40 PUMP IN FROM V-387 THRU UNDERSRFE DISTRIBUTORS	378	169-A	378
	AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL STEARATE, EMCOL P-10-59)	44	155-A	44
	41 SHUT OFF PUMP	44	160-A	44
	42 STIR 30 MIN AT 178-182°F FOR S 48			
	43 DO NOT SHUT OFF AGITATOR			

EQUIP MENT		PAGE 3 CG 03 KY-908-D	USE LBS	N- CODE	ACCT LBS
		V-240			
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			
		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>3.5</u> (3.3-3.7)			
	56	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)			
		& RECORD: PH <u> </u>			
		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>4.3</u> (4.2-4.4) & IF NECESSARY, ADJ			
		TO PH 4.2-4.4 & RECORD: PH <u> </u> ASSUME 50%		7-D	
		(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			
		START FINISH OPERATOR			
TIME	SP STEP	TIME SP STEP			
11:00 PM		2:00 AM			409-438
3:12 PM		6:45 PM			54

