YC-3-B

CG 03 CODE KY-781-D PKG. _____

JAN 19 33880

EST. WGT. 818 LBS.

STD. HRS. _____ TIME 3 P M

| PROCESSES | | APPROVED B |
|---|---|---|
| ( ) KY-781-D | (N) | FWP 10-13-78 |
| ( ) | ( ) | AMJ 10-13-78 |
| ( ) | ( ) | FWP 06-26-79 |
| ( ) | ( ) | |
| TYPED BY emw062879 | | |

#2 ALL

OK

03 ~~14~~ KY-781-D ~~YC-3-B~~ 98 4 Lot 28326 , 600#
14 YC-3-B 93 4 Lot 24408 , 2250#
14 YC-3-B 93 4 Lot _____ , _____#
14 YC-3-B 93 4 Lot _____ , _____#

Total Wgt 4268# (Req. _____ )

Homog #3 Repacked 9:00 AM,

Homog #3 - 2nd Pass

NON-BLEEDING

| EQUIPMENT | | NAME: KROLOR® YELLOW LIGHT | USE LBS. | N CODE | ACC LBS |
|---|---|---|---|---|---|
| 203 & 205 1 | 1 | Run 60" (992 G) water in V-203 & add Assume 50% | 30 | 7-D | 15 |
| | 2 | Weigh in drum & pour in | 382 | 32-D | 382 |
| | 3 | Dump in & stir 5 min Lot | 57 x 50 | YC-3-B | 2850 |
| | | Record: Start 1:25 PM | | | |
| | | Fin 1:46 | | | |
| | | 75" (1275 G) 2400-2600 24408 | | | |
| | 4 | Adj to ~~80" (1360 G)~~ & Record: pH (10.5-11.5) | | | |
| | 5 | Pump V-203 thru Homog # 3 at ~~1800-2200~~ psi into V-~~205~~ 263 | | | |
| | 6 | When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water | | | |
| | 7 | Record: V-205 Vol 40 " & adj to 45" (1662 G) | | | |
| | 8 | Inspect Homog strainer & clean if necessary | | | |
| 205 & SV 2 | 9 | Run 12" (200 G) water into SV & start agitator | | | |
| | 10 | Pump V-205 thru Homog at 4800-5200 psi into V-244 | | | |
| | | Record: Time Start 9:05A Total Min 1:50 | | | |
| | | NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205 | | | |
| | 11 | When V-205 MTY, run in 5" (240 G) water & pump thru Homog at 4800-5200 psi | | | |
| SP & CP 3 | 12 | SP Step 01 — Set Formula Selector to position #1 (V-243) or #6 (V-244) | | | |
| | 13 | Press SV Cam Reset PB-Set 22TC in Auto Remote (Tempterature is set at 190-194°F) | | | |
| | 14 | Record levels & set Raw Material Counter #1 as follows: | | | |
| | | a) 11LG 45 % — preset #3 162 Gal | | 15-A | 324 |
| | 15 | Set strike flow controllers as follows: | | | |
| | | a) 3FC10 (N-27-D Controller) in Manual 0.78 GPM | | 27-D | 322 |
| | | b) 3FC20 (N-27-D Water) in Manual Local 5.44 GPM | | | |
| | | c) 3FR10 (N-27-D / Water Ratio) 0.7 | | | |
| | | d) 8FC10 (N-32-D Controller) in Manual 1.04 GPM | | 32-D | 2182 |
| | | e) 8FC20 (N-32-D Water) in Manual Local 4.66 GPM | | | |
| | | f) 8FC20 (N-32-D Water) in Remote | | | |
| | | g) 8FR10 (N-32-D / Water Ratio) 0.9 | | | |
| SV SP & CP 4 | 16 | Operator Step PB | | | |
| | 17 | Record Level 2LG 78 %. If below 35% follow solution make-up procedure for N-27-D | | | |
| | 18 | Adj SV to 54" (2800 G) | | | |
| | 19 | Record: pH 10.7 | | | |
| | 20 | Adj pH to 11.4-11.6 using Assume 50% | 30 | 7-D. | 15 |
| | | (Dilute to 5% (10 parts water to 1 part N-7-D)) | | | |
| | | Siphon into SV. Record: pH 11.4 | | | |
| | 21 | Operator Step PB | | | |

V 263

REV.

V-249

| MENT | | PAGE 2 CG 03 CODE KY-781-D (N) EST. WGT. 4268 LBS. | USE LBS. | CODE | |
|---|---|---|---|---|---|
| SV | 22 | SP Step 06/39 — After heat-up Record: pH 10.1 (9.6-10.2) | | | |
| SP | 23 | Switch 3FC20, 8FC10, 8FC20 to Auto | | | |
| & | 24 | Operator Step PB | | | |
| CP | 25 | SP Step 10/43 — When 3FC20, 8FC10, 8FC20 water flow in limits switch 3FC10 to Auto. Operator Step PB | | | |
| 5 | 26 | SP Step 11/44 — When 3FC10, 3FC20 flow in limits, switch 3FC20 to Remote. Opterator Step PB | | | |
| | 27 | During strike, Record pH & Time as follows: | 2:35 PM | | |

| SP Step | pH | Range | Time |
|---|---|---|---|
| 13/41 (30 min) | 10.0 | 9.3-10.0 | 3:05 |
| 14/47 (60 min) | 10.0 | 9.3-10.0 | 3:35 |
| ( 2 hrs) | 10.0 | 9.3-10.0 | 4:35 |
| ( 3 hrs) | 10.0 | 9.3-10.0 | 5:35 |
| 17/50 ( Final) | 6.5 | 7.5- 8.5 | 6:20 |

NOTE: If pH not as specified notify Supervisor & note in log. If final pH is above (8.5) adj to pH 7.5-8.5

| | | | | | |
|---|---|---|---|---|---|
| | | | M , % | | 27-D |
| ALM | 28 | During strike clean #2 ALM magnetic separator & pump strainer | | | |
| 6 | 29 | Install dust hood to #2 ALM & run in 2000# water | | | |
| | 30 | Dump in Lot 28326 | 600 | KY-781-D | 600 |
| | 31 | Stir 60 min. Add water as necessary to fluidize | | | |
| | 32 | When strike (S 27) complete, pump ALM thru box screen into SV- 249 | | | |
| | 33 | Rinse in ALM & lines | | | |
| | 34 | Clean magnetic separator & strainer | | | |
| 302 | 35 | Add 31" (379 G) water to V-302 | | | |
| | 36 | Add & stir 5 min Assume 50% | 110 | 7-D | 55 |
| SV | 37 | SP Step 17/50 — After checking pH. Operator PB | | | |
| SP | 38 | SP Step 23/53 — Record: pH 3.4 (3.3-3.7) | | | |
| & | 39 | If necessary adj pH (DOWN ONLY) Record: pH | | 15-A | |
| CP | | NOTE: Dissolve extra N-15-A in water at 110-120°F in drum | | | |
| 8 | | Use ± 30 G of water to 50# N-15-A. Stir SV 5 min after each addition | | | |
| | 40 | Run in N-7-D from S 36 & stir 5 min | | | |
| | 41 | Record: pH 3.8 (4.2-4.4) | | | |
| | 42 | If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts $H_2O$ to 1 part N-7-D) or N-27-D M , % | | 27-D | |
| | | Assume 50% | 50 | 7-D | 25 |
| | | Siphon (if N-7-D) into SV. Record: pH 4.2 | | | |
| | 43 | Operator Step PB | | | |
| | 44 | SP Step 24/54 — Add N-978-A & stir 15 min | 17 | 978-A | 17 |
| | 45 | Operator Step PB | | | |
| | 46 | SP Step 60 — Batch complete | | | |

| START Time | START SP Step | FINISH Time | FINISH SP Step | OPTR |
|---|---|---|---|---|
| 4:00 P | | 4:00P | | 126-201 |
| 7:00 AM | | 3:00P | | 235-222 |
| 3 P.M. | | 9:15 P.M. | | 201-22 |

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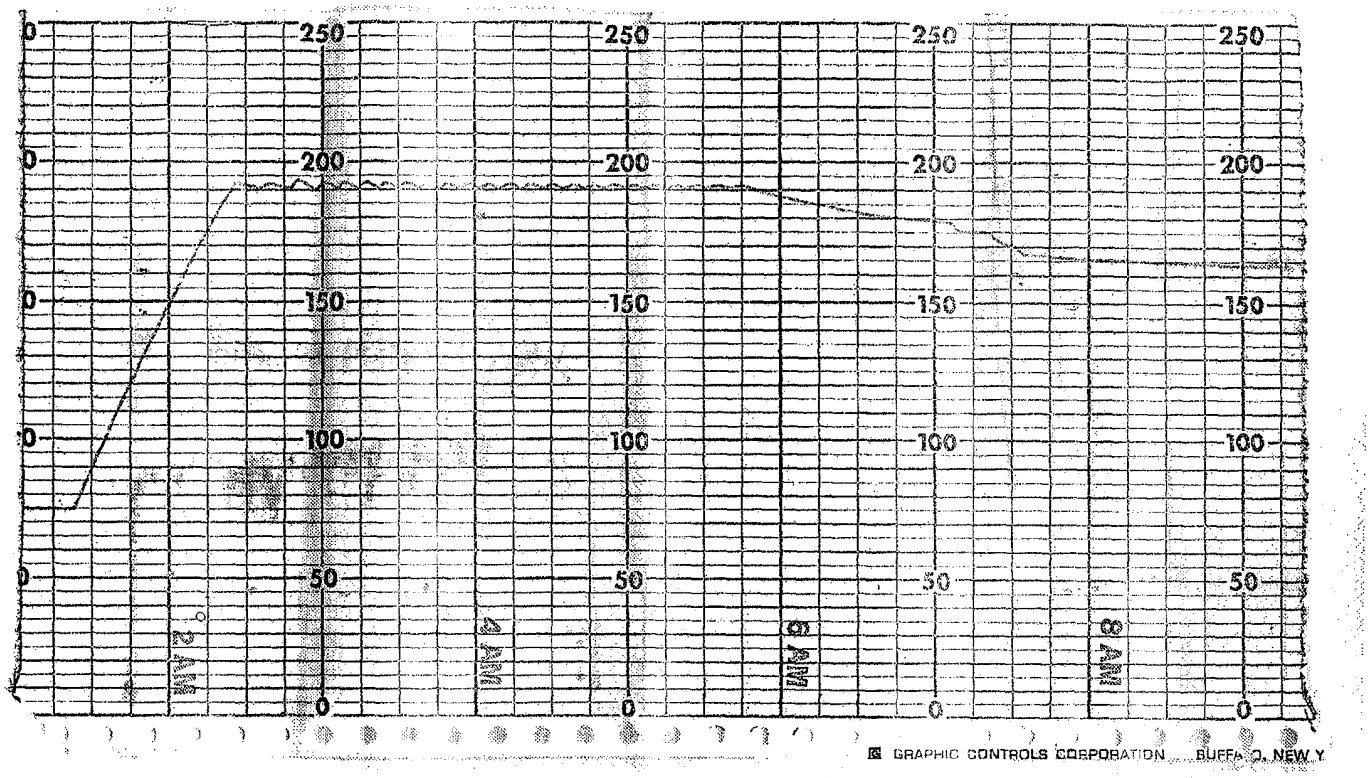
DUP050094248

V-244

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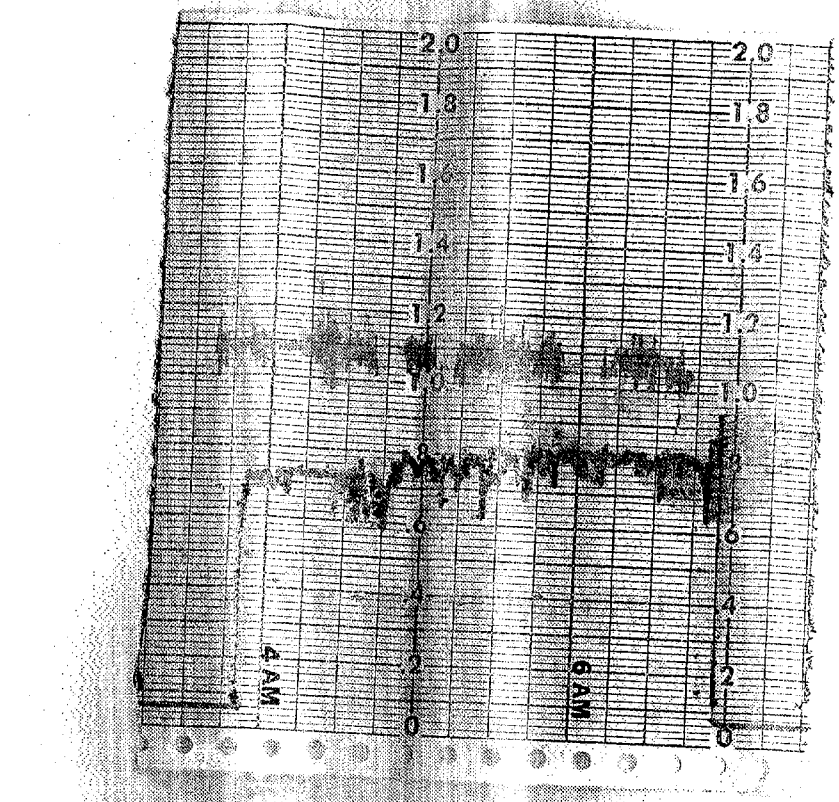


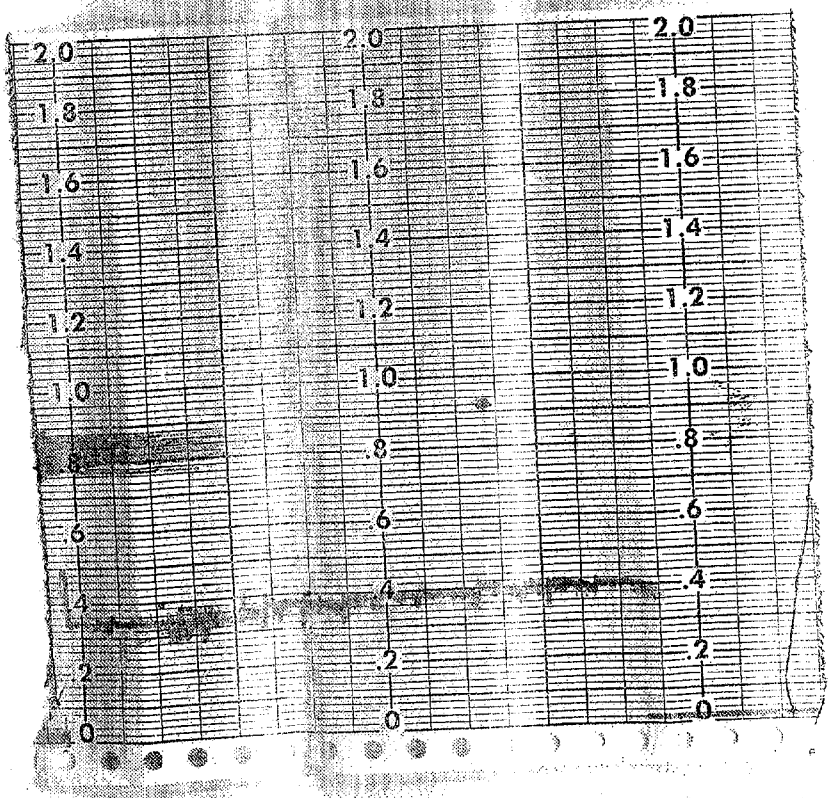


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