S.V. 240, 244 ( AUTOMATED ) DATE PRINTED: 6/25/82

CG 03 CODE KY-787-D PKG PROCESSES APPROVED BY
( ) KY-787-D (T) FWP 06/25/82

JUL 23 1982 G2J69 3404* COMTYP JOB NAME: 03KY787DMT
( DATE ) ( LOT ) ( EST WGT )

| LOCATN | CG | CODE | PQ | LOT | DRY WEIGHT | DRY CONT | NO. PKG | PKG WGT | TOTAL WEIGHT | ACTUAL USE LBS |
|---|---|---|---|---|---|---|---|---|---|---|
| | == | ====== | == | ====== | ====== | ===== | === | === | ====== | ======= |
| | 03 | YC-2 | 03 | G2B-14 | 2500 | XX.XX | | | | |
| | | | | | | XX.XX | | | | |
| | | | | | | XX.XX | | | | |
| | | | | | | XX.XX | | | | |
| | | | | | | XX.XX | | | | |

NON-BLEEDING

| EQUIP | | NAME : "KROLOR" YELLOW-MEDIUM | USE LBS | N-CODE | ACCT LBS |
|---|---|---|---|---|---|
| | | "BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF." | | | |
| 203 & 205 | 1 | RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED. | | | |
| | 2 | WEIGH IN DRUM & POUR IN | 250 | 32-D | 250 |
| | 3 | DUMP IN AND STIR 5 MIN LOT G2B.14 | 50X50 2500 | YC-2-D | 2500 |
| 1 | | RECORD: START 12:15PM FIN 12:45PM | | | |
| | 4 | ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CUASE 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 50" & 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 2:30 PM TOTAL MINUTES 150 | | | |
| 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 | JUL 27 1982 | | |
| SP & CP | 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) | | | |
| 3 | 14 | RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: | | | |
| | | A. 11LG 30 % PRESET #1 32 GAL | | 115-D | 168 |
| | | B. 13LG 22 % PRESET #6 141 GAL | | 20-A | 141 |
| | 15 | SET STRIKE FLOW CONTROLLERS AS FOLLOWS: | | | |
| | | 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM | | 27-D | 213 |
| | | 3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM | | | |
| | | 3FR10 (N-27-D/WATER) RATIO 1.31 | | | |
| | | 8FC10 (N-32-D CONTROLLER) IN MANUAL .64 GPM | | 32-D | 1425 |
| | | 8FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM | | | |
| | | 8FC20 (N-32-D WATER) IN REMOTE | | | |
| | | 8FR10 (N-32-D/WATER) RATIO 1.76 | | | |

N32745

LOT= _____ _ COMTYP JOB NAME = 03KY787DMT PAGE 02 DATE PRINTED: 6/25/82

| EQUIPMENT | | PAGE 2 CG 03 KY-787-D 240 | USE LBS | N- CODE | USE LBS |
|---|---|---|---|---|---|
| | 16 | OPERATOR STEP PB | | | |
| 320 | 17 | RECORD LEVEL 2LG 70 % IF BELOW 35% FOLLOW SOL'N | | | |
| SV | | MAKE-UP PROCEDURE FOR N-27-D | | | |
| SP | 18 | ADJUST SV TO 48" (2470 G) | | | |
| CP | 19 | RECORD PH 10.4 ADJ TO 11.1-11.3 WITH N-7-D AT | | | |
| | | 5% (10 PARTS WATER TO 1 PART N-7-D) | | | |
| 4 | | SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50% | 40 | 7-D | 20 |
| | 20 | OPERATOR STEP PB | | | |
| | 21 | SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9 | | | |
| 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 6:50 PM | | | |
| | | V-243/V-244 PH RANGE TIME | | | |
| | | 13/46 (30 MIN) 9.6 9.0-10.0 7:20 | | | |
| | | 14/47 (60 MIN) 9.7 9.0-10.0 7:50 | | | |
| | | 15/48 (2 HRS) 9.7 9.0-10.0 8:50 | | | |
| | | 16/49 (2 HRS, 25 MIN) 9.7 9.0-10.0 9:15 | | | |
| | | 17/50 (FINAL 3 HRS) 7.2 7.5- 8.5 9:50 PM | | | |
| | | 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 | WHILE STRIKING RUN 30" (234 G) WATER INTO V-339 | | | |
| | 29 | ADD IN 7-8 MIN. CHECK FOR DRAFT IN VENT STACK | 365 | 530-A | 365 |
| | | BEFORE DUMPING. | | | |
| 339 | 30 | ADJ TO 49" (382 G) AT 80-100*F | | | |
| 6 | 31 | STIR 5 MIN & RECORD: PH 9.9 (9.5-10.5) | | | |
| | 32 | STIR 15 MIN OR LONGER FOR SP STEP 26 | | | |
| | 33 | RECORD: VOL 49 " & CALC 49 " X 0.78 = 38.2 GAL | | | |
| | 34 | SET PRESET #8 TO 38.2 GAL FROM S 33 | | | |
| 385 | 35 | RUN 47" (360 G) WATER INTO V-385 | | | |
| 7 | 36 | ADD & STIR 2 MIN FOR S 40 ASSUME 50% | 160 | 7-D | 80 |
| | 37 | SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB. | | | |
| | 38 | SIFT IN | 110 | 128-A | 110 |
| SV | 39 | SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2) | | | |
| SP | 40 | RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 | | | |
| | | MIN | | | |
| 8 | 41 | RECORD: PH 9.4 (9.0-9.5). ADJ IF NECESSARY & | | | |
| | | RECORD: PH____ ASSUME 77% | ____ | 27-D | ____ |
| | | (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% | ____ | 7-D | ____ |
| | | (SIPHON N-7-D INTO SV) | | | |
| | 42 | OPERATOR STEP PB | | | |
| | 43 | SP STEP 29/58. RECORD: PH 9.2 & TIME 10:35 PM | | | |
| | 44 | OPERATOR STEP PB. | | | |
| | 45 | SP STEP 60. BATCH COMPLETE. | | | |

| | START TIME | SP STEP | FINISH TIME | SP STEP | OPTR |
|---|---|---|---|---|---|
| | 5:00 PM | _____ | ____ | _____ | 320 |

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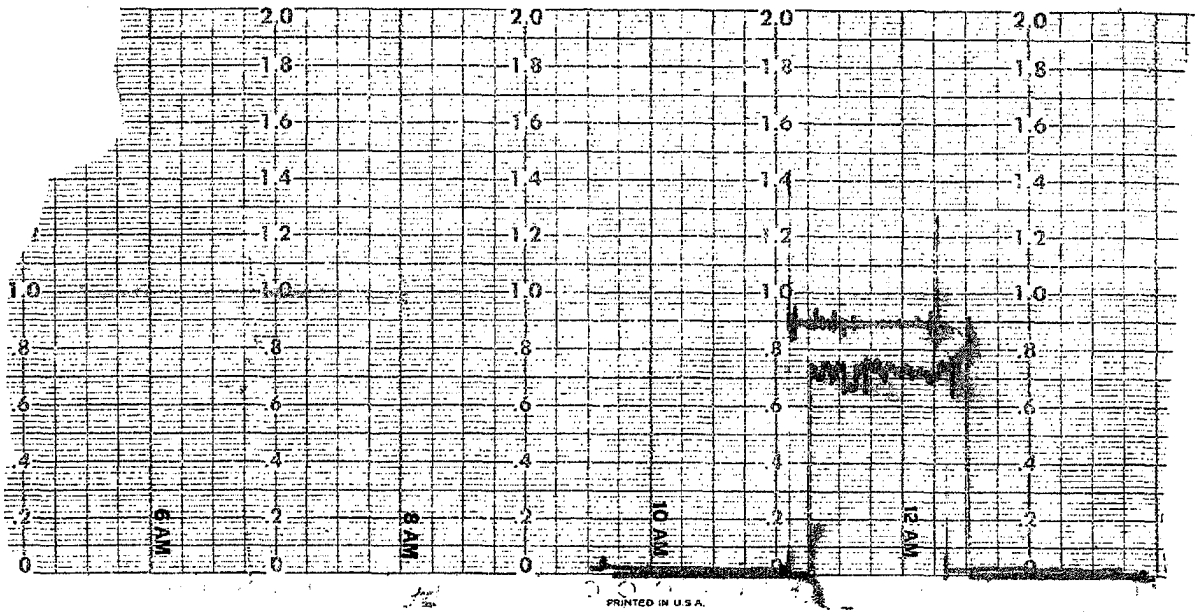


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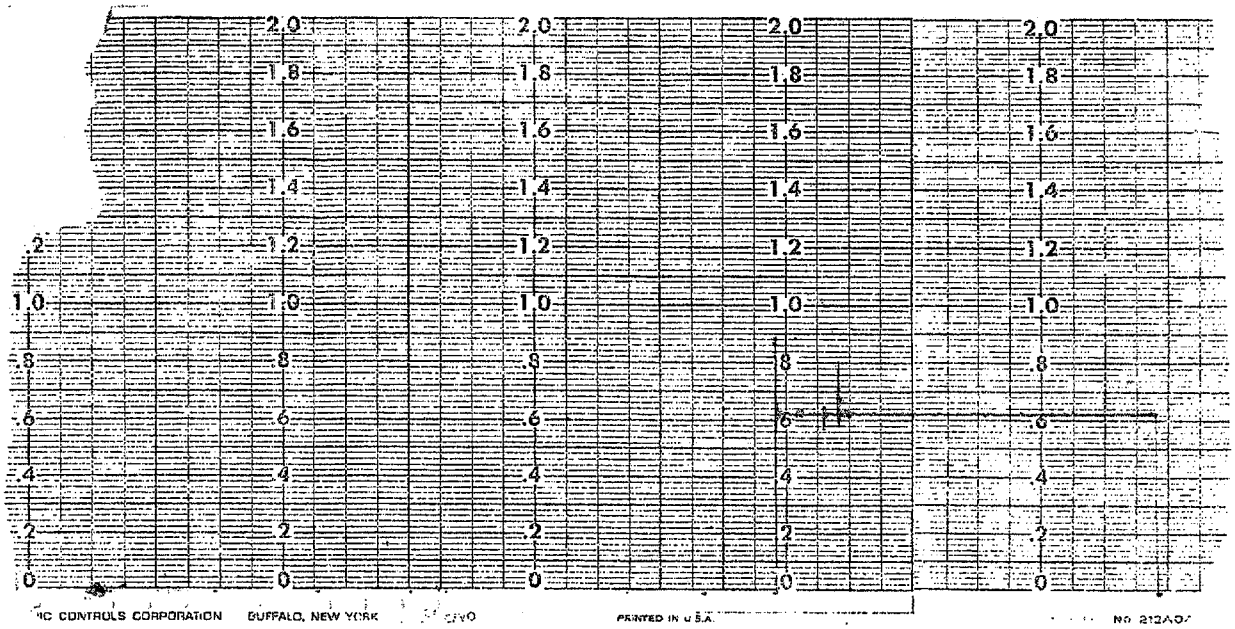


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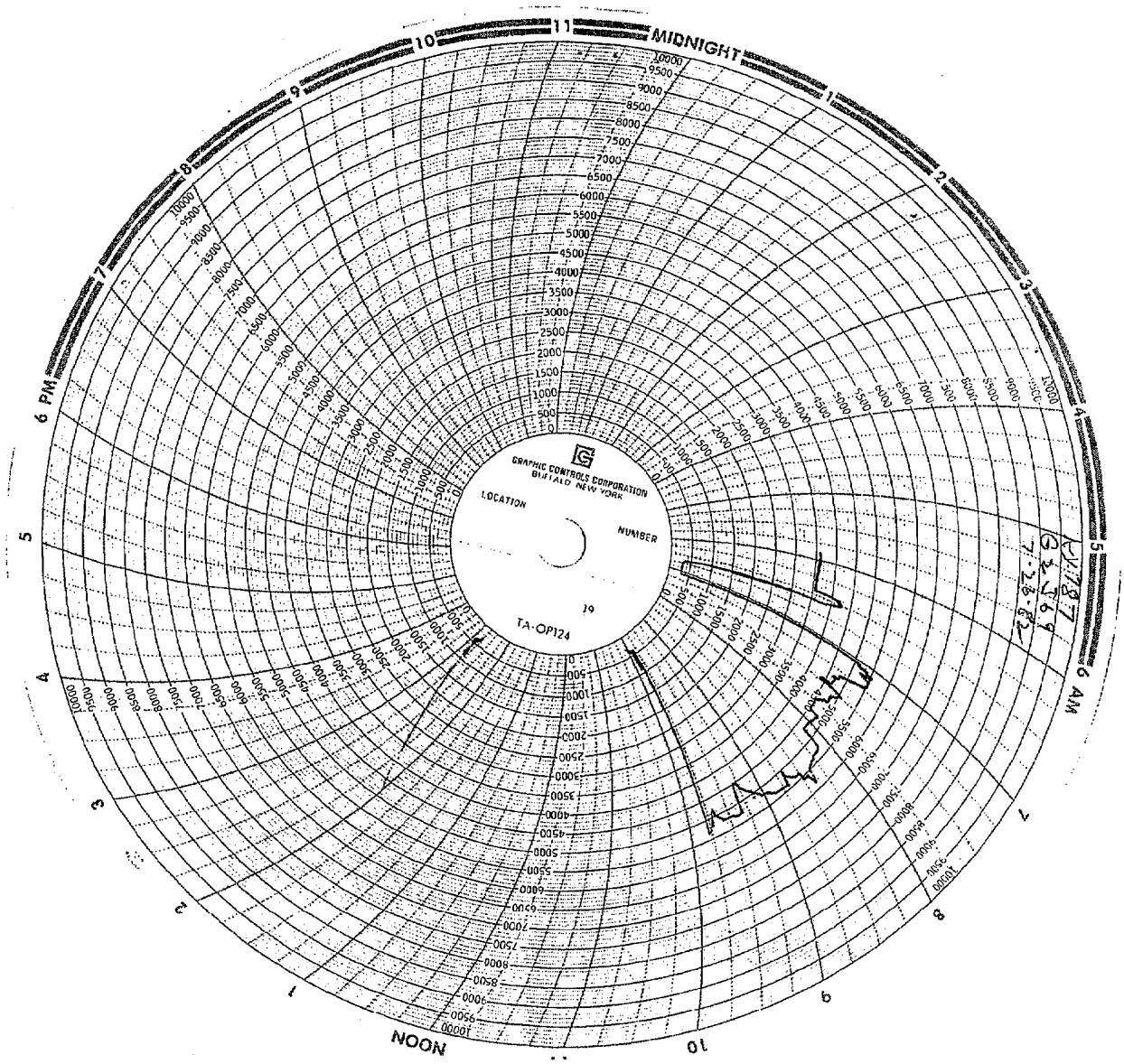


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