

CG 03 CODE KY-788-D PKG

PROCESSES

APPROVED BY

JAN 11 1982

A2H90

() KY-788-D (J) FWP 12/09/81

DATE

LOT NUMBER

STANDARD HRS. 8.8

TIME _____ M

JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	14878	93	---	14	YC-3-B	---	93	---
14	YC-3-B	14876	93	---	14	YC-3-B	---	93	---
14	YC-3-B	---	93	---	14	YC-3-B	---	93	---

DO NOT USE YC-3-B LOTS 14001 THRU 14004

TOTAL EST'D WGT 3489* LBS.

NON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	345	32-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START 8:30 A.M. 14878	2000		
	FIN 8:50 A.M. 14876	600		
263	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 43" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 12:15 A TOTAL MINUTES 130			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
14	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	12 SET STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)			
CP	12 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOVE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A 11LG 40% PRESET #2 78 GAL		115-A	416
	B 13LG 51% PRESET #6 135 GAL		20-A	135
	17 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM		27-D	180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.8			
	3FD10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM		32-D	1215
	3FD20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	3FD20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.1			

EQUIP
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PAGE 2 CG 03 KY-788-D
COMPTYP JOB NAME: 03KY788DMJ

U-243

USE
LBS

W-
CODE

ACCT
LBS

120 118 OPERATOR STEP PB
121 119 RECORD LEVEL 2LG 48% IF <35% FOLLOW SOLUTION
SV 122 MAKE-UP PROCEDURE FOR N-27-D
SP 123 ADJUST SV TO 47" (2400 G)
EP 124 RECORD PH 10.3. ADJ TO 11.0-11.2 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 125 SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50% 40 7-D 20
126 OPERATOR STEP PB

127 SP STEP 66/39. AFTER HEAT-UP RECORD: PH 9.6
SV 128 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
EP 129 OPERATOR STEP PB
130 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 131 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
132 OPERATOR STEP PB
133 DURING STRIKE RECORD: 6:00 A.M.
134 SP STEP

V-243/V-244	PH	RANGE	TIME
13/46 (30 MIN)	9.5	9.3-10.0	6:30 AM
14/47 (60 MIN)	9.4	9.3-10.0	7:00 AM
15/48 (2 HRS)	9.5	9.3-10.0	8:00 AM
16/49 (2 HRS, 25 MIN)	9.5	9.3-10.0	8:25 AM
17/50 (FINAL 3 HRS)	11.0	7.5-8.5	9:00 AM

NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE
IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.

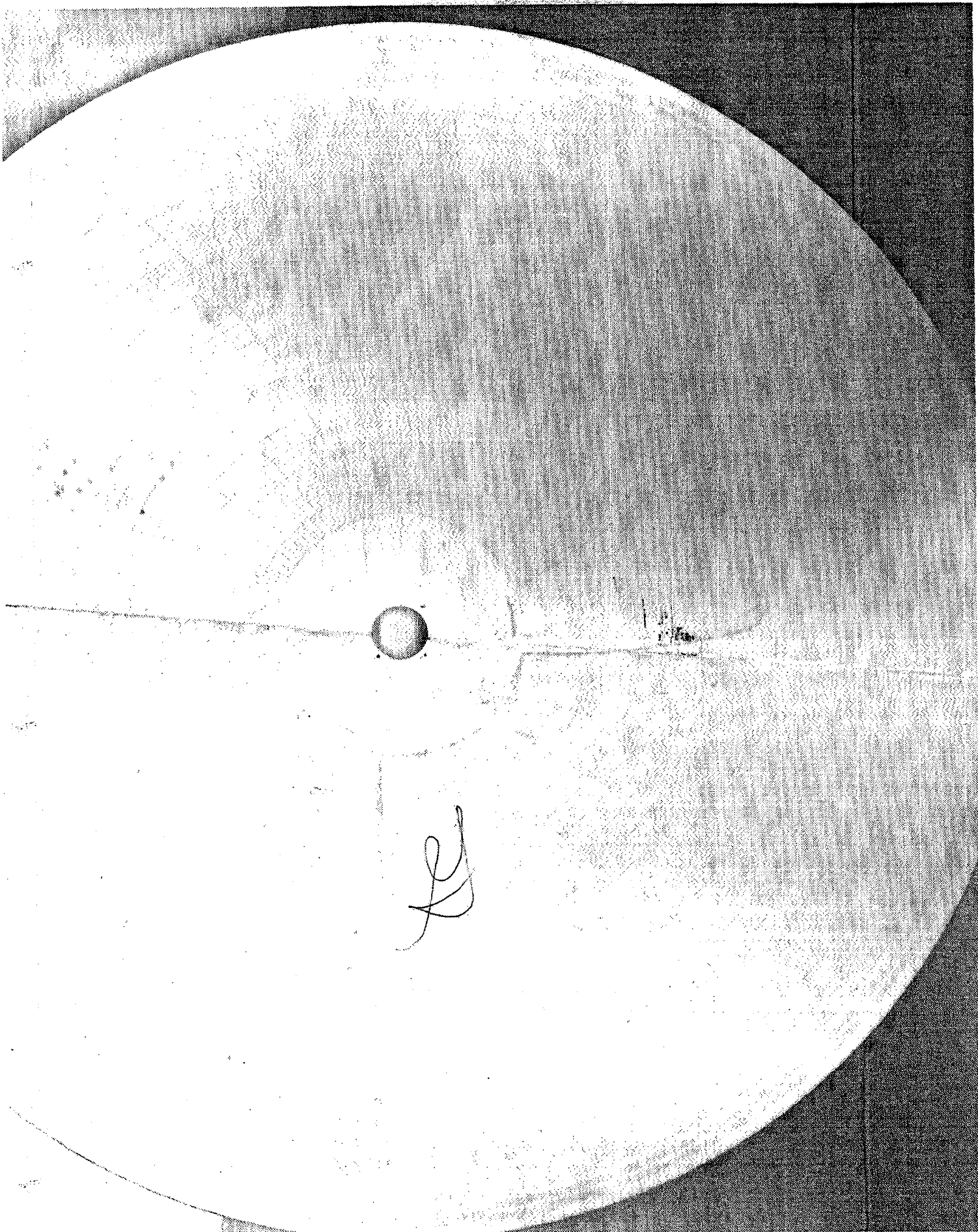
& RECORD: PH --- ASSUME 77% 27-D

128 WHIZLE STRIKING RUN 30" (234 G) WATER INTO V-339
129 ADD IN 7-8 MIN 350 530-A 350
339 130 ADJ TO 49" (382 G) AT 80-100°F
6 131 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
132 STIR 15 MIN OR LONGER FOR SP STEP 26/56
133 RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL
134 SET PRESET #8 TO 38.2 GAL FROM S 33

385 135 RUN 57" (440 G) WATER INTO V-385
7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 360 7-D 180

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
138 SIFT IN 100 128-A 100
SV 139 SP STEP 23/53. RECORD: PH 3.0 (3.7-4.2)
SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
9 141 RECORD: PH 8.5 (9.0-9.5). ADJ IF NECESSARY &
RECORD: PH 7.4 ASSUME 77%
(DILUTE 10 PARTS WATER TO 1 PART). ASSUME 50% 40 27-D 20
(SIPHON N-7-D INTO SV)
142 OPERATOR STEP PB
143 SP STEP 29. RECORD: PH 9.1 & TIME 10:55 AM
144 OPERATOR STEP PB
145 SP STEP 60. BATCH COMPLETE.

START TIME SP STEP	FINISH TIME SP STEP	OPTR
11:00 AM	1:00 AM	382223
7:00 AM	12:30 PM	320



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