S.V. 243 244 (AUTOMATED) DATE PRINTED: 3/26/82

CG 03 CODE KY-908-D PKG

MAY 28 1982 DATE

F2H72 LOT NUMBER

PROCESSES
( ) KY-908-D (G)
( ) ( )
( ) ( )
( ) ( )

APPROVED BY
FWP 03/26/82

STANDARD HRS. TIME _____ M JOB NAME: 03KY908DMG

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	14858	93	2000	14	YC-3-B		93	
14	YC-3-B	14224	93	1150	14	YC-3-B		93	
14	YC-3-B		93		14	YC-3-B		93	

EST. WT. 4221* LBS. NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW-LIGHT	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	420	32-D	420
	3	DUMP IN AND STIR 5 MIN LOT	63X50	YC-3-B	3150
		RECORD: START 8:30PM 14858	2000		
1		FIN 9:45PM 14224	1150		
	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 60" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY	JUN 7 1982		
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 2:20P TOTAL MINUTES 120			
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 & 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 76 % PRESET #2 95 GAL		115-D	504
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) 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			

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EQUIPMENT		PAGE 2 CG 03 KY-908-D COMTYP JOB NAME: 03KY908DMG V-243	USE LBS	N-CODE	ACCT LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 68% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 47* (2400 G)			
CP	19	RECORD PH 10.6. ADJ TO 11.0-11.2 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.1. ASSUME 50%	60	7-D	30
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5			
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			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.5 9.3-10.0 8:35P			
		14/47 (60 MIN) 9.4 9.3-10.0 9:05P			
		15/48 (2 HRS) 9.3 9.3-10.0 10:05P			
		16/49 (2 HRS, 25 MIN) 9.3 9.3-10.0 10:30P			
		17/50 (FINAL 3 HRS) 9.1 7.5-8.5 11:05P			
		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	SIFT IN	50	128-A	50
385	29	ADD 42* (320 G) WATER TO V-385			
6	30	ADD & STIR FOR 2 MIN FOR S 57 (3.0) ASSUME 50%	260	7-D	130
	31	DURING STRIKE CHECK LEVEL IN V-387.			
387	32	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	33	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	34	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			
	35	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	36	TURN ON STEAM & AGITATOR			
8	37	ADJUST TO 32*-(317 GAL) AT 178-182*F			
	38	SET BADGER METER FOR 466#			
	39	PUMP IN FROM V-387 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE	378 44 44	169-A 155-A 160-A	378 44 44
	40	SHUT OFF PUMP			
	41	STIR 30 MIN AT 178-182*F FOR S 48			
	42	DO NOT SHUT OFF AGITATOR			

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EQUIPMENT		PAGE 3 CG 03 KY-908-D JOB NAME: 03KY908DMG	USE LBS	N-CODE	ACCT LBS
SV & SP 9	43	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN			
	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 3.0 (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 4.2 (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH____. 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 TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPERATOR
3:00 PM	_____	11:00 PM	_____	237
_____	_____	_____	_____	_____
_____	_____	_____	_____	_____

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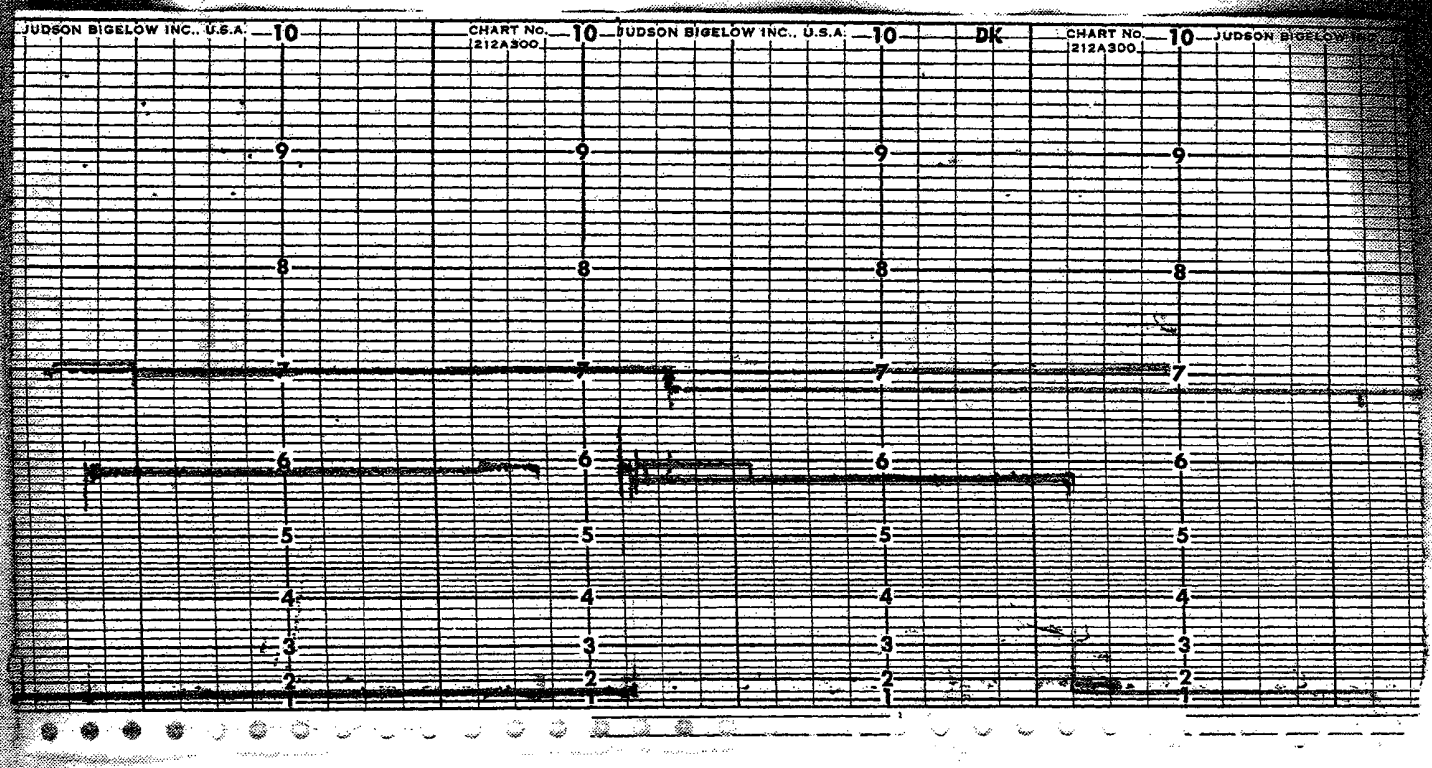

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12 AM
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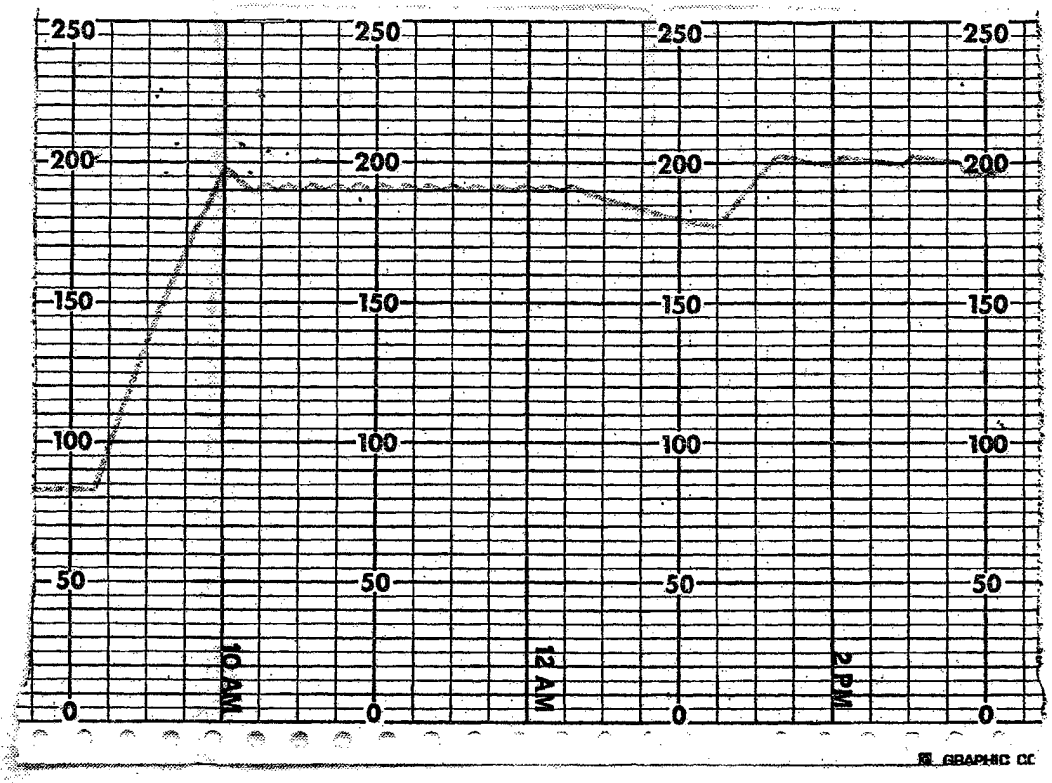

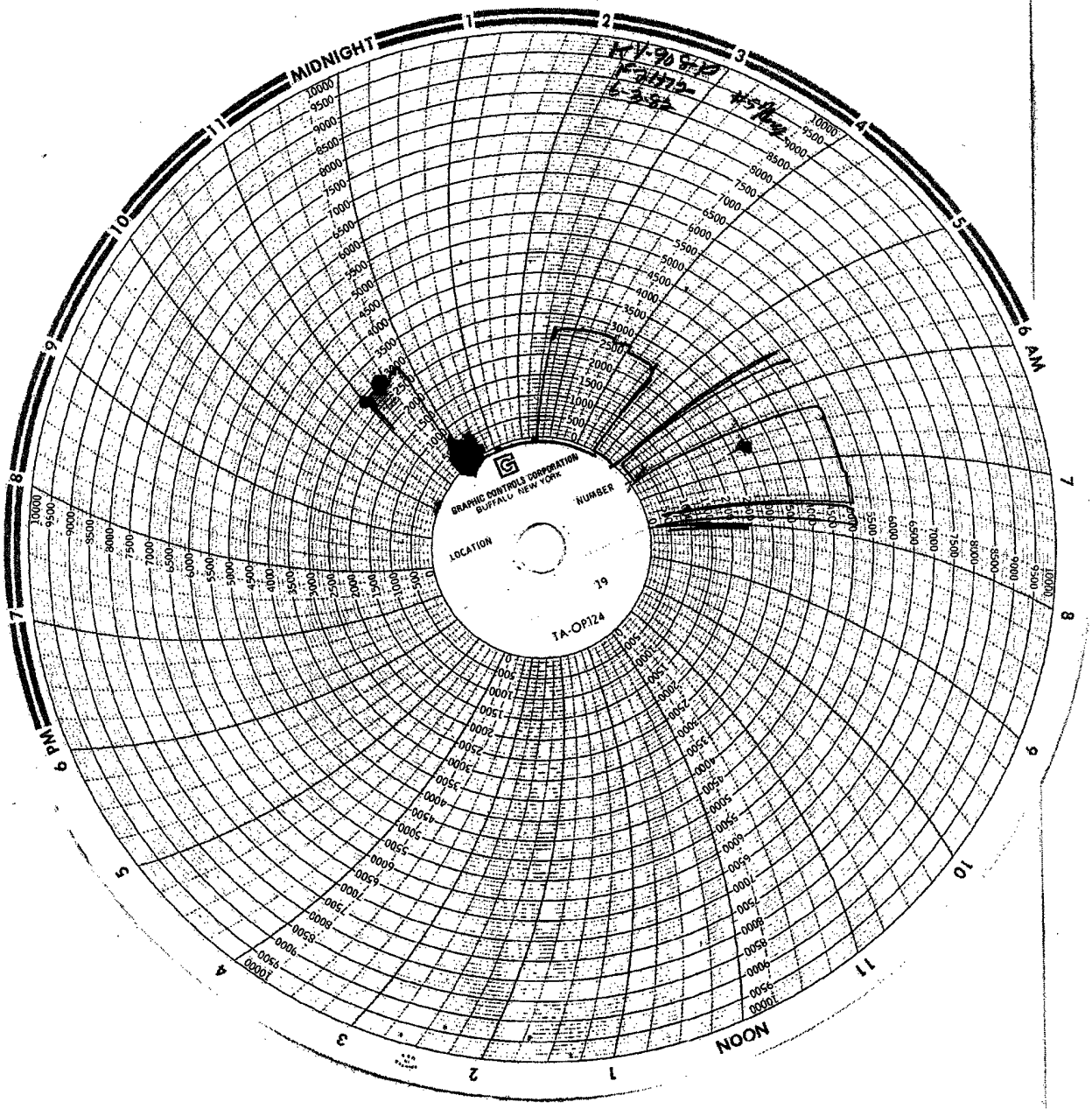

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