

JUN 23, 1982

F2L35 4780*
(LOT) (EST WGT)

COMTYP JOB NAME: 03KY907DMH
TYPED BY:

STANDARD HRS. 8.9 TIME M

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	14	YC-2	93	F2E19	2000					
	14	YC-2	93	F2E20	1550					
	14	YC-2	93							
	14	YC-2	93							

EQUIP MENT		NON-BLEEDING			
		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	1	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2	WEIGH IN DRUM & POUR IN	355	32-D	355
	3	DUMP IN AND STIR 5 MIN	71X50	YC-2-B	3550
		RECORD: START 3:15 PM LOT F2E19	2000		
		FIN 4:30 PM F2E20	1550		
	4	ADJUST TO 75" (1275 G)			
	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 58" & 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 10:15 TOTAL MINUTES 200			
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 6 (V-243) OR POSITION 6 (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 52% PRESET #3 45 GAL		115-D	239
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.73 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 9.56 GPM 3FR10 (N-27-D/WATER) RATIO 1.31 BFC10 (N-32-D CONTROLLER) IN MANUAL .96 GPM BFC20 (N-32-D WATER) IN MANUAL LOCAL 8.45 GPM BFR10 (N-32-D/WATER) RATIO 1.76		27-D 32-D	302 2022

JUN 25 1982

6/24

EQUIP MENT		PAGE 2 CG 03 KY-907-D <i>✓-243</i>	USE LBS	N- CODE	ACCT LBS
320	116	OPERATOR STEP PB			
SV	117	RECORD LEVEL 2LG <i>52%</i> IF BELOW 35% FOLLOW SOL'N			
SP	118	MAKE-UP PROCEDURE FOR N-27-D			
CP	119	ADJUST SV TO 48" (2470 G)			
	120	RECORD PH <i>28</i> . 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 <i>4.1</i> ASSUME 50%	<i>50</i>	7-D	<i>25</i>
	120	OPERATOR STEP PB			
SV	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <i>9.7</i>			
SP	122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	123	OPERATOR STEP PB			
	124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	125	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	126	OPERATOR STEP PB			
	127	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) <i>9.4</i> 9.0-10.0 <i>4:50</i>			
		14/47 (60 MIN) <i>9.4</i> 9.0-10.0 <i>5:20</i>			
		15/48 (2 HRS) <i>9.4</i> 9.0-10.0 <i>6:20</i>			
		16/49 (3 HRS) <i>9.4</i> 9.0-10.0 <i>7:20</i>			
		17/50 (FINAL) <i>8.2</i> 7.5-8.5 <i>8:05 AM</i>			
		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	SIFT IN	<i>55</i>	27-D 128-A	55
385	129	ADD 27" (208 G) WATER TO V-385			
6	130	ADD & STIR FOR 2 MIN FOR S 57. ASSUME 50%	90	7-D	45
	131	DURING STRIKE CHECK LEVEL IN V-387.			
387	132	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	133	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING			
		THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	134	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW			
		STEARATE MAKE-UP PROCEDURE.			
	135	RUN IN 32" (317 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	136	TURN ON STEAM & AGITATOR			
8	137	ADJUST TO 42" (403 GAL) AT 178-182°F			
	138	SET BADGER METER FOR <i>550</i>			
	139	PUMP IN FROM V-387 THRU UNDERSURFACE	450	169-A	450
		DISTRIBUTORS AS FAST AS POSSIBLE	50	155-A	50
			50	160-A	50
	140	SHUT OFF PUMP			
	141	STIR 30 MIN AT 178-182°F FOR S 48			
	142	DO NOT SHUT OFF AGITATOR			

EQUIP MENT		PAGE 3 CG 03 KY-907-D	243	USE LBS	N- CODE	ACCT LBS
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				
9		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				
SV	47	WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG				
&		DISCHARGE VALVE TO SV AND CLOSE VALVE TO				
SP		SEWER				
9	48	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,				
CONT		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 & STERATE 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>3.2</u> (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 <u>4.4</u> (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	FINISH	OPERATOR		
		TIME SP STEP	TIME SP STEP			
		7 AM	10 A	120		

