

CG 03

CODE KY-787-D

PKG

PROCESSES

APPROVED BY:

10/6/82

K2J35

(EST WGT)

() KY-787-D (T)

FWP 09/27/82

COMTYP JOB NAME: 03KY787DMT

(DATE)

(LOT)

3444

7A

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
				120229		100.00	40	50	2000	
				120333		100.00	10	50	500	
						100.00				

BLEND BACK FOR STEP 43: KY-787-D, 62099, 150 # ON 6-3 OR GET FROM R/M.

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
	NOT FOR V-203 NAME: "KROLOR" YELLOW-MEDIUM			
203	"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF".			
205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN (SODIUM SILICATE)	250	32-D	250
	3 DUMP IN AND STIR 5 MIN (CHROME YELLOW MEDIUM)	50X50	YC-2-B	2500
	RECORD: START 1:00 AM LOT 120229	2000		
	FIN 2:00 PM 120333	500		
	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 51" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 10:15 AM TOTAL MINUTES 100			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	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		
&	2	(V-243) OR POSITION 7 (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 64% PRESET #1 32 GAL (LIQUID ALUM)	115-D	168
		B. 13LG 12% PRESET #6 141 GAL (CALCIUM CHLORIDE 77Z)	29-A	141
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:		
		3FC10 (N-27-D -SULFURIC ACID 60%- CONTROLLER)	27-D	213
		IN MANUAL 0.64 GPM		
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM		
		3FR10 (N-27-D/WATER) RATIO 1.31		
		3EC10 (N-32-D CONTROLLER) IN MANUAL 0.84 GPM	32-D	1423
		3FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM		
		3FC20 (N-32-D WATER) IN REMOTE		
		3FR10 (N-32-D/WATER) RATIO 1.76		
	16	OPERATOR STEP PB		

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EQUIP PAGE 2 CG 03 KY-787-D USE N- USE
MENTI LBS CODE LBS

320 17 RECORD LEVEL 2LG 80 % IF BELOW 35% FOLLOW SOLN
SV MAKE-UP PROCEDURE FOR N-27-D
SP 18 ADJUST SV TO 48" (2470 G)
CP 47 RECORD PH 9.0. ADJ TO 11.1-11.3 WITH N-7-D
(CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1
4 PART N-7-D)
4 SIPHON INTO SV. RECORD: PH 11.1. ASSUME 50% 50 7-D 25
20 OPERATOR STEP PB

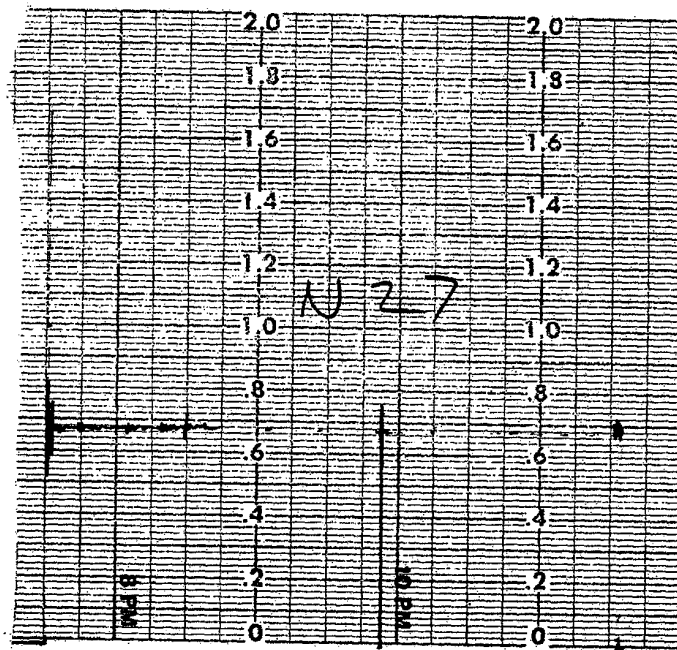
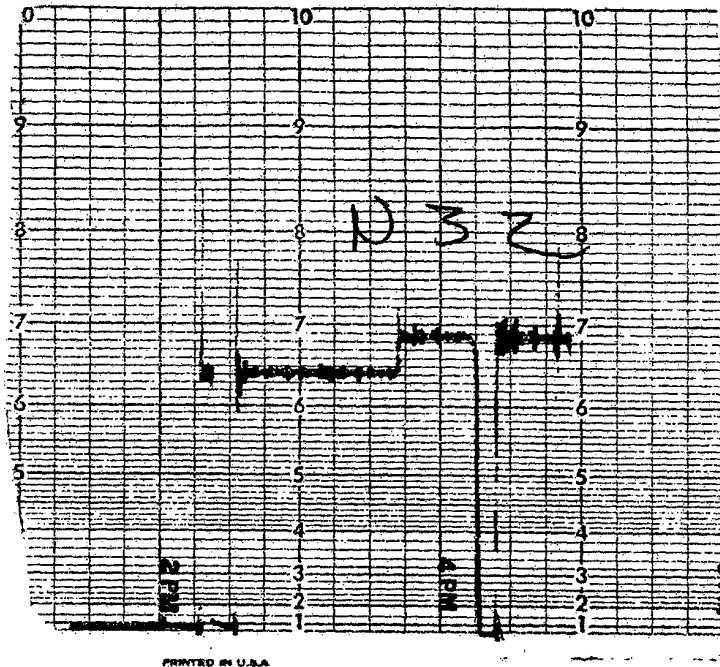
121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.6
SV 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 123 OPERATOR STEP PB
124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
126 OPERATOR STEP PB
127 DURING STRIKE RECORD: 2:05 PM
SP STEP
V-243/V-244
PH RANGE TIME
13/46 (30 MIN) 2:31 PM 9.0-10.0 9.3
14/47 (60 MIN) 3:05 PM 9.0-10.0 9.1
15/48 (2 HRS) 4:05 PM 9.0-10.0 9.1
16/49 (2 HRS, 25 MIN) 4:30 PM 9.0-10.0 9.0
17/50 (FINAL 3 HRS) 5:05 PM 7.5- 8.5 7.5
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 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
29 ADD IN 7-8 MIN. (DRESINATE X) CHECK FOR DRAFT 365 530-A 365
IN VENT STACK BEFORE DUMPING.
339 129 ADJ TO 49" (382 G) AT 80-100*F
6 130 STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)
131 STIR 15 MIN OR LONGER FOR SP STEP 26
132 RECORD: VOL 49 * & CALC 49 * X 0.78 = 38.2 GAL
133 SET PRESET #8 TO 38.2 GAL FROM S 33

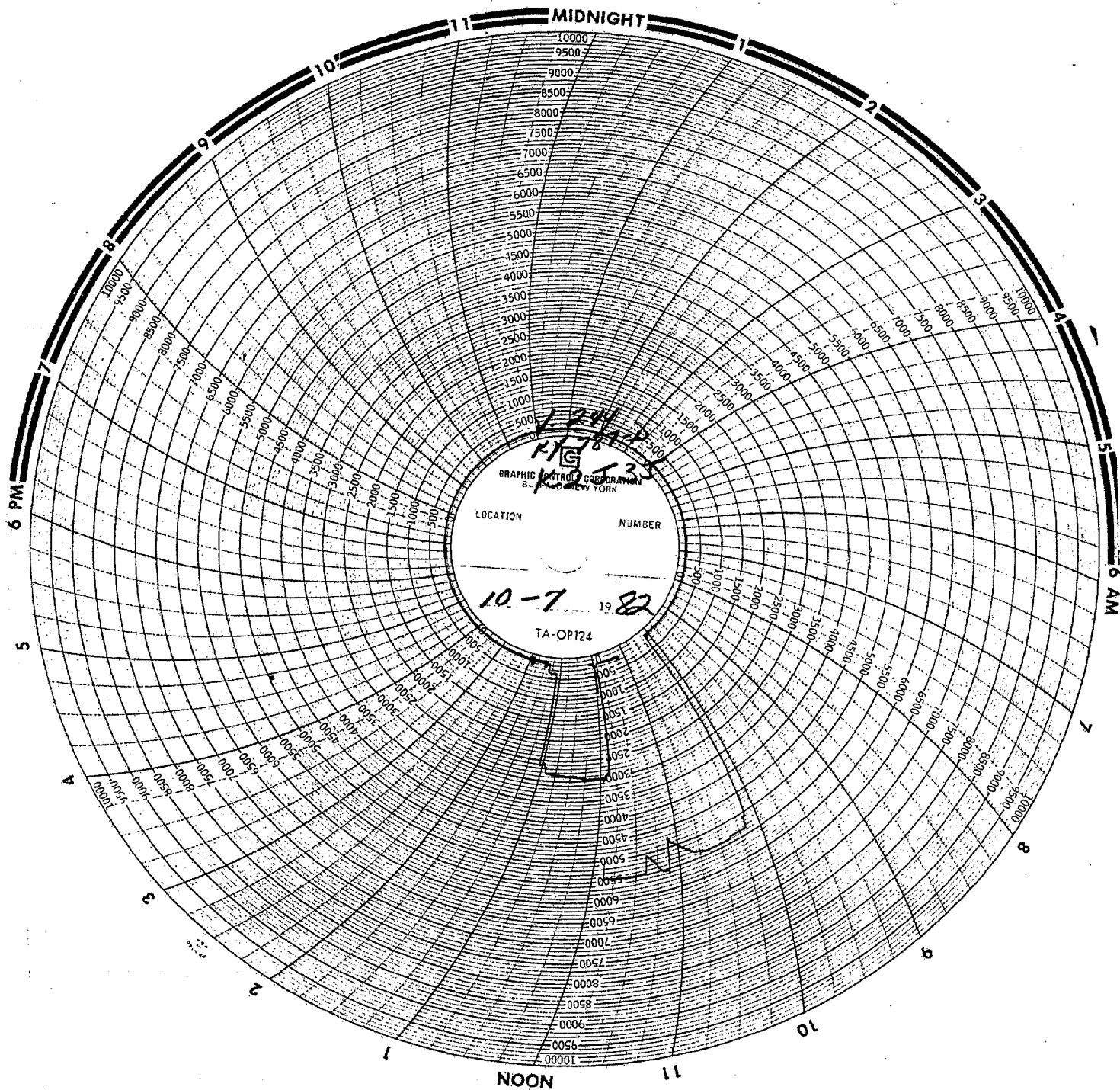
385 135 RUN 47" (360 G) WATER INTO V-385
7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
138 STET IN (BLANC FIXE N) 110 128-A 110
SV 139 SP STEP 23/53. RECORD: PH 3.6 (3.7-4.2)
SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
8 141 RECORD: PH 9.2 (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)
142 OPERATOR STEP PB
143 SIFT IN BLEND BACK: KY-787-D, 92599, 150
144 SP STEP 29/58. RECORD: PH 9.2 & TIME 6:14 PM
145 OPERATOR STEP PB
146 SP STEP 60. BATCH COMPLETE. 6-1 202

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>7:14 PM</u>	<u>3:02 PM</u>	<u>114</u>



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DUP050102825