

OCT 29 1982

L2H85

4226*

() KY-908-D (G) FWP 10/05/82

("DATE")

("LOT")

("EST WGT")

COMTYP JOB NAME: 03KY908DMG

STANDARD HRS.

TIME _____ M

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	14	YC-3	93	J2B08	2000					
	14	YC-3	93	K2B04	1150					
	14	YC-3	93							
	14	YC-3	93							

EQUIP MENT		NON-BLEEDING				
		NAME :	USE LBS	N- CODE	ACCT LBS	
		"KROLOR" YELLOW-LIGHT				
203	1	BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF.				
205	2	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.				
1	3	WEIGH IN DRUM & POUR IN (SODIUM SILICATE)	420	32-D	420	
		DUMP IN AND STIR 5 MIN (CHROME YELLOW)	63X50	YC-3-B	3150	
		RECORD: START 11:50 PM LOT J2B08	2000			
		FIN 12:45 K2B04	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 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.				
2		RECORD: TIME START 7 PM TOTAL MINUTES 90				
		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				
&		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 21% PRESET #2 95 GAL				
		(LIQUID ALUM)				
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:				
		3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%)				
		IN MANUAL 0.65 GPM				
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.2 GPM				
		3PR10 (N-27-D/WATER) RATIO 0.8				
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.87 GPM				
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.8 GPM				
		8FC20 (N-32-D WATER) IN REMOTE				
		8PR10 (N-32-D/WATER) RATIO 1.1				

NOV 2 1982

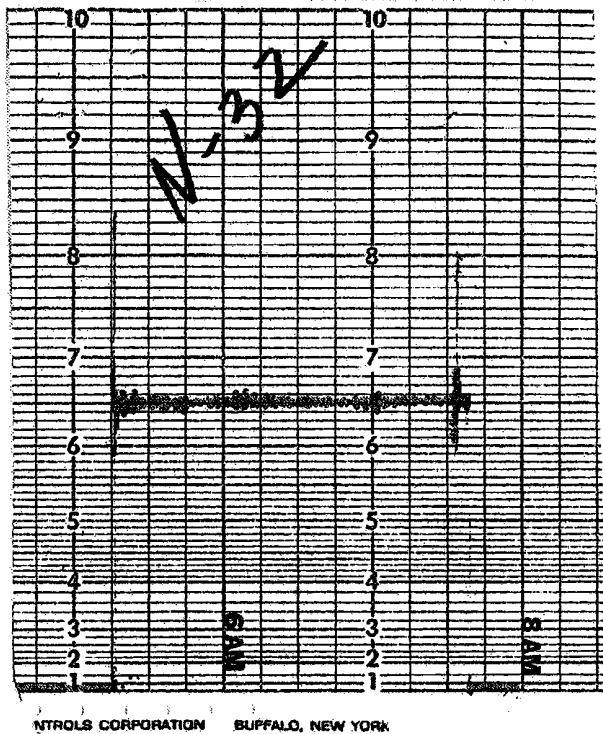
115-D 504

27-D 218

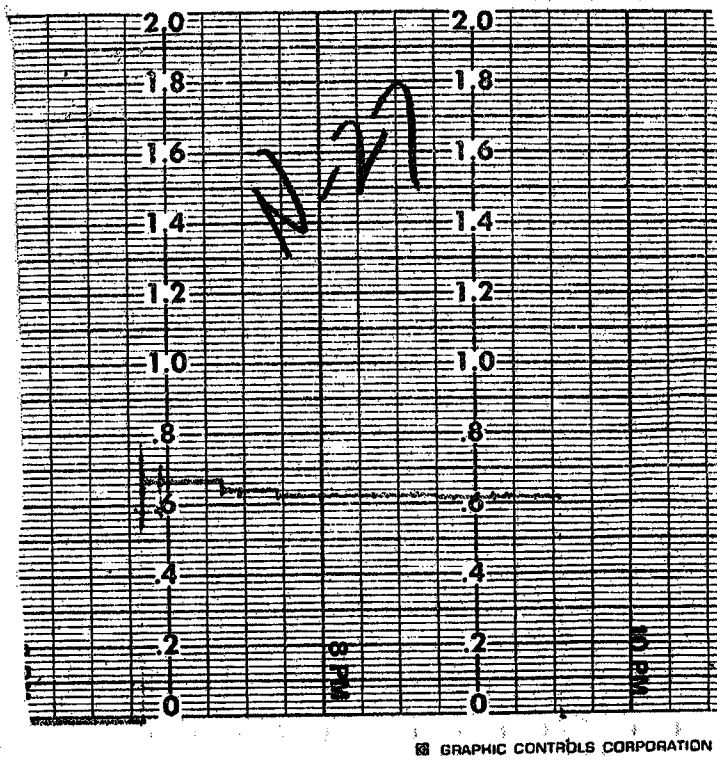
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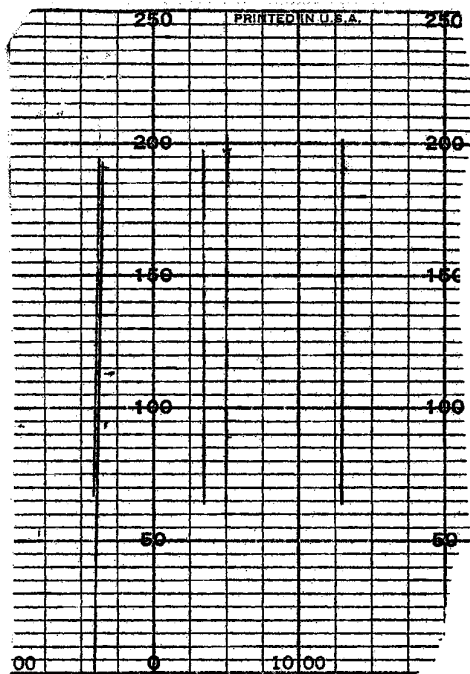
EQUIP MENT	PAGE 2 CG 03 KY-908-D	V-240	USE LBS	N- CODE	ACCT. LBS
320	16 OPERATOR STEP PB				
SV	17 RECORD LEVEL 2LG 50% IF (35% FOLLOW SOLUTION				
SP	18 MAKE-UP PROCEDURE FOR N-27-D				
CP	19 ADJUST SV TO 47" (2400 G)				
	20 RECORD PH 9.5. ADJ TO 11.0-11.2 WITH N-7-D				
	(CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1				
	PART N-7-D)				
4	21 SIPHON INTO SV. RECORD: PH 11.3. ASSUME 50%		50	7-D	25
	22 OPERATOR STEP PB				
SV	23 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7.				
SP	24 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
	25 OPERATOR STEP PB				
5	26 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS				
	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB				
	27 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN				
	LIMITS, SWITCH 3FC20 TO REMOTE				
	28 OPERATOR STEP PB				
	29 DURING STRIKE RECORD: 11:30				
	SP STEP				
	V-243/V-244				
	13/46 (30 MIN)	PH 9.35	RANGE 9.3-10.0	TIME 12:06	
	14/47 (60 MIN)	9.3	9.3-10.0	12:35	
	15/48 (2 HRS)	9.3	9.3-10.0	1:35	
	16/49 (2 HRS, 25 MIN)	9.3	9.3-10.0	2:00	
	17/50 (FINAL 3 HRS)	8.0	7.5-8.5	2:35	
	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%				
	30 SIFT IN (BLANC FIXE N)		55	27-D 128-A	55
385	31 ADD 42" (320 G) WATER TO V-385				
6	32 ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%		260	7-D	130
	33 DURING STRIKE CHECK LEVEL IN V-387.				
387	34 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35				
7	35 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING				
	THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE				
	36 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW				
	STEARATE MAKE-UP PROCEDURE.				
	37 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	38 TURN ON STEAM & AGITATOR				
8	39 ADJUST TO 32" (317 GAL) AT 178-182°F				
	40 SET BADGER METER FOR 466#				
	41 PUMP IN FROM V-387 THRU UNDERSRFECE DISTRIBUTORS	378	169-A	378	
	AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL	44	155-A	44	
	STEARATE, EMCOL P-10-59)	44	160-A	44	
	42 SHUT OFF PUMP				
	43 STIR 30 MIN AT 178-182°F FOR S 48				
	44 DO NOT SHUT OFF AGITATOR				

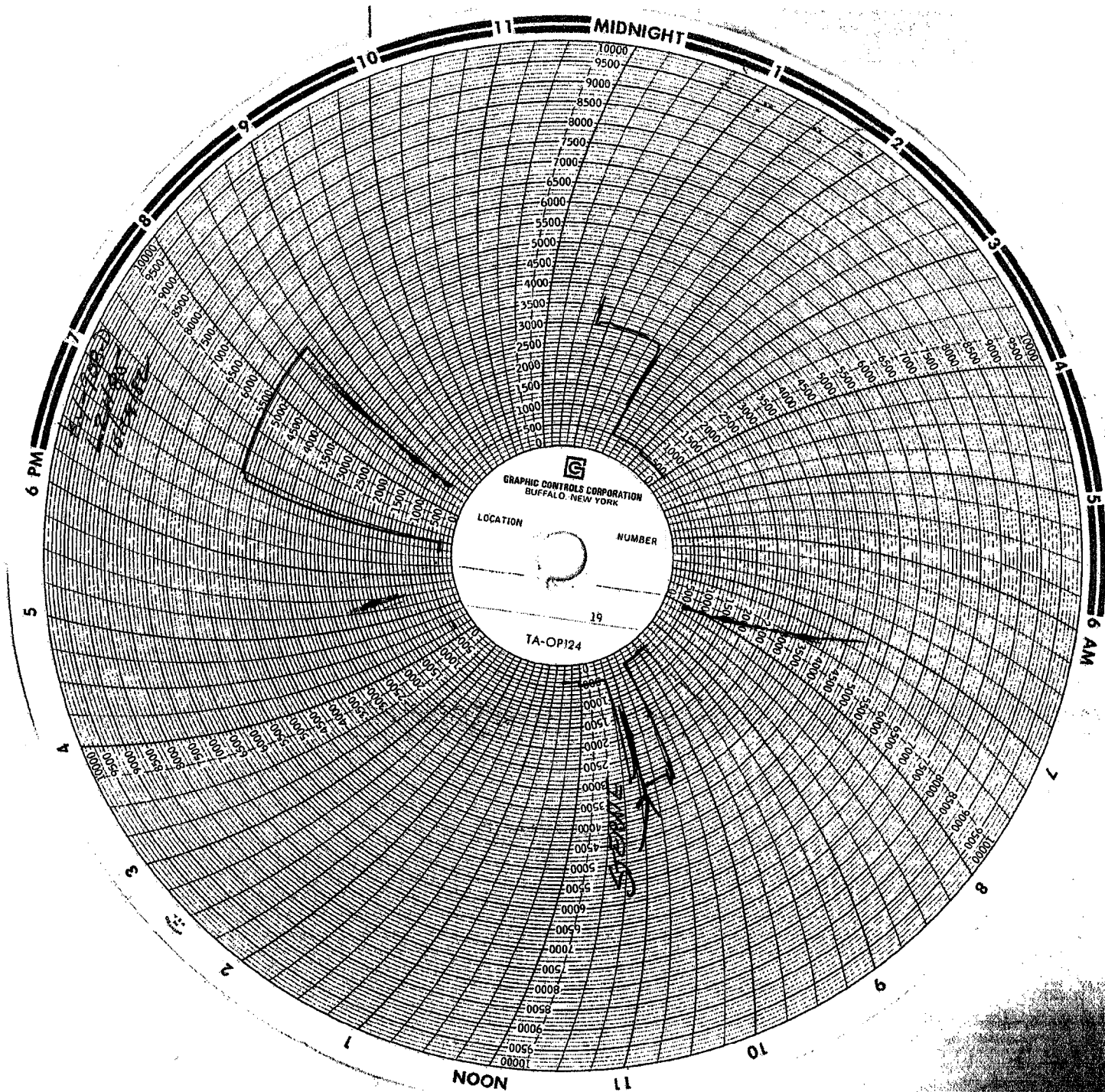
EQUIP MENT	PAGE 3 CG 03 KY-908-D	USE LBS	N- CODE	ACCT LBS												
SV-13	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN.															
SP-14	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP															
9-15	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET															
146	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI, TO SEWER															
147	WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG DISCHARGE VALVE TO SV AND CLOSE VALVE TO SEWER															
148	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.															
149	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP															
150	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER															
151	WHEN S50 COMPLETE TURN OFF HOMOG & STEARATE PUMP															
152	STIR 5 MIN AT 198-200°F															
153	SHUT OFF STEAM															
154	WHEN S53 COMPLETE, OPERATOR PB															
155	SP STEP 23/53 RECORD PH <u>3.7</u> (3.3-3.7)															
156	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													
157	RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN															
158	RECORD: PH <u>4.3</u> (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH <u>4.4</u> . ASSUME 50% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%		7-D													
	SIPHON N-7-D INTO SV	<u>30</u>	27-D													
159	OPERATOR STEP PB															
160	OPERATOR STEP PB															
161	SP STEP 60 - BATCH COMPLETE															
<table border="0" style="width: 100%;"> <tr> <td style="text-align: center;">START</td> <td style="text-align: center;">FINISH</td> <td style="text-align: center;">OPERATOR</td> </tr> <tr> <td>TIME SP STEP</td> <td>TIME SP STEP</td> <td></td> </tr> <tr> <td><u>7:PM</u></td> <td><u>11:PM</u></td> <td><u>54</u></td> </tr> <tr> <td><u>11:00 PM</u></td> <td><u>4:30 AM</u></td> <td><u>409-438</u></td> </tr> </table>					START	FINISH	OPERATOR	TIME SP STEP	TIME SP STEP		<u>7:PM</u>	<u>11:PM</u>	<u>54</u>	<u>11:00 PM</u>	<u>4:30 AM</u>	<u>409-438</u>
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NTROLS CORPORATION BUFFALO, NEW YORK







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V-240