

CG 03 CODE KY-908-D PKG PROCESSES APPROVED BY
MAY 26 1982 *F2H66* * *OK* () KY-908-D (G) FWP 03/26/82
 DATE LOT NUMBER () ()
 () ()
 () ()
 STANDARD HRS. TIME _____ M JOB NAME: 03KY908DMG

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	<i>22216</i>	93	<i>2000</i>	14	YC-3-B		93	
14	YC-3-B	<i>22227</i>	93	<i>1150</i>	14	YC-3-B		93	
14	YC-3-B		93	<i>3150</i>	14	YC-3-B		93	

EST. WT. 4221* LBS.

NOTE YC-3

NON-BLEEDING

EQUIP	NAME	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	63X50	YC-3-B	3150
	RECORD: START <i>7:20</i> <i>22216</i>	<i>2000</i>		
	FIN <i>10:00</i> <i>22227</i>	<i>1150</i>		
	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 <i>42</i> & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V- 203 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <i>11:30 PM</i> TOTAL MINUTES <i>250</i>			
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 <u>7 (V-244)</u>			
	13 PRESS SV CAM RESET PB - SET 22 TO IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG <i>40</i> % PRESET #2 95 GAL		115-D	504
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: SEC10 (N-27-D CONTROLLER) IN MANUAL 0.65 GPM SEC20 (N-27-D WATER) IN MANUAL LOCAL 5.2 GPM SEC10 (N-27-D/WATER) RATIO 0.8 SEC10 (N-32-D CONTROLLER) IN MANUAL 0.87 GPM SEC20 (N-32-D WATER) IN MANUAL LOCAL 4.8 GPM SEC20 (N-32-D WATER) IN REMOTE SEC10 (N-32-D/WATER) RATIO 1.1		27-D	218
			32-D	1476

JUN 4 1982

LOT

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EQUIP	PAGE 2	CG 03	KY-908-D	USE	N-	ACCT
MENTI	COMTYP	JOB NAME:	03KY908DMG	LBS	CODE	LBS
320	117	OPERATOR STEP PB				
SV	118	RECORD LEVEL 2LG 75% IF (35% FOLLOW SOLUTION				
SP	119	MAKE-UP PROCEDURE FOR N-27-D				
CP	120	ADJUST SV TO 47" (2400 G)				
4	121	RECORD PH 9.2- ADJ TO 11.0-11.2 WITH N-7-D AT				
	122	5% (10 PARTS WATER TO 1 PART N-7-D)				
	123	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	60	7-D	30	
	124	OPERATOR STEP PB				
SV	125	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5				
SP	126	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
	127	OPERATOR STEP PB				
5	128	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS				
	129	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB				
	130	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN				
	131	LIMITS, SWITCH 3FC20 TO REMOTE				
	132	OPERATOR STEP PB				
	133	DURING STRIKE RECORD:	5:10 PM			
	134	SP STEP				
	135	V-243/V-244				
	136	13/46 (30 MIN)	9.3 9.3-10.0	5:40 PM		
	137	14/47 (60 MIN)	9.35 9.3-10.0	6:10 PM		
	138	15/48 (2 HRS)	9.4 9.3-10.0	7:10 PM		
	139	16/49 (2 HRS, 25 MIN)	9.4 9.3-10.0	7:35 PM		
	140	17/50 (FINAL 3 HRS)	8.1 7.5-8.5	8:10 PM		
	141	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE				
	142	IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.				
	143	& RECORD: PH --- ASSUME 77%		27-D		
	144	SIFT IN	50	128-A	50	
385	129	ADD 42" (320 G) WATER TO V-385				
6	130	ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	260	7-D	130	
	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				
	134	THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE				
	135	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW				
	136	STEARATE MAKE-UP PROCEDURE.				
	137	RUN IN 25" (244 GAL). DO NOT MAKE UP THIS				
	138	SOLUTION MORE THAN 30 MINUTES IN ADVANCE.				
	139	DELAY BETWEEN END OF STEP 41 HEAT-UP AND				
	140	START OF STEP 48 HOMOGENIZATION SHOULD BE				
	141	LESS THAN 30 MINUTES.				
388	136	TURN ON STEAM & AGITATOR				
8	137	ADJUST TO 32" (317 GAL) AT 178-182°F				
	138	SET BADGER METER FOR 466#				
	139	PUMP IN FROM V-387 THRU UNDERSURFACE	378	169-A	378	
	140	DISTRIBUTORS AS FAST AS POSSIBLE	44	155-A	44	
	141		44	160-A	44	
	142	SHUT OFF PUMP				
	143	STIR 30 MIN AT 178-182°F FOR S 48				
	144	DO NOT SHUT OFF AGITATOR				

DUP050046645

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EQUIP PAGE 3 CG 03 KY-908-D
MENTI JOB NAME: 03KY908DMGUSE N- ACCT
LBS CODE LBS

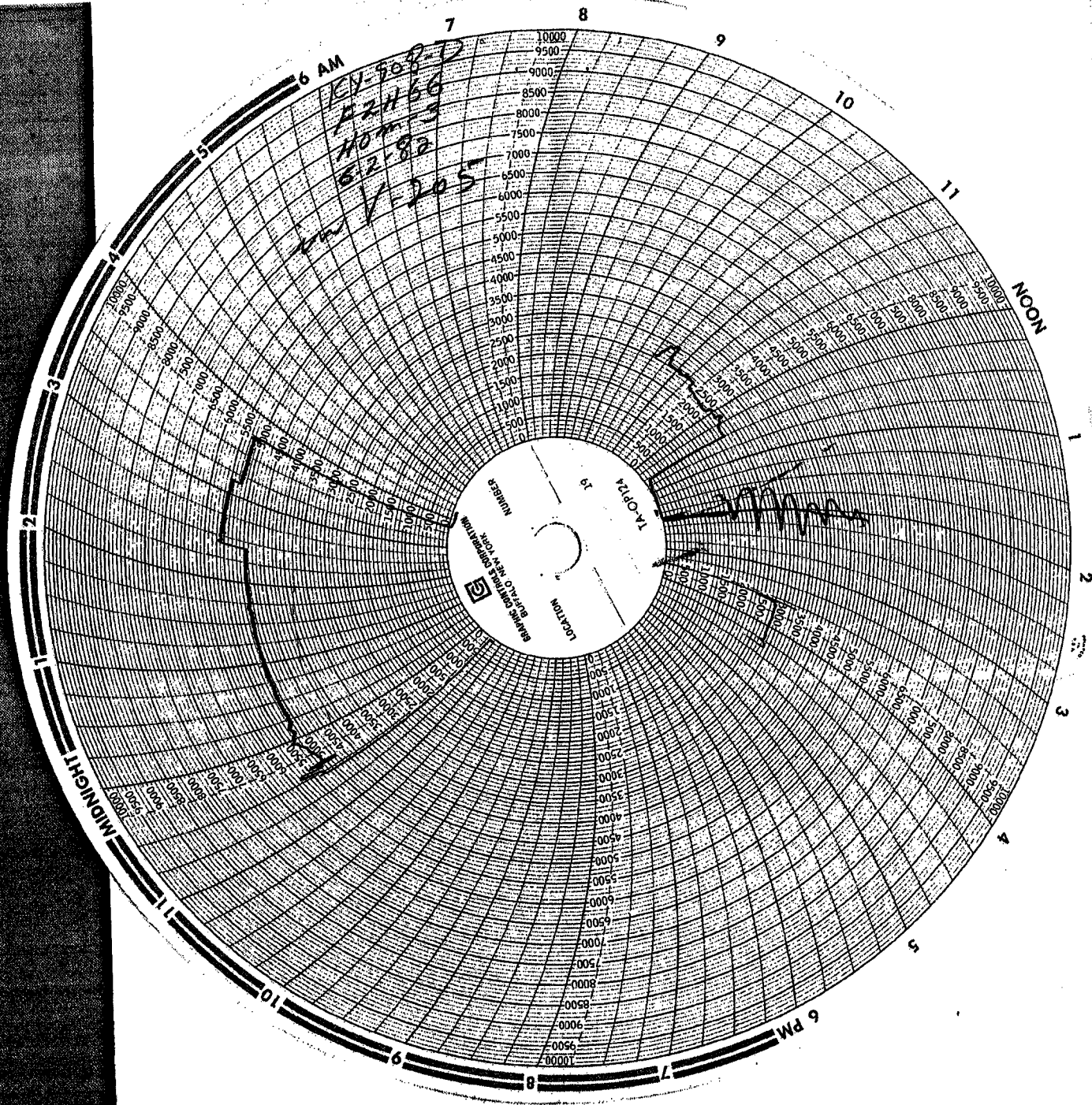
SV 43 WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN
& 5 TO 10 MIN
SP 44 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
9 PUMP
45 OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP
INLET
46 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI, TO SEWER
47 WHILE HOMOG WATER AT 2900-3100 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%
57 RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN
58 RECORD: PH 3.6 (4.2-4.4) & IF NECESSARY, ADJ
TO PH 4.2-4.4 & RECORD: PH 4.25 ASSUME 50%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%
SIPHON N-7-D INTO SV
59 OPERATOR STEP PB
60 OPERATOR STEP PB
61 SP STEP 60 - BATCH COMPLETE

115-D

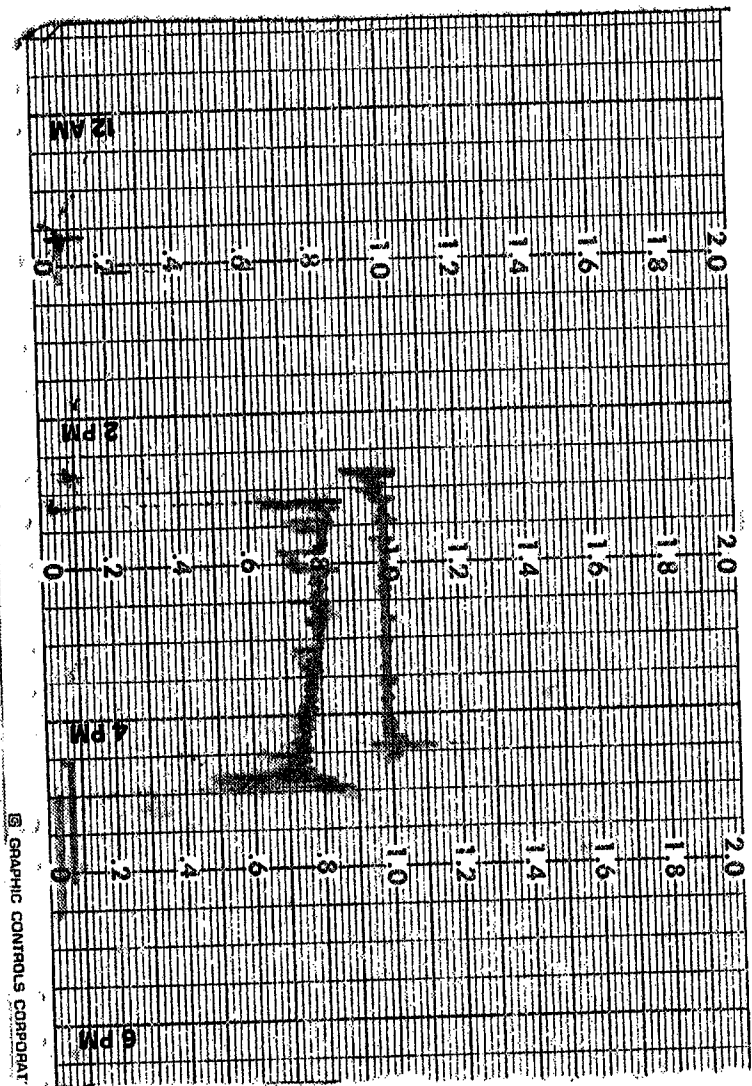
7-D

27-D

START TIME	SP STEP	FINISH TIME	SP STEP	OPERATOR
7 AM		10:50 A		120-144



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