CG 03 CODE KY-907-D EST WGT 4780* PROCESSES APPROVED BY:
OCT 20 1982 K2K92 _____ M ( ) KY-907-D (H) FWP 10/07/82
(DATE) (LOT) (TIME) COMTYP JOB NAME: 03KY907DMH

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	14	YC-2	93	G2B28	2000					
	14	YC-2	93	G2B4	1400					
	14	YC-2	93	G2B5	150					
	14	YC-2	93							

NON-BLEEDING

EQUIPMENT		NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
		BEFORE USING SV MAKE SURE N-28-D LINE (HYDROCHLORIC ACID) 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 (SODIUM SILICATE)	355	32-D	355
	3	DUMP IN AND STIR 5 MIN (CHROME YELLOW)	71X50	YC-2-B	3550
		LOT			
		RECORD: START 3:25 PM			
1		FIN 4:50PM G2B28	2000		
		G2B4	1400		
	4	ADJUST TO 75* (1275 G) G2B5	150		
	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. RECORD: TIME START 8:15 AM TOTAL MINUTES 120			
2		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	11	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 & CP 3	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 1 (V-243) OR POSITION 6 (V-244)			
	13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194*F)	OCT 25 1982		
	14	RECORD LEVELS (LIQUID ALUM) & SET R/M COUNTER #1 AS FOLLOWS:			
		A. 11LG 38 % PRESET #3 45 GAL		115-D	239
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%)			
		IN MANUAL 0.73 GPM		27-D	302
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 9.56 GPM			
		3FR10 (N-27-D/WATER) RATIO 1.31			
		8FC10 (N-32-D CONTROLLER) IN MANUAL .96 GPM		32-D	2022
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 8.45 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.76			

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EQUIPMENT		PAGE 2 CG 03 KY-907-D V-240	USE LBS	N-CODE	ACCT LBS
	16	OPERATOR STEP PB			
320 SV	17	RECORD LEVEL 2LG 85% IF BELOW 35% FOLLOW SOL'N MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 48" (2470 G)			
CP	19	RECORD PH 9.8 ADJ TO 11.1-11.3 W/N-7-D (CAUSTIC SODA SLN) AT 5% (10 PRTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50%	46	7-D	23
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
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 12:50			
	27	DURING STRIKE RECORD: SP STEP V-243/V-244 — PH — RANGE — TIME: 13/46 (30 MIN) 9.5 9.0-10.0 1:20 PM; 14/47 (60 MIN) 9.5 9.0-10.0 1:50; 15/48 (2 HRS) 9.5 9.0-10.0 2:50; 16/49 (3 HRS) 9.5 9.0-10.0 3:50; 17/50 (FINAL) 7.7 7.5-8.5 4:35 PM. 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 (BLANC FIXE N)	55	128-A	55
385 6	29	ADD 27" (208 G) WATER TO V-385			
	30	ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	90	7-D	45
	31	DURING STRIKE CHECK LEVEL IN V-387.			
387 7	32	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
	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 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 8	36	TURN ON STEAM & AGITATOR			
	37	ADJUST TO 42" (403 GAL) AT 178-182*F			
	38	SET BADGER METER FOR 550#			
	39	PUMP IN FROM V-387 THRU UNDRSURFCE DISTRIBUTORS	450	169-A	450
		AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL STEARATE & EMCOL P-10-59)	50 50	155-A 160-A	50 50
	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-907-D	USE LBS	N-CODE	ACCT LBS
SV & SP 9 CONT	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 & 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 3.3 (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
111	_____	7A	_____	120-114
2:00 PM	_____	2:30 PM	_____	237
3:00	_____	630R	_____	382

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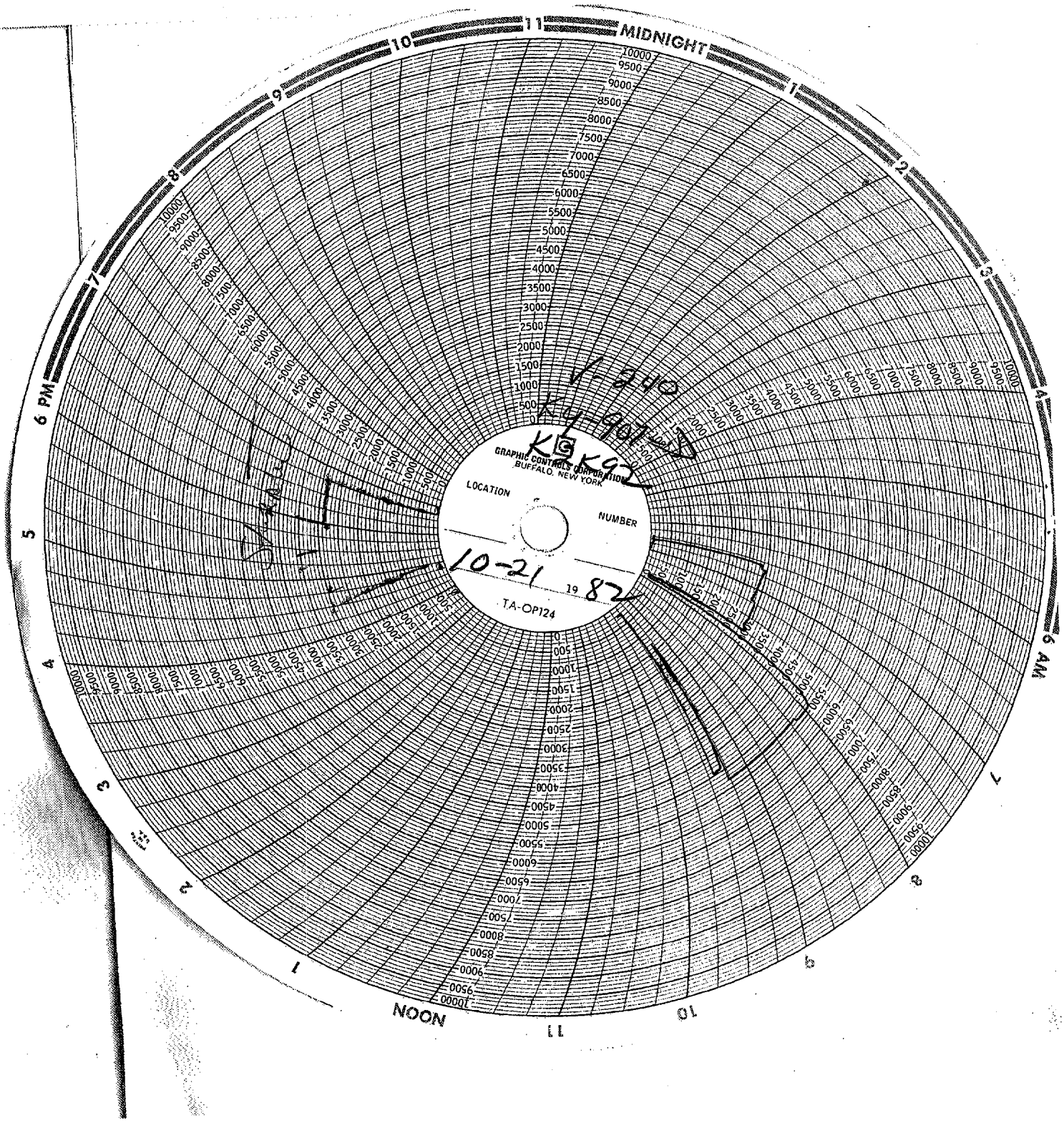

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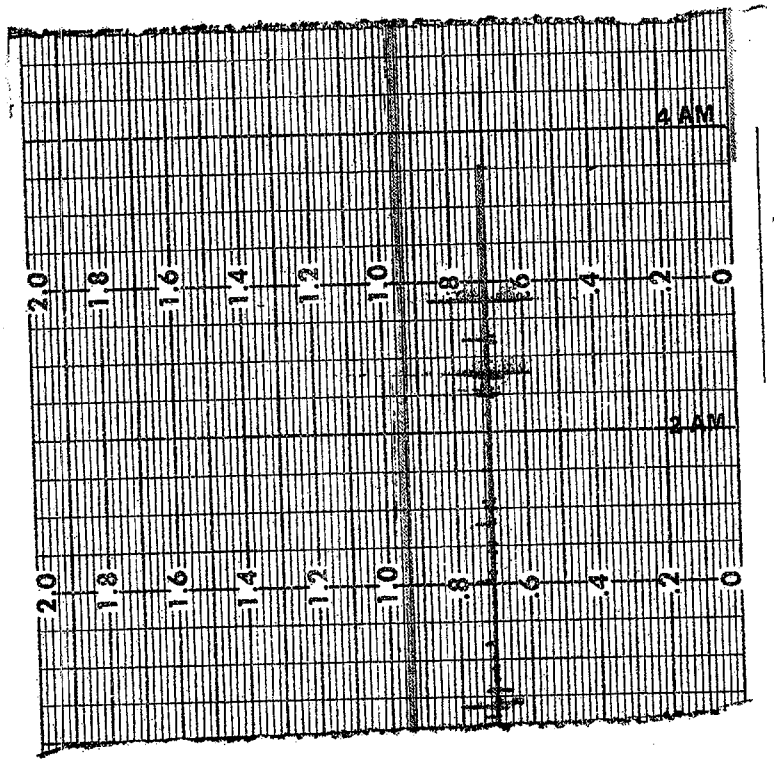
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