

CG 03

CODE KY-787-D

PKG

PROCESSES

APPROVED BY:

10/18/82

K2J63

(EST WGT)

() KY-787-D (T)

FWP 09/27/82

COMTYP JOB NAME: 03KY787DMT

(DATE)

(LOT)

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
						100.00				
						100.00				
						100.00				

BLEND BACK FOR STEP 43: KY-787-D, G2J99, 150 # ON 6-3 OR GET FROM R/M.

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
	"KROLOR" YELLOW-MEDIUM			
203 & 205	BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF*. RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	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
1	RECORD: START <u>5:32pm</u> LOT <u>D46 40X50</u> FIN <u>7:29pm</u> <u>D/E 6 10X50</u>			
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 <u>4.8</u> & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V- <u>244</u> & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START <u>4:20</u> TOTAL MINUTES <u>130</u>			
11	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 7 (V-244)			
3	13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
14	REMOTE (TEMP IS SET AT 190-194°F)			
14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG <u>52</u> % PRESET #1 32 GAL (LIQUID ALUM)	115-D		168
	B. 13LG <u>24</u> % PRESET #6 141 GAL (CALCIUM CHLORIDE 77%)	20-A		141
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D -SULFURIC ACID 60%- CONTROLLER) IN MANUAL 0.64 GPM	27-D		213
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.31			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.84 GPM	32-D		1425
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.76			
16	OPERATOR STEP PB			

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EQUIP PAGE 2 CG 03 KY-787-D *V-244* USE N- USE
MENTI | LBS CODE LBS

320 17 RECORD LEVEL 2LG *85%* IF BELOW 35% FOLLOW SOLN
SV MAKE-UP PROCEDURE FOR N-27-D
SP 18 ADJUST SV TO 48" (2470 G)
CP 19 RECORD PH *10.4* 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 *11.3*. ASSUME 50% 7-D
120 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH *9.7*
SV 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 23 OPERATOR STEP PB
124 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
27 DURING STRIKE RECORD:
SP STEP
V-243/V-244
13/46 (30 MIN) BH RANGE. TIME
14/47 (60 MIN) *9.5* 9.0-10.0 *8:15*
15/48 (2 HRS) *9.4* 9.0-10.0 *8:45*
16/49 (2 HRS, 25 MIN) *9.3* 9.0-10.0 *9:15*
17/50 (FINAL 3 HRS) *9.3* 9.0-10.0 *10:10*
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
129 ADD IN 7-8 MIN. (DRESINATE X) CHECK FOR DRAFT 365 530-A 365
IN VENT STACK BEFORE DUMPING.
339 30 ADD TO 49" (382 G) AT 80-100*F
6 31 STIR 5 MIN & RECORD: PH *10.1* (9.5-10.5)
32 STIR 15 MIN OR LONGER FOR SP STEP 26
33 RECORD: VOL *49* & CALC *49* X 0.78 = *38.2* GAL
34 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 SIFT IN (BLANC FIXE N)
SV 139 SP STEP 23/53. RECORD: PH *3.4* (3.7-4.2) 140 128-A 110
SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
8 141 RECORD: PH *8.5* (9.0-9.5). ADJ IF NECESSARY &
RECORD: PH *9.5* 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, *62599*, *150* #
144 SP STEP 29/58. RECORD: PH *9.4* & TIME *12:25 PM*
145 OPERATOR STEP PB
146 SP STEP 60. BATCH COMPLETE.

START *10:00 PM*
TIME SP STEP
7:00 AM

FINISH *11:00 PM* OPTR *54-114*
TIME SP STEP
12:30 PM *320-322*

