

OCT 28 1982
(DATE)

L2H84
(LOT)

4226*
(EST WGT)

() KY-908-D (G) FWP 10/05/82
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	-----	-----	-----	---	---	-----	-----
	14	YC-3	93	-----	-----	-----	---	---	-----	-----
	14	YC-3	93	-----	-----	-----	---	---	-----	-----
	14	YC-3	93	-----	-----	-----	---	---	-----	-----

NON-BLEEDING						USE LBS	N- CODE	ACCT LBS
EQUIP MENT	NAME : "KROLOR" YELLOW-LIGHT							

203	1	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF.						
	2	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.						
	3	WEIGH IN DRUM & POUR IN (SODIUM SILICATE)					420	32-D
	4	DUMP IN AND STIR 5 MIN (CHROME YELLOW)					63X50	YC-3-B
	5	RECORD: START <u>7:30 AM</u> LOT <u>K2804</u>					3150	
	6	FIN <u>10:30 AM</u>						
	7	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.						
	8	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-204						
	9	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-204						
	10	RECORD: V-205 VOL <u>56</u> & ADJ TO 60" (2100 G)						
	11	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY						

205	1	RUN 10" (514 G) WATER INTO V-204 START AGITATOR						
	2	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV						
	3	RECORD: TIME START <u>8:35 AM</u> TOTAL MINUTES <u>135</u>						
	4	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-204						
	5	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV						

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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						
	14	REMOTE (TEMP IS SET AT 190-194°F)						
3	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:						
		A. 11LG <u>72%</u> PRESET #2					95 GAL	115-D
		(LIQUID ALUM)						504
15		SET STRIKE FLOW CONTROLLERS AS FOLLOWS:						
		3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%)						
		IN MANUAL					0.65 GPM	27-D
		3FC20 (N-27-D WATER) IN MANUAL LOCAL					5.2 GPM	
		3FR10 (N-27-D/WATER) RATIO					0.8	
		3FC10 (N-32-D CONTROLLER) IN MANUAL					0.87 GPM	32-D
		3FC20 (N-32-D WATER) IN MANUAL LOCAL					4.8 GPM	
		3FR20 (N-32-D WATER) IN REMOTE						
		3FR10 (N-32-D/WATER) RATIO					1.1	

9/11/2

EQUIP MENT	PAGE 2 CG 03 KY-908-D	USE LBS	N- CODE	ACCT LBS
16	OPERATOR STEP PB			
320	17 RECORD LEVEL 2LG 9.7 IF (35% FOLLOW SOLUTION			
SV	18 MAKE-UP PROCEDURE FOR N-27-D			
SP	19 ADJUST SV TO 47° (2400 G)			
CP	20 RECORD PH 9.1. 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 11.2 ASSUME 50%	70	7-D	35
	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: 12:40 PM			
	SP STEP			
	V-243/V-244			
	13/46 (30 MIN) PH 7.5 RANGE 9.3-10.0 TIME 1:40 P			
	14/47 (60 MIN) PH 9.5 RANGE 9.3-10.0 TIME 1:40 P			
	15/48 (2 HRS) PH 9.5 RANGE 9.3-10.0 TIME 2:40 P			
	16/49 (2 HRS, 25 MIN) PH 9.4 RANGE 9.3-10.0 TIME 3:05 P			
	17/50 (FINAL 3 HRS) PH 8.0 RANGE 7.5-8.5 TIME 3:40 P			
	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%			
28	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
387	33 DURING STRIKE CHECK LEVEL IN V-387.			
7	34 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
	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.			
388	37 RUN IN 25° (244 GAL). DO NOT MAKE UP THIS			
8	38 SOLUTION MORE THAN 30 MINUTES IN ADVANCE.			
	39 DELAY BETWEEN END OF STEP 41 HEAT-UP AND			
	START OF STEP 48 HOMOGENIZATION SHOULD BE			
	LESS THAN 30 MINUTES.			
	40 TURN ON STEAM & AGITATOR			
	41 ADJUST TO 32° (317 GAL) AT 178-182°F			
	42 SET BADGER METER FOR 466#			
	43 PUMP IN FROM V-387 THRU UNDERSRFE 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
	44 SHUT OFF PUMP			
	45 STIR 30 MIN AT 178-182°F FOR S 48			
	46 DO NOT SHUT OFF AGITATOR			

EQUIP MENT		PAGE 3 CG 03 KY-908-D <i>V-244</i>	USE LBS	N- CODE	ACCT LBS
SV-143	✓	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN			
SP-144	✓	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
145	✓	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>3.5</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>5.0</u> (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH <u>4.2</u> ASSUME 50% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%	<u>20</u>	7-D 27-D	<u>15</u>
		SIPHON N-7-D INTO SV			
159	✓	OPERATOR STEP PB			
160	✓	OPERATOR STEP PB			
161	✓	SP STEP 60 - BATCH COMPLETE			
		START FINISH OPERATOR			
		TIME SP STEP TIME SP STEP			
		<u>11:00am</u> _____ <u>7:00am</u> _____ <u>409-438</u>			
		<u>7:00pm</u> _____ <u>3:00pm</u> _____ <u>37</u>			
		<u>3:40pm</u> _____ <u>6:15pm</u> _____ <u>54-726</u>			

NOTE. COULD NOT GET N-115-D FROM AUTOMATIC; GOT IT MANUALLY.

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