

CG 03

CODE KY-787-D PKG

PROCESSES

APPROVED BY:

34043 3444 OK

() KY-787-D (T)

FWP 09/27/82

(EST WGT)

COMTYP JOB NAME: 03KY787DMT

(DATE)

(LOT)

K2H90

30m

LOCATN	CG	CODE	PR	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
				02516		100.00	40	50	2000	
				12036		100.00	10	50	500	
						100.00				

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

EQUIP ~~NOT FOR V-203~~ ~~G2J99 150~~ USE LBS N- CODE ACCT LBS

NAME: "KROLOR" YELLOW-MEDIUM

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.								
205	3	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					
		RECORD: START <u>2:30 AM</u> LOT <u>02516</u>	2000							
		FIN <u>4:30 AM</u> <u>12036</u>	500							
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>54</u> & 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 <u>8:30 AM</u> TOTAL MINUTES								
		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 <u>23</u> % PRESET #1 32 GAL (LIQUID ALUM)		115-D	168					
		B. 13LG <u>46</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								

EQUIP PAGE 2 CG 03 KY-787-D V-240 USE N- FUSE
MENT! LBS CODE LBS

320 117 RECORD LEVEL 2LG 76 % IF BELOW 35% FOLLOW SOLN
SV 118 WAKE-UP PROCEDURE FOR N-27-D
SP 119 ADJUST SV TO 48" (2470 G)
CP 120 RECORD PH 9.4 ADJ TO 11.1-11.3 WITH N-7-D
(CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1
PART N-7-D)
121 SIPHON INTO SV. RECORD: PH 11.5 ASSUME 50% 52 7-D 25
122 OPERATOR STEP PB

123 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7
SV 124 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 125 OPERATOR STEP PB
126 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
127 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
128 OPERATOR STEP PB
129 DURING STRIKE RECORD: 11:40 AM

V-243/V-244	PH	RANGE	TIME
13/46 (30 MIN)	<u>9.6</u>	9.0-10.0	<u>12:10 PM</u>
14/47 (60 MIN)	<u>9.6</u>	9.0-10.0	<u>12:40 PM</u>
15/48 (2 HRS)	<u>9.6</u>	9.0-10.0	<u>1:40 PM</u>
16/49 (2 HRS, 25 MIN)	<u>9.6</u>	9.0-10.0	<u>2:05 PM</u>
17/50 (FINAL 3 HRS)	<u>7.9</u>	7.5-8.5	<u>3:40 PM</u>

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.
339 130 ADJ TO 49" (382 G) AT 80-100°F
6 131 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
132 STIR 15 MIN OR LONGER FOR SP STEP 26
133 RECORD: VOL 49 * & CALC 49 * X 0.78 = 38.2 GAL
134 SET PRESET 48 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 (BLAND FIXE N) 110 128-A 110
SV 139 SP STEP 23/53. RECORD: PH 3.2 (3.7-4.2)
SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
141 RECORD: PH 8.7 (9.0-9.5). ADJ IF NECESSARY &
RECORD: PH 9.4 ASSUME 77% 27-D
(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 16 7-D 8
(SIPHON N-7-D INTO SV) G 2 J 99
142 OPERATOR STEP PB
143 SIFT IN BLEND BACK: KY-787-D, 100 #
144 SP STEP 29/58. RECORD: PH 9.5 & TIME
145 OPERATOR STEP PB
146 SP STEP 60. BATCH COMPLETE.

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>3:00 PM</u>	<u>11:00 PM</u>	<u>252-409</u>
<u>11:00 PM</u>	<u>3:35 PM</u>	<u>27-242</u>





