

CO 03 CODE KY-787-D PKG.
 DEC 18 33311
 EST. WGT. 1090 990 LBS.

STD. MRS. 8.9 TIME 11:15 M

14 - YC-2-B 98 4 Lot 24075, 1.600 #
 Lot 23968, 800 #
 Lot 2400, 2400 #

PROCESSES		APPROVED BY	
() KY-787-D	()	FWK	9/22/76
()	()	DCG	9/27/76
()	()	MTW	9/30/76
()	()		
TYPED BY			
N.E. 2/12/77			

Homog # 4-1 SI Pass

Total Wgt. - 3490# 3390

NON-BLEEDING

PMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1 Run 6" (922 G) water into V-203			
	2 Weigh in drum & pour in	320	32-D	320
	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 24075	32		
	Fin 0.15 23968	18		
	4 Add to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water			
	7 Record V-205 Vol 43 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205 & SV 2	9 Run 10" (514G) water into SV & start agitator			
	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time start 3.00 min Total Min 115			
	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
	11 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
SP & CP 3	12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 46 % - preset #1 80 Gal		15-A	160
	b. 13LG 23 % - preset #2 135 Gal		20-A	135
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.83 GPM		27-D	275
	b. 3FC20 (N-27-D Water) in Manual Local 5.28 GPM			
	c. 3ER10 (N-27-D/Water Ratio) 0.64			
	d. 8FC10 (N-32-D Controller) in Manual 1.08 GPM		32-D	1840
	e. 8EC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8EC20 (N-32-D Water) in Remote			
	g. 8ER10 (N-32-D/Water Ratio) 0.83			
SV & CP 4	16 Operator Step PB			
	17 Record Level 2 LG 1.4 %. If below 35% follow solution make-up procedure for N-27-D			
	18 Add to 48" (2470 G)			
	19 Record pH 10.8			
	20 Add to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% (10 parts water to 1 part N-7-D)	30	1-D	15
	Siphon into SV, Record pH 11.3			
	21 Operator Step PB			

SHIPMENT	PAGE	CG	CODE	KY-787-D (S)	EST. WGT.	6121	LBS.	USE	N	ACC
								LBS.	CODE	LB.
SV 6	25	When S 20 heating complete. Record: pH (9.6-10.2)								
	26	Set V-343 acid pump at 57 setting ($\pm$ 225 min)								
	27	Set V-349 silicate pump at 48 setting ($\pm$ 180 min)								
	28	Immediately meter in V-343 & 349, maintain SV at 190-194°F during strike								
	29	Record: START FIN MIN								
		V-343								
		V-349								
		Record:	TIME	V-343	V-349	SV	NORMAL			
				in	in	pH	pH			
		at 20 min		(37)	(15)		9.3-10.0			
		40 min		(34)	(13)		9.3-10.0			
		1 hr		(30)	(11)		9.3-10.0			
		2 hrs		(19)	(6)		9.3-10.0			
		3 hrs		(8)	(0)		9.3-10.0			
		Finish		(0)	(0)		7.5- 8.5			
		Note: (1) If pH not as specified, notify Supervisor & note in log								
		(2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH Assume 78%								
									27-D	
330 7	30	Run 35" (600 G) water into V-330 & heat to 160-170°F								
	31	Add in 12-13 min								
	32	Stir 5 min & Record: pH (9.5-10.5)								
	33	Stir 20 min or longer to dissolve for S 46								
357 8	34	Run 11" (80 G) water into V-357 & heat to 135-140°F								
	35	Dump in & stir to dissolve for S 42								
362 9	36	Run 42" (513 G) water into V-302								
	37	Add & stir 2 min for S 44 Assume 50%								
SV 10	38	When V-349 MTY, rinse in with minimum water then set pump to zero setting								
	39	When V-343 MTY, rinse in with minimum water then turn off pump motor								
	40	Turn off steam								
	41	Sift in 4 bags								
	42	Run in V-357 from S 35 & stir 5 min								
	43	Record: pH (3.7-4.2)								
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min								
	45	Record: pH (9.0-9.5) & if necessary, adj to pH 9.0-9.5 & Record: pH Assume 78%								
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%								
		Siphon N-7-D into SV								
330 11	46	Run in V-330 thru 20 mesh screen & stir 20 min								
	47	Run 11" (216 G) water into V-330 & dump in								
SV 12	48	Stir 5 min to dissolve for S 49								
	49	Run V-313 into SV in 15-20 min								
	50	Stir 15 min								
	51	Record: pH (9.0-10.0)								
	52	Stop agitator								
		START FIN OPTR								
		Step V-262 (20 RPM) V-243, 244, 245, 247								
		9 2" 4"								
		18 26" 50"								