

LOT

L2J20

NOV 4 1982

MAKING NOTES

EST. WT. 4226* LBS.

JOB NAME: 03KY908DPG

INSTRUCTIONS

= PRESSING =

RECORD

							1ST	2ND	3RD	4TH	5TH
DATE						PRESSLOAD					
TIME						STARTED					
RELEASED BY						CAKES USED					
PRESS	2	22	23	24		WATER ON					
NO. OF CAKES	46	46	46	52		HRS. WASHED					
PRESS WITH						M MHOS					
WASH TO 500 M MHOS - 135-145 F WATER						HRS. WASHED					
TEST AFTER 2 HOURS						M MHOS					
LOAD ON 7 CARS						HRS. WASHED					
						M MHOS					
						CAKE CONDITION					
						NO CARS LOADED					
						EXPLAIN LOSSES					

SAMPLES
DELIVER TO

SAMPLED BY
RELEASED BY

= DRYING =

DRY 24 HOURS AT 180 F
NOTE: DRY ON FIRST STAGE ONLY.
RE-SET ON FIRST STAGE TIL DRY.

LUMP: - OK - WET - SALTS - CONTAMINATD

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES
DELIVER TO

NO CARS PULLED
SAMPLED BY
RELEASED BY

NO DRUMS
LUMP WGT

= GRINDING =

MILL 939 HSP 3/32"RP SCREEN 3500 RPM
MAX. TEMP. 170 F

SCREEN RPM
MAX. TEMP. F

EXPLAIN LOSSES

SAMPLE W/O MIXING 1 ENV & 2 PT CANS
IF PACKED IN BAGS SAMPLE AS FOLLOWS:
FIRST BAG: 1 ENV.
40TH BAG: 1 ENV. & 2 PINT CANS
LAST BAG: 1 ENV.
DELIVER TO CTL

DATE MIXED
SAMPLED BY
RELEASED BY

EQUIP MENT	PAGE 3 CG 03 KY-908-D	USE LBS	N- CODE	ACCT LBS
SV-43	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN			
SP-44	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
9-45	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 & STEARATE 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_____ (3.3-3.7)			
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_____ (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH_____ ASSUME 50% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%		7-D	
	SIPHON N-7-D INTO SV		27-D	
59	OPERATOR STEP PB			
60	OPERATOR STEP PB			
61	SP STEP 60 - BATCH COMPLETE			
	START FINISH OPERATOR			
	TIME SP STEP TIME SP STEP			

CG 03 CODE KY-908-D PKG

PROCESSES

APPROVED BY

() KY-908-D (G)

FWP 10/05/82

NOV 4, 1982

L2J20

4226*

COMTYP JOB NAME: 03KY908DMG

(DATE)

(LOT)

(EST WGT)

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							

EQUIP
MENT

NAME : "KROLOR" YELLOW-LIGHT

NON-BLEEDING

USE LBS	N- CODE	ACCT LBS
------------	------------	-------------

"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF."

203 1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.

205 2 WEIGH IN DRUM & POUR IN (SODIUM SILICATE) 420 32-D 420

3 DUMP IN AND STIR 5 MIN (CHROME YELLOW) 63X50 YC-3-B 3150

1 RECORD: START _____ LOT _____

FIN _____

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 _____ & ADJ TO 60" (2100 G)

8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY

205 9 RUN 10" (514 G) WATER INTO V-_____ START AGITATOR

SV 10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.

2 RECORD: TIME START _____ 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 112 SP STEP 01 - SET FORMULA SELECTOR TO POSITION

& 2 (V-243) OR POSITION 7 (V-244)

CP 113 PRESS SV CAM RESET PB - SET 22 TC IN AUTO

3 114 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:

A. 11LG _____% PRESET #1 95 GAL 115-D 504

(LIQUID ALUM)

115 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:

3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%) 27-D 218

IN MANUAL 0.65 GPM

3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.2 GPM

3FR10 (N-27-D/WATER) RATIO 0.8

8FC10 (N-32-D CONTROLLER) IN MANUAL 0.87 GPM 32-D 1476

8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.8 GPM

8FC20 (N-32-D WATER) IN REMOTE

8FR10 (N-32-D/WATER) RATIO 1.1

DUP050060035

N41015.01

EQUIP MENT	PAGE 2 CG 03 KY-908-D	USE LBS	N- CODE	ACCT. LBS
16	OPERATOR STEP PB			
320 SV	17 RECORD LEVEL 2LG ____% IF (35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
SP	18 ADJUST SV TO 47" (2400 G)			
CP	19 RECORD PH ____ 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	SIPHON INTO SV. RECORD: PH ____ ASSUME 50%		7-D	
120	OPERATOR STEP PB			
21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH ____			
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			
27	DURING STRIKE RECORD: SP STEP V-243/V-244 PH RANGE TIME 13/46 (30 MIN) ____ 9.3-10.0 ____ 14/47 (60 MIN) ____ 9.3-10.0 ____ 15/48 (2 HRS) ____ 9.3-10.0 ____ 16/49 (2 HRS, 25 MIN) ____ 9.3-10.0 ____ 17/50 (FINAL 3 HRS) ____ 7.5-8.5 ____ 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	SIFT IN (BLANC FIXE N)	55	27-D 128-A	55
385	29 ADD 42" (320 G) WATER TO V-385			
6	30 ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	260	7-D	130
31	DURING STRIKE CHECK LEVEL IN V-387.			
387	32 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	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 25" (244 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	36 TURN ON STEAM & AGITATOR			
8	37 ADJUST TO 32" (317 GAL) AT 178-182°F			
38	SET BADGER METER FOR 466#			
39	PUMP IN FROM V-387 THRU UNDERSRFE DISTRIBUTORS AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL STEARATE, EMCOL P-10-59)	378 44 44	169-A 155-A 160-A	378 44 44
40	SHUT OFF PUMP			
41	STIR 30 MIN AT 178-182°F FOR S 48			
42	DO NOT SHUT OFF AGITATOR			