

NOV 2 1982

L2J11

4226*

() KY-908-D (G) FWP 10/05/82

COMTYP JOB NAME: 03KY908DMG

(DATE)

(LOT)

(EST WGT)

STANDARD HRS.

TIME _____ M

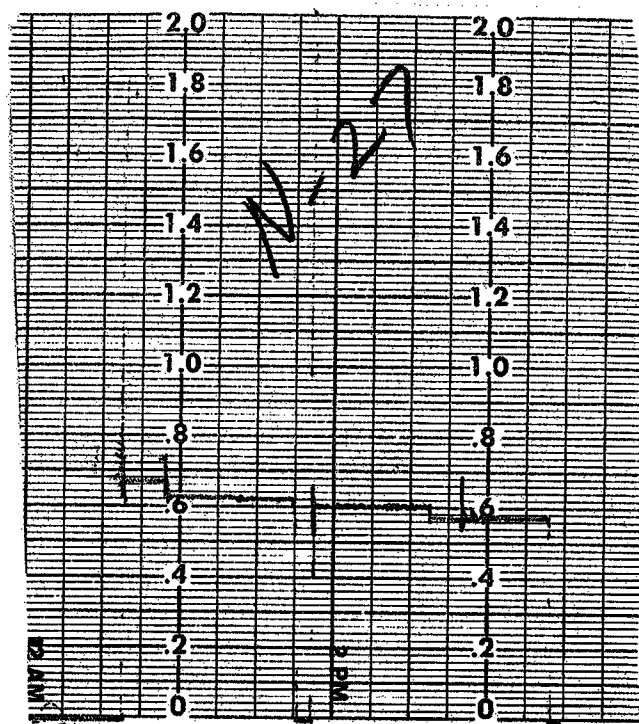
LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	==	=====	==	=====	=====	=====	=====	=====	=====	=====
	14	YC-3	93	-----	-----	-----	-----	-----	-----	-----
	14	YC-3	93	-----	-----	-----	-----	-----	-----	-----
	14	YC-3	93	-----	-----	-----	-----	-----	-----	-----
	14	YC-3	93	-----	-----	-----	-----	-----	-----	-----

EQUIP MENT		NON-BLEEDING				
		NAME :	USE LBS	N- CODE	ACCT LBS	
		"KROLOR" YELLOW-LIGHT				
		"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	
		RECORD: START <u>7:00 PM</u> LOT <u>K2B18</u>	<u>2000</u>			
		FIN <u>8:00 PM</u> <u>528.09</u>	<u>1150</u>			
		ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.				
		WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205				
		WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205				
		RECORD: V-203 VOL _____ & ADJ TO 60" (2100 G)				
		INSPECT HOMOG STRAINER & CLEAN IF NECESSARY				
205	9	RUN 10" (514 G) WATER INTO V-204. START AGITATOR				
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.				
		RECORD: TIME START <u>2:15 PM</u> TOTAL MINUTES <u>180</u>				
	2	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>60</u> % PRESET #1 95 GAL		115-D	504	
		(LIQUID ALUM)				
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:				
		3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%)		27-D	218	
		IN MANUAL 0.65 GPM				
		3PC20 (N-27-D WATER) IN MANUAL LOCAL 5.2 GPM				
		3PR10 (N-27-D/WATER) RATIO 0.8				
		BFC10 (N-32-D CONTROLLER) IN MANUAL 0.87 GPM		32-D	1476	
		BFC20 (N-32-D WATER) IN MANUAL LOCAL 4.8 GPM				
		BFC20 (N-32-D WATER) IN REMOTE				
		BFR10 (N-32-D/WATER) RATIO 1.1				

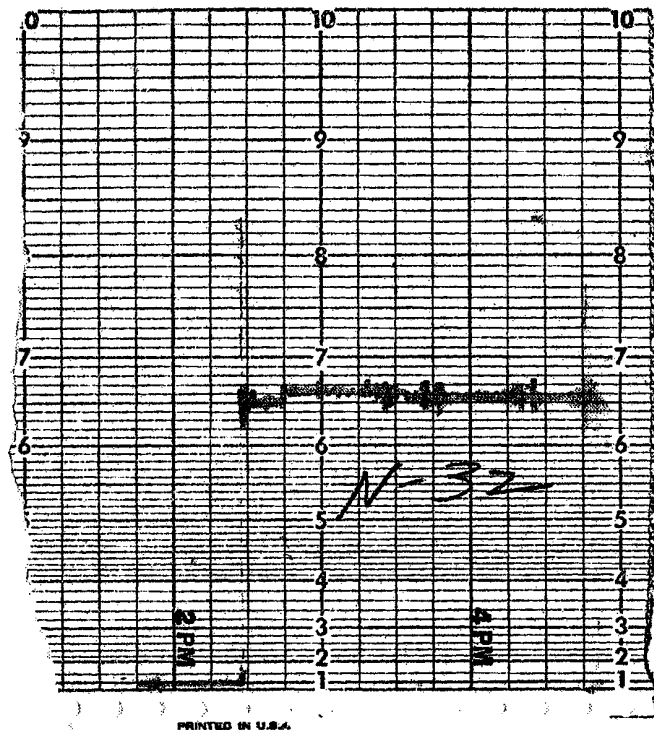
NOV 4 1982

EQUIP MENT	PAGE 2 CG 03 KY-908-D	USE LBS	N- CODE	ACCT. LBS
320	16 OPERATOR STEP PB			
SV	17 RECORD LEVEL 2LG 64% IF (35% FOLLOW SOLUTION			
SP	18 MAKE-UP PROCEDURE FOR N-27-D			
CP	19 ADJUST SV TO 47" (2400 G)			
	20 RECORD PH 9.5. 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 11.1. ASSUME 50%	50	7-D	25
	20 OPERATOR STEP PB			
SV	21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 7.5.			
SP	22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	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: 10:20/8			
	SP STEP			
	V-243/V-244			
	13/46 (30 MIN) PH 9.4 RANGE 9.3-10.0 TIME 10:30/8			
	14/47 (60 MIN) 9.7 9.3-10.0 11:30/8			
	15/48 (2 HRS) 9.3 9.3-10.0 12:30/8			
	16/49 (2 HRS, 25 MIN) 9.3 9.3-10.0 12:55/8			
	17/50 (FINAL 3 HRS) 7.8 7.5-8.5 1:20/8			
	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%			
128	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
	33 DURING STRIKE CHECK LEVEL IN V-387.			
387	34 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	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.			
	37 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	38 TURN ON STEAM & AGITATOR			
8	39 ADJUST TO 32" (317 GAL) AT 178-182°F			
	40 SET BADGER METER FOR 466			
	41 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
	42 SHUT OFF PUMP			
	43 STIR 30 MIN AT 178-182°F FOR S 48			
	44 DO NOT SHUT OFF AGITATOR			

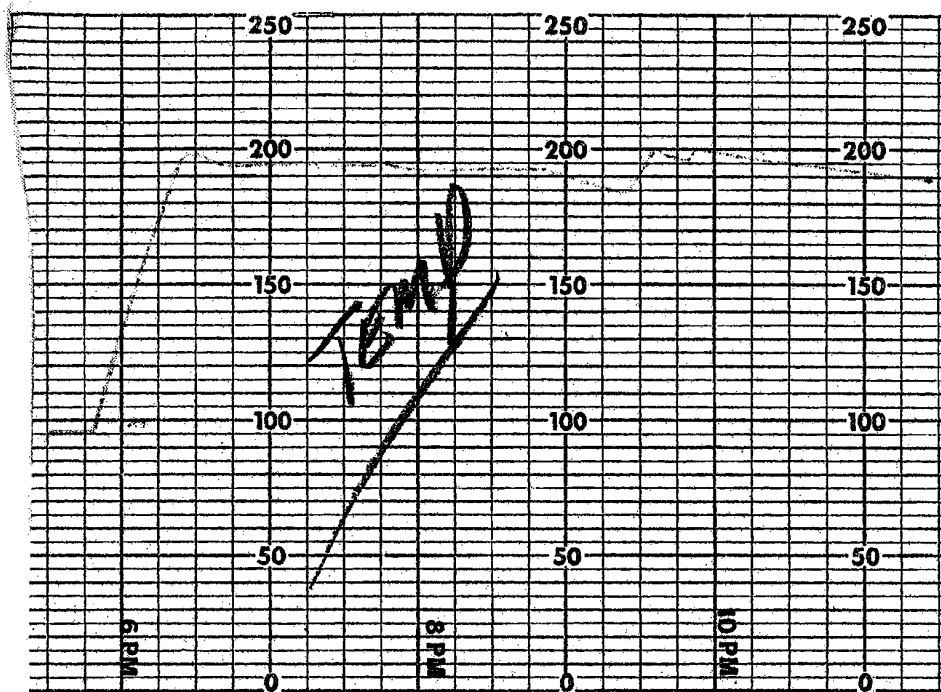
EQUIP MENT	PAGE 3 CG 03 KY-908-D	V-244	USE LBS	N- CODE	ACCT LBS
SV-143	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN				
2	5 TO 10 MIN				
SP-144	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE				
9	PUMP				
145	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP				
	INLET				
146	OPEN WATER VALVE AT STEARATE 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>3.7</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>4.2</u> (4.2-4.4) & IF NECESSARY, ADJ				
	TO PH 4.2-4.4 & RECORD: PH _____ ASSUME 50%			7-D	
	(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%			27-D	
	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>11:00PM</u>		<u>2:00AM</u>		<u>409-438</u>	
<u>3:00PM</u>		<u>4:00AM</u>		<u>54</u>	
<u>11:00PM</u>		<u>3:26AM</u>		<u>409</u>	



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