

OCT 15, 1982

K2K64

() KY-907-D (H) FWP 10/07/82
COMTYP JOB NAME: 03KY907DMH

DATE)

(LOT)

(TIME)

LOCATN	CG	CODE	PR	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
14	YC-2	93		G2B30			71	50	3550	
14	YC-2	93								
14	YC-2	93								
14	YC-2	93								

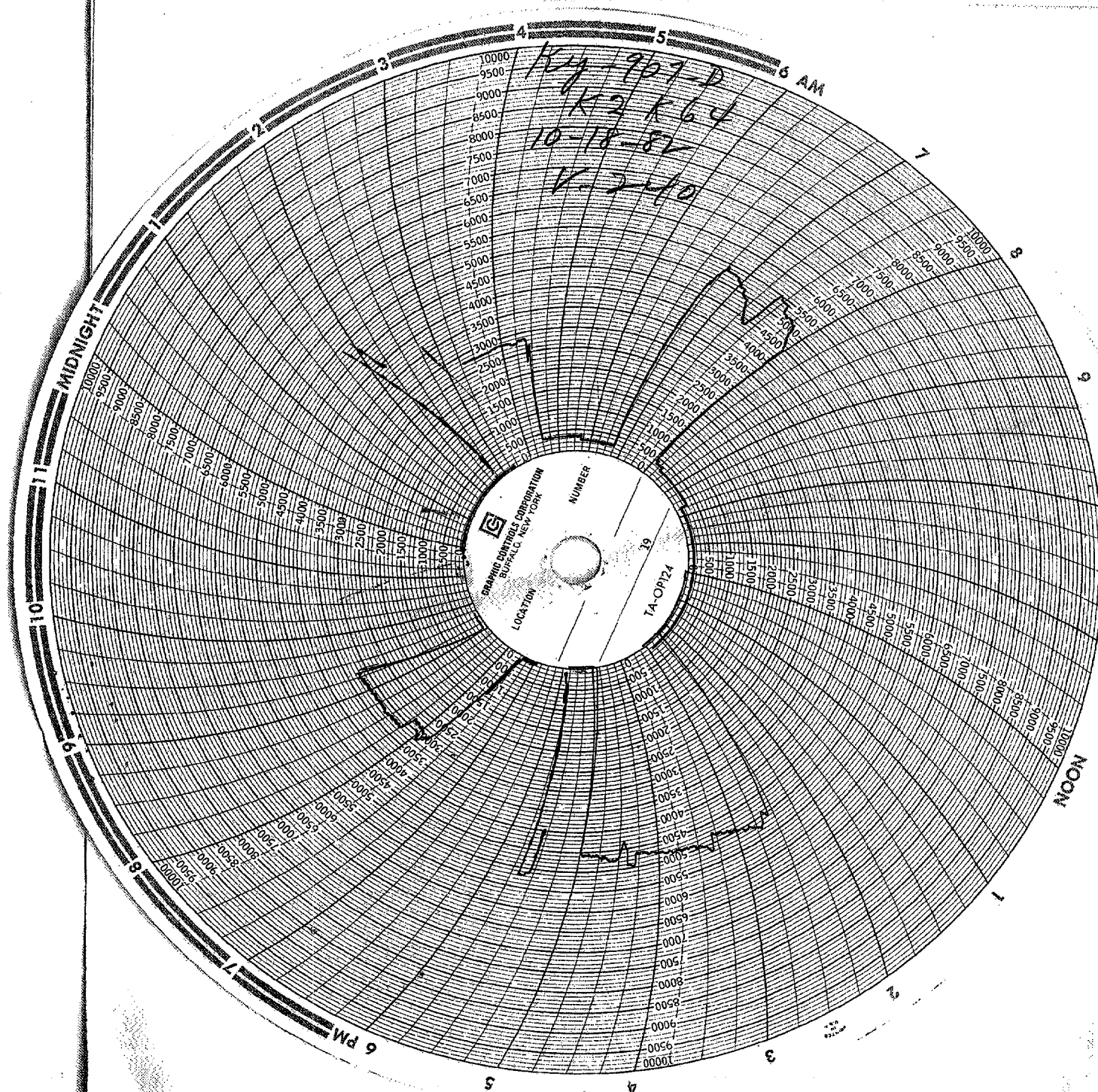
EQUIP MENT		NAME : "KROLOR" YELLOW-MEDIUM		USE LBS	N- CODE	ACCT LBS
		"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO- CHLORIC ACID) IF ANY IS BLANKED OFF."				
203	1	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.				
205	2	WEIGH IN DRUM & POUR IN (SODIUM SILICATE)		355	32-D	355
	3	DUMP IN AND STIR 5 MIN (CHROME YELLOW)		71X50	YC-2-B	3550
		LOT RECORD: START <u>3:00 PM</u> <u>G2B30</u>		3550		
		FIN <u>5:00 PM</u>				
		ADJUST TO 75" (1275 G)				
		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-205 VOL <u>40</u> " & ADJ TO 60" (2100 G)				
		INSPECT HOMOG STRAINER & CLEAN IF NECESSARY				
205	5	RUN 10" (514 G) WATER INTO V- <u>240</u> & START AGITATOR				
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.				
		RECORD: TIME START <u>6:20 A</u> TOTAL MINUTES <u>FIN 6:10 PM</u>				
2		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205				
		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				
		1 (V-243) OR POSITION 6 (V-244)				
CP	113	PRESS SV CAM RESET PB - SET 22 TC IN AUTO				
		REMOTE (TEMP IS SET AT 190-194°F)				
3	114	RECORD LEVELS (LIQUID ALUM) & SET R/M COUNTER				
		#1 AS FOLLOWS:				
		A. 11LC <u>70</u> % PRESET #3 45 GAL				
115		SET STRIKE FLOW CONTROLLERS AS FOLLOWS:				
		(SFC10 (N-27-D CONTROLLER - SULFURIC ACID 60%)				
		IN MANUAL 0.73 GPM			115-D	239
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 9.56 GPM				
		2FR10 (N-27-D/WATER) RATIO 1.31			27-D	302
		8FC10 (N-32-D CONTROLLER) IN MANUAL .96 GPM				
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 8.45 GPM			32-D	202
		8FC20 (N-32-D WATER) IN REMOTE				
		8FR10 (N-32-D/WATER) RATIO 1.76				

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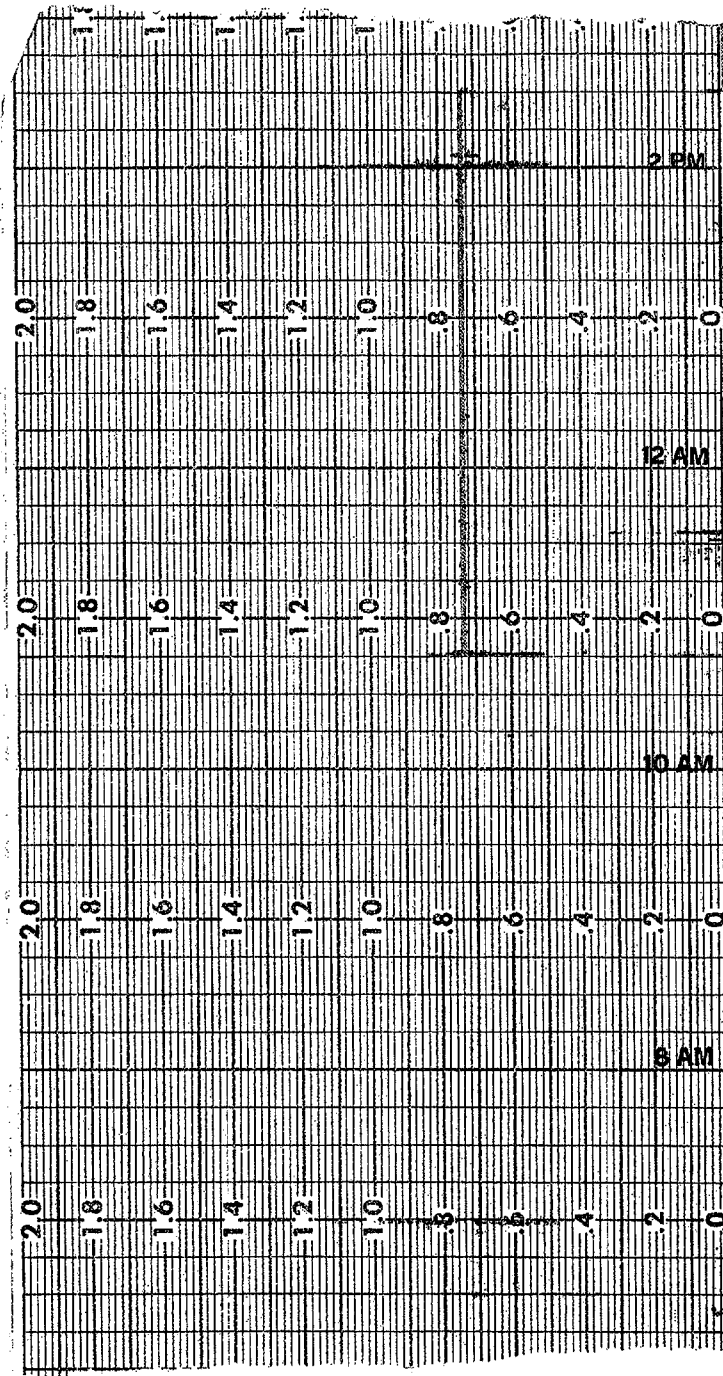
EQUIP MENT	PAGE 2 CG 03 KY-907-D	USE LBS	N- CODE	ACCT LBS
320	18 OPERATOR STEP PB			
SV	17 RECORD LEVEL 2LG 37% IF BELOW 35% FOLLOW SOL'N			
SP	18 MAKE-UP PROCEDURE FOR N-27-D			
CP	18 ADJUST SV TO 48" (2470 G)			
4	19 RECORD PH 9.2 ADJ TO 11.1-11.3 W/N-7-D (CAUSTIC SODA SLN) AT 5% (10 PRTS WATER TO 1 PART N-7-D)			
	SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50%	50	7-D	25
	20 OPERATOR STEP PB			
SV	21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5			
SP	22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	23 OPERATOR STEP PB			
5	24 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
	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			
	13/46 (30 MIN)	9.5	9.0-10.0	9:00 PM
	14/47 (60 MIN)	9.5	9.0-10.0	9:20 PM
	15/48 (2 HRS)	9.5	9.0-10.0	10:30 PM
	16/49 (3 HRS)	9.5	9.0-10.0	11:30 PM
	17/50 (FINAL)	9.5	7.5-8.5	12:15 AM
	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH > 8.5, ADJ TO 7.5-8.5.			
	& RECORD: PH			
	28 SIFT IN (BLANC FIXE N)	55	27-D	55
385	29 ADD 27" (208 G) WATER TO V-385			
6	30 ADD & STIR FOR 2 MIN FOR S 57	ASSUME 50%	90	7-D 45
387	31 DURING STRIKE CHECK LEVEL IN V-387.			
7	32 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
	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.			
388	35 RUN IN 32" (317 GAL). DO NOT MAKE-UP THIS SOLUTION MORE THAN 30 MINUTES IN ADVANCE.			
8	36 DELAY BETWEEN END OF STEP 41 HEAT-UP AND START OF STEP 48 HOMOGENIZATION SHOULD BE LESS THAN 30 MINUTES.			
	37 TURN ON STEAM & AGITATOR			
	38 ADJUST TO 42" (403 GAL) AT 178-182°F			
	39 SET BADGER METER FOR 550#			
	40 PUMP IN FROM V-387 THRU UNDRSURFACE DISTRIBUTORS	450	169-A	450
	AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL STEARATE & EMCOL P-10-59)	50	155-A	50
	41 SHUT OFF PUMP	50	160-A	50
	42 STIR 30 MIN AT 178-182°F FOR S 48			
	DO NOT SHUT OFF AGITATOR			

EQUIP MENT	PAGE 3 CG 03 KY-907-D	240	USE LBS	N- CODE	ACCT LBS																														
SV	45	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN																																	
&		5 TO 10 MIN																																	
SP	44	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE																																	
9		PUMP																																	
	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																																	
SV	47	WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG																																	
&		DISCHARGE VALVE TO SV AND CLOSE VALVE TO																																	
SP		SEWER																																	
9	48	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,																																	
CONT		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 <u>3.1</u> (3.3-3.7)																																	
	56	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)																																	
		& RECORD: PH <u> </u>																																	
		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 <u>4.4</u> (4.2-4.4) & IF NECESSARY, ADJ																																	
		TO PH 4.2-4.4 & RECORD: PH <u> </u> . ASSUME 50%			7-D																														
		(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%			27-D																														
		SIPHON N-7-D INTO SV																																	
	59	OPERATOR STEP PB																																	
	60	OPERATOR STEP PB																																	
	61	SP STEP 60 - BATCH COMPLETE																																	
<table> <tr> <th colspan="2">START</th><th colspan="2">FINISH</th><th colspan="2">OPERATOR</th></tr> <tr> <th>TIME</th><th>SP STEP</th><th>TIME</th><th>SP STEP</th><th></th><th></th></tr> <tr> <td><u>11:00</u></td><td></td><td><u>7:11</u></td><td></td><td><u>120</u></td><td></td></tr> <tr> <td><u>2:00 PM</u></td><td></td><td><u>3:00 PM</u></td><td></td><td><u>237-438</u></td><td></td></tr> <tr> <td><u>11:00</u></td><td></td><td><u>2:40 A</u></td><td></td><td><u>114-120</u></td><td></td></tr> </table>						START		FINISH		OPERATOR		TIME	SP STEP	TIME	SP STEP			<u>11:00</u>		<u>7:11</u>		<u>120</u>		<u>2:00 PM</u>		<u>3:00 PM</u>		<u>237-438</u>		<u>11:00</u>		<u>2:40 A</u>		<u>114-120</u>	
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