S.V. 243, 244 (AUTOMATED) 240

CG 03 CODE KY-781-D PKG PROCESSES APPROVED BY:
OCT 27 1982 L2H66 4248* ( ) KY-781-D (N) FWP 10/19/82
(DATE) (LOT) (EST WGT) COMTYP JOB NAME: 03KY781DMN
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	K2B03	3300	___.__	---	---	------	-------
	14	YC-3	93	------	------	___.__	---	---	------	-------
	14	YC-3	93	------	------	___.__	---	---	------	-------

NON-BLEEDING

240 VAT mtg @ 2:45 PM

EQUIP		NAME : "KROLOR" YELLOW LIGHT	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, ADD CAUSTIC SODA			
&		SOLN. SET AGITATOR ON HIGH SPEED. ASSUME 50%	36	7-D	18
~~205~~	2	WEIGH SODIUM SILICATE IN DRUM & POUR IN	442	32-D	442
204	3	DUMP IN MONASTRAL RED B & STIR 5 MIN	66X50	YC-3-B	3300
		RECORD: START 1:35 PM LOT K2B03	------		
1		FIN 5:35 PM ----------	------		
		----------	------		
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER			
	5	THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	6	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~~ 204			
	7	RECORD: V-~~205~~ VOL 56 " & ADJ TO 45" (1662 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
204					
~~205~~	9	RUN 10"(514 G) WATER INTO V-240 & START AGITATR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 345 TOTAL MINUTES 180			
2		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	11	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	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
&		1 (V-243) OR POSITION 6 (V-244)			
CP	13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO	NOV 1 1982		
		REMOTE (TEMP IS SET AT 190-194*F)			
3	14	RECORD LEVELS LIQUID ALUM & SET R/M COUNTER #1			
		AS FOLLOWS: A. 11LG 34 % PRESET #3 70 GAL		115-A	374
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC1~~0~~ (N-27-D SULFURIC ACID 60% CONTROLLER IN			
		MANUAL) 0.90 GPM		27-D	373
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM			
		3FR10 (N-27-D/WATER) RATIO 0.7			
		~~3~~FC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM		32-D	2527
		~~3~~FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		~~3~~FC20 (N-32-D WATER) IN REMOTE			
		~~3~~FR10 (N-32-D/WATER) RATIO 0.9			

LOT: _____ COMTYP JOB NAME: 03KY781DMN PAGE 02 DATE PRINTED: 10/19/82

EQUIPMENT		PAGE 2 CG 03 KY-781-D 240	USE LBS	N-CODE	ACCT LBS
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 92% IF (35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 54" (2800 G)			
CP	19	RECORD PH 9.9. ADJ TO 11.4-11.6 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.5. ASSUME 50%	40	7-D	20
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
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 8:45 PM			
	27	DURING STRIKE RECORD: SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/41 (30 MIN) 9.4 9.3-10.0 9:15 PM			
		14/47 (60 MIN) 9.4 9.3-10.0 9:45			
		15/48 (2 HRS) 9.4 9.3-10.0 10:45			
		16/49 (3 HRS) 9.5 9.3-10.0 11:45			
		17/50 (FINAL) 7.8 7.5-8.5 12:30 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 ___. ASSUME 77%	____	27-D	____
385	28	RUN 49" (379 G) WATER INTO V-385			
6	29	ADD & STIR 5 MIN ASSUME 50%	124	7-D	62
	30	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	31	SIFT IN BLANC FIXE N	165	128-A	165
SV	32	SP STEP 23/53.			
	33	RECORD: PH 3.5 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH ___ NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%	_____	115-D	_____
SP	34	RUN IN N-7-D FROM S-29 IN 10-12 MIN, STIR 5 MIN			
7	35	RECORD: PH 4.1 (4.2-4.4). ADJ IF NECESSARY & RECORD: PH 4.2 ASSUME 77%	____	27-D	____
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	10	7-D	5
		(SIPHON N-7-D INTO SV)			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54-ADD PLASTOLEIN 9746A & STIR 5 MIN	40	978-A	40
	38	OPERATOR STEP PB			
	39	SP STEP 60. BATCH COMPLETE.			

	START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
	11:00 PM	_____	7:00 AM	_____	320
	11:00 PM	_____	1100 AM	_____	322-320

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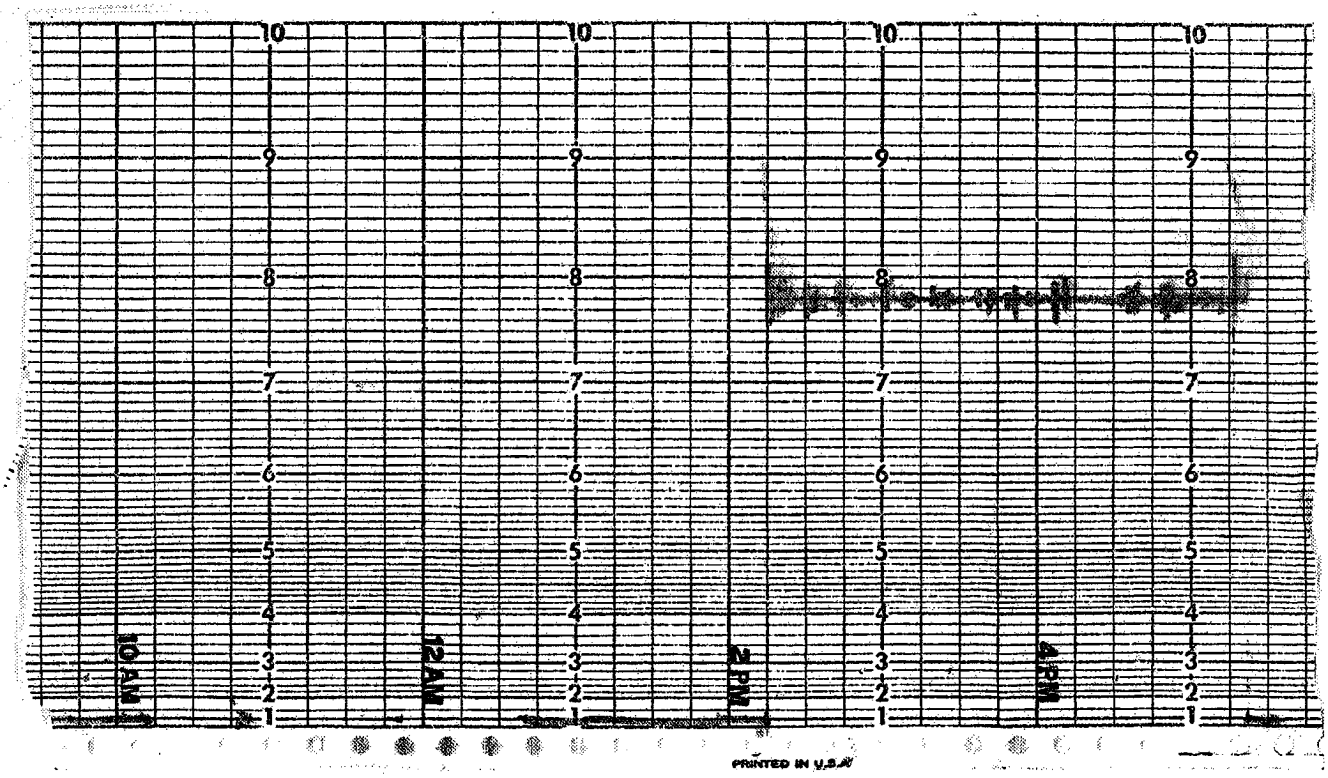
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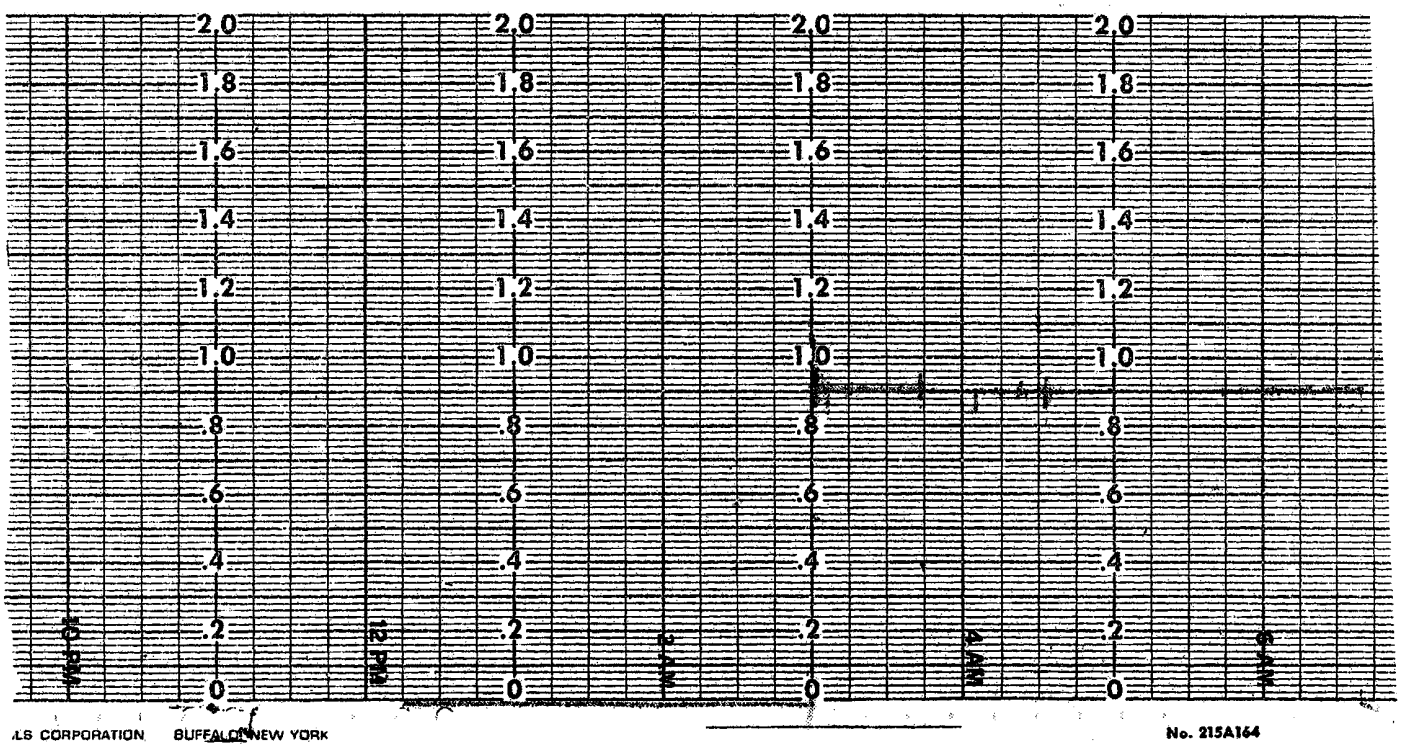

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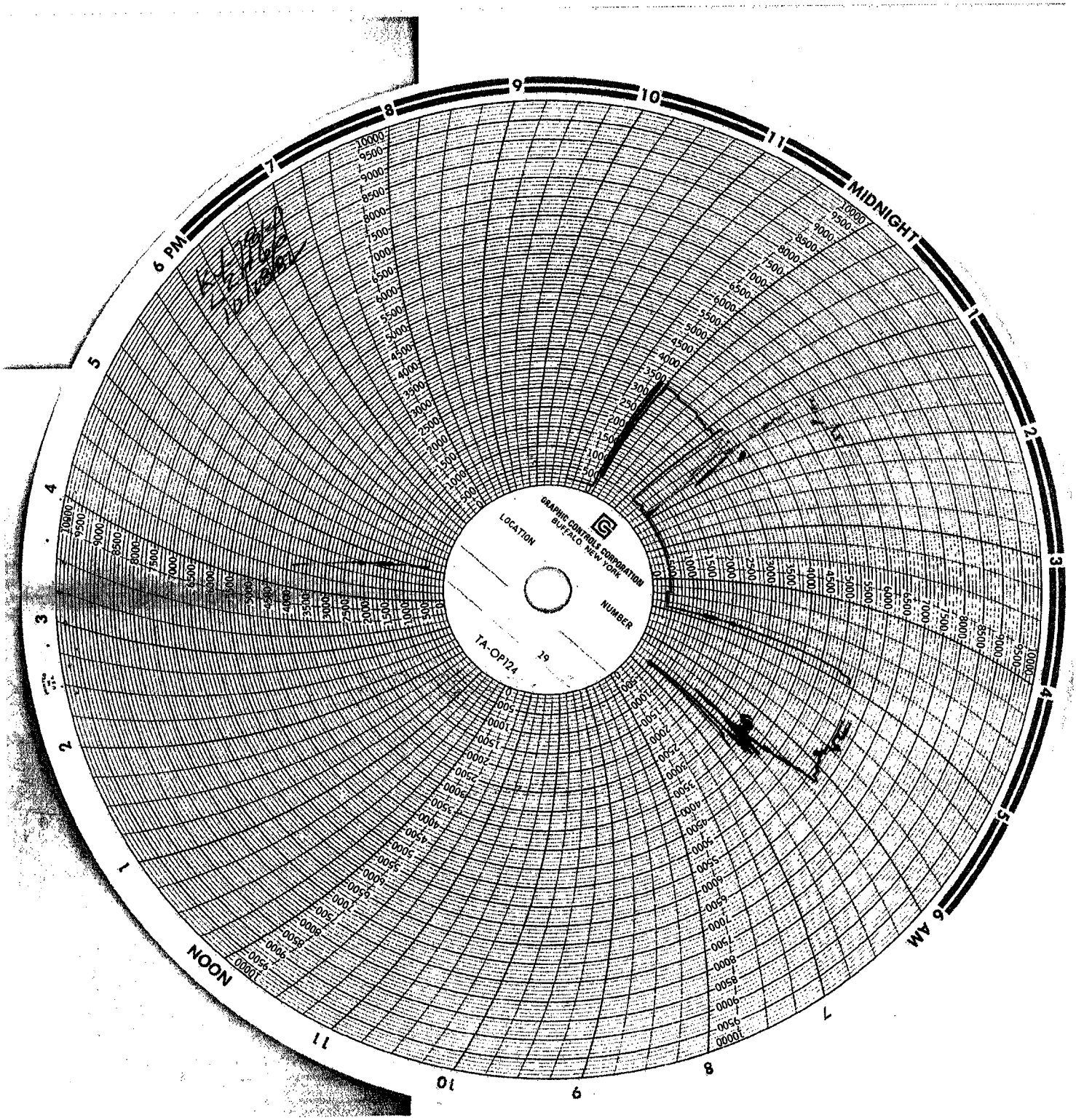

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