

CG 03 CODE KY-907-D EST WGT 4780* PROCESSES APPROVED BY:
 10/13/82 KAK07 7AM () KY-907-D (H) FWP 10/07/82
 (DATE) (LOT) (TIME) COMTYP JOB NAME: 03KY907DMH

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	14	YC-2	93							
	14	YC-2	93							
	14	YC-2	93							
	14	YC-2	93							

						NON-BLEEDING		
EQUIP MENT		NAME :				USE LBS	N- CODE	ACCT LBS
		"KROLOR" YELLOW-MEDIUM						
		"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						
1		RECORD: START						
		FIN						
	4	ADJUST TO 75" (1275 G)						
	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.						
		RECORD: TIME START TOTAL MINUTES						
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 & 1 (V-243) OR POSITION 6 (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 (LIQUID ALUM) & SET R/M COUNTER #1 AS FOLLOWS:						
		A. 11LG % PRESET #3 45 GAL					115-D	239
115		SET STRIKE FLOW CONTROLLERS AS FOLLOWS:						
		3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%) IN MANUAL 0.73 GPM					27-D	302
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 9.56 GPM						
		3FR10 (N-27-D/WATER) RATIO 1.31						
		8FC10 (N-32-D CONTROLLER) IN MANUAL .96 GPM					32-D	2022
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 8.45 GPM						
		8FC20 (N-32-D WATER) IN REMOTE						
		8FR10 (N-32-D/WATER) RATIO 1.76						

EQUIP MENT		PAGE 2 CG 03 KY-907-D	USE LBS.	N- CODE	ACCT LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG ____% IF BELOW 35% FOLLOW SOL 'N			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	118	ADJUST SV TO 48" (2470 G)			
CP	119	RECORD PH ____ ADJ TO 11.1-11.3 W/N-7-D (CAUSTIC			
		SODA SLN) AT 5% (10 PRTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH ____ ASSUME 50%		7-D	
	120	OPERATOR STEP PB			
	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH ____			
SV	122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	123	OPERATOR STEP PB			
	124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	125	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	126	OPERATOR STEP PB			
	127	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) ____ 9.0-10.0 ____			
		14/47 (60 MIN) ____ 9.0-10.0 ____			
		15/48 (2 HRS) ____ 9.0-10.0 ____			
		16/49 (3 HRS) ____ 9.0-10.0 ____			
		17/50 (FINAL) ____ 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%		27-D	
	128	SIFT IN (BLANC FIXE N)	55	128-A	55
385	129	ADD 27" (208 G) WATER TO V-385			
6	130	ADD & STIR FOR 2 MIN FOR S 57 ASSUME 50%	90	7-D	45
	131	DURING STRIKE CHECK LEVEL IN V-387.			
387	132	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	133	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING			
		THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	134	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW			
		STEARATE MAKE-UP PROCEDURE.			
	135	RUN IN 32" (317 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	136	TURN ON STEAM & AGITATOR			
8	137	ADJUST TO 42" (403 GAL) AT 178-182°F			
	138	SET BADGER METER FOR 550#			
	139	PUMP IN FROM V-387 THRU UNDRSURFACE DISTRIBUTORS	450	169-A	450
		AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL	50	155-A	50
		STEARATE & EMCOL P-10-59)	50	160-A	50
	140	SHUT OFF PUMP			
	141	STIR 30 MIN AT 178-182°F FOR S 48			
	142	DO NOT SHUT OFF AGITATOR			

EQUIP MENT	PAGE 3	CG 03	KY-907-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				
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 & STERATE 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%				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				
		START	FINISH	OPERATOR		
		TIME	SP STEP	TIME	SP STEP	
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PRODUCT NAME = KROLOR YELLOW - MEDIUM

NON-BLEEDING

5/14/82

CG 03 CODE KY-907-D PKG

PROCESSES:

APPROVED BY

KY-907-D (H)

FWP 12/19/82

LOT **K2K07**

TYPED BY KLV

MAKING NOTES

EST. WT. 4780* LBS.

JOB NAME: 03KY907DPH

INSTRUCTIONS

= PRESSING =

RECORD

VAT	DATE	TIME	RELEASED BY	PRESS	NO. OF CAKES	PRESS WITH	WASH TO 500 M MHOS	TEST AFTER 3 HOURS	LOAD ON 8 CARS	PRESSLOAD	STARTED	CAKES USED	WATER ON	HRS. WASHED	M MHOS	HRS. WASHED	M MHOS	HRS. WASHED	M MHOS	CAKE CONDITION	NO CARS LOADED	EXPLAIN LOSSES
				2	22	23	24	95														
					46	46	46	52														

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
MAX. TEMP. RPM
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