

CG 03

CODE KY-787-D

PKG

3444

OK

PROCESSES

APPROVED BY:

3404#

() KY-787-D (T)

FWP 09/27/82

(EST WGT)

COMTYP JOB NAME: 03KY787DMT

10/11/82
(DATE)

K2J99

(LOT)

3 Pm

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
①	==	=====	==	=====	=====	=====	=====	=====	=====	=====
				J8D-46	100.00					
				D2E 16	100.00					
					100.00					

BLEND BACK FOR STEP 43: KY-787-D, G2J99, 150# ON 6-3 OR GET FROM R/M.

EQUIP NAME: "KROCOR" YELLOW-MEDIUM USE LBS N-CODE ACCT LBS

203	1	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF.								
205	2	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.								
	3	WEIGH IN DRUM & POUR IN (SODIUM SILICATE)	250	32-D	250					
		DUMP IN AND STIR 5 MIN (CHROME YELLOW MEDIUM)	50X50	YC-2-B	2500					
		RECORD: START 11:40 AM LOT J8D-46	2000							
		FIN 11:50 AM D2E-16	500							
	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 50" & ADJ TO 60" (2100 G)								
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY								

205	9	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR								
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.								
		RECORD: TIME START 9:30/2 TOTAL MINUTES 180								
	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 72% PRESET #1 32 GAL (LIQUID ALUM)	115-D		168					
		B. 13LG 61% PRESET #6 141 GAL (CALCIUM CHLORIDE 77%)	20-A		141					
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:								
		3FC10 (N-27-D -SULFURIC ACID 60%- CONTROLLER) IN MANUAL 0.64 GPM	27-D		213					
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM								
		3FR10 (N-27-D/WATER) RATIO 1.31								
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.84 GPM	32-D		1425					
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM								
		8FC20 (N-32-D WATER) IN REMOTE								
		8FR10 (N-32-D/WATER) RATIO 1.76								
	16	OPERATOR STEP PB								

OCT 15 1982

10/14

EQUIP | PAGE 2 CG 03 KY-787-D **244** | USE | N- | USE
MENT | | | LBS. | CODE | LBS

320 | 17 | ~~RECORD LEVEL 2LG 57% IF BELOW 35% FOLLOW SOLN~~
SV | ~~MAKE-UP PROCEDURE FOR N-27-D~~
SP | 18 | ~~ADJUST SV TO 48° (2470 G)~~
CP | 19 | ~~RECORD PH 10.5. ADJ TO 11.1-11.3 WITH N-7-D~~
| | ~~(CAUSTIC SODA SOLN) AT 5% (10 PARTS WATER TO 1~~
4 | | ~~PART N-7-D)~~
4 | | ~~SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%~~ 7-D
120 | ~~OPERATOR STEP PB~~

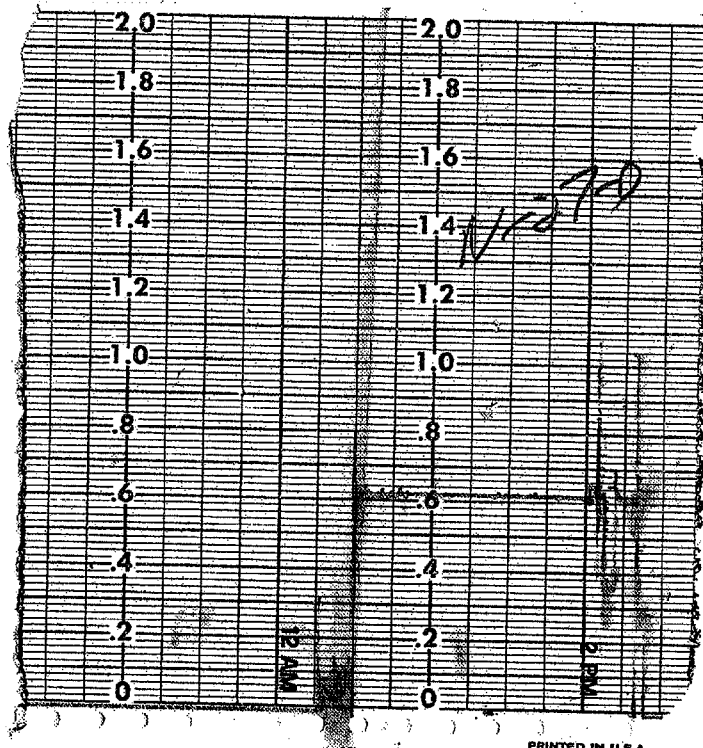
SV | 21 | ~~SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.2.~~
SV | 22 | ~~SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO~~
SP | 23 | ~~OPERATOR STEP PB~~
| 24 | ~~SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS~~ **NOTE**
| | ~~ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB~~ **AFTER 30 MIN 6.27**
5 | 25 | ~~SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN~~ **STOPPED**
| | ~~LIMITS, SWITCH 3FC20 TO REMOTE~~
| 26 | ~~OPERATOR STEP PB~~
| 27 | ~~DURING STRIKE RECORD:~~ **2.30**
| | ~~SP STEP~~
| | ~~V-243/V-244~~
| | 13/46 (30 MIN) PH RANGE TIME
| | 14/47 (60 MIN) 9.3 9.0-10.0 3.42
| | 15/48 (2 HRS) 9.7 9.0-10.0 3.30
| | 16/49 (2 HRS, 25 MIN) 9.0-10.0 4.30
| | 17/50 (FINAL 3 HRS) 7.5-8.5 5.30
| | ~~NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE~~ **NOTE** **10-32** **WHS**
| | ~~IN LOG. IF FINAL PH > 8.5, ADJ TO 7.5-8.5.~~ **STRIKE FOR 75 MIN**
| | ~~& RECORD: PH 8.25 ASSUME 77%~~ 20 27-D 15

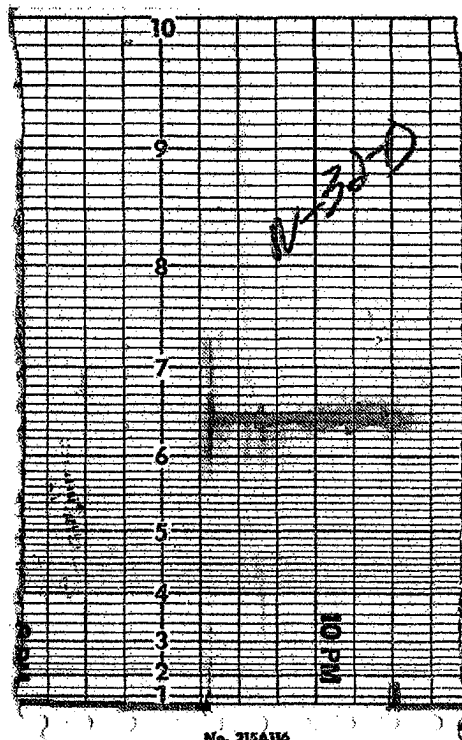
28 | ~~WHILE STRIKING RUN 30° (234 G) WATER INTO V-339~~
29 | ~~ADD IN 7-8 MIN. (DRESINATE X) CHECK FOR DRAFT~~ 365 530-A 365
| | ~~IN VENT STACK BEFORE DUMPING.~~
339 | 30 | ~~ADJ TO 49° (382 G) AT 80-100°F~~
6 | 31 | ~~STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)~~
| 32 | ~~STIR 15 MIN OR LONGER FOR SP STEP 26~~
| 33 | ~~RECORD: VOL 49° & CALC 49° X 0.78 = 38.2 GAL~~
| 34 | ~~SET PRESET #8 TO 38.2 GAL FROM S 33~~

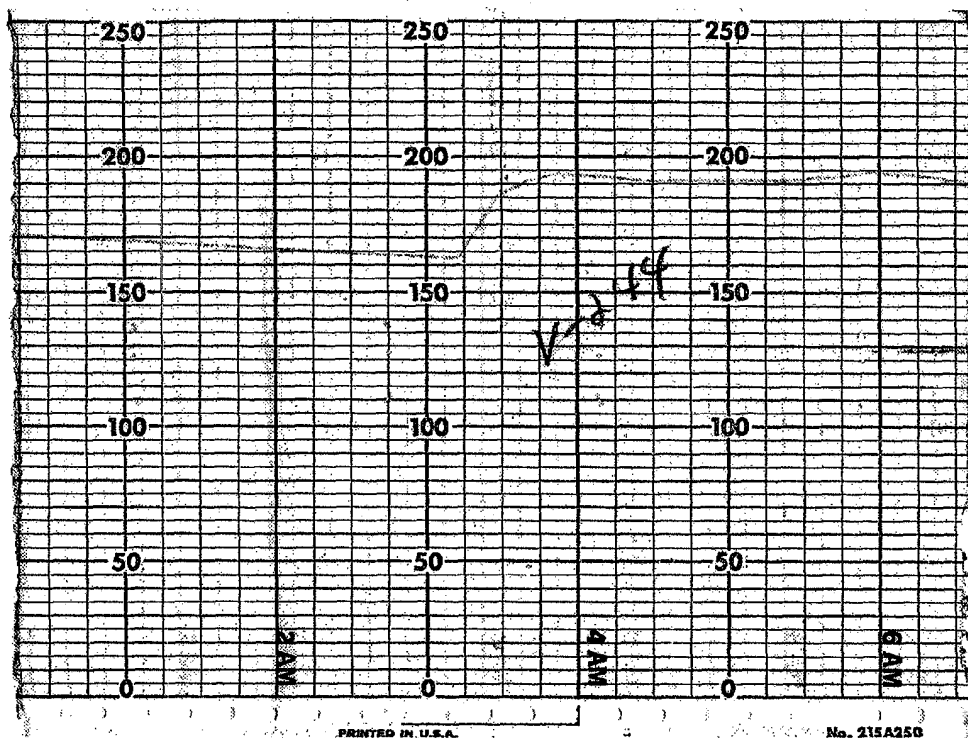
385 | 35 | ~~RUN 47° (360 G) WATER INTO V-385~~
7 | 36 | ~~ADD & STIR 2 MIN FOR S 40~~ 10 ASSUME 50% 160V 7-D 80

37 | ~~SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.~~
38 | ~~SIFT IN (BLANC FIXE N)~~ 410 128-A 110
SV | 39 | ~~SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)~~
SP | 40 | ~~RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5~~
| | ~~MIN~~
8 | 41 | ~~RECORD: PH 9.5 (9.0-9.5). ADJ IF NECESSARY &~~
| | ~~RECORD: PH _____ ASSUME 77%~~ 27-D
| | ~~(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%~~ 7-D
| | ~~(SIPHON N-7-D INTO SV)~~
42 | ~~OPERATOR STEP PB~~
43 | ~~SIFT IN BLEND BACK: KY-787-D, 62J99, 150 ✓~~
44 | ~~SP STEP 29/58. RECORD: PH 9.4 & TIME 6:10 PM~~
45 | ~~OPERATOR STEP PB~~
46 | ~~SP STEP 60. BATCH COMPLETE.~~

START 5:14 PM FINISH 11:00 PM OPT 54:00
TIME SP STEP 3:00 PM TIME SP STEP 6:00 PM 54:30 PM







PRODUCTION SCHEDULE WEEK ENDING OCTOBER 3, 1982

MARKING

SEPT.

OCT.

EQUIPMENT		MON. 27		TUES. 28		WED. 29		THURS. 30		FRI. 1	
VAT	PRESS	CODE	LOT	CODE	LOT	CODE	LOT	CODE	LOT	CODE	LOT
241	91	YC16	K2H14 K2H15	YC16		YC16		YE162 K2H21	K2H20 K2H21	YE735	
242	92	YC16	K2H16	YC16		YC16		XC16	K2H22	YE721	
245	92	YC16	K2H17	YC16		YC16		YC16	K2H23	YE721	
240	2/22	KY-787	K2H31	KY-787		KY-787		KY-787	K2H80	KY-787	
244	23	KY-787	K2H44	KY-787		KY-787		KY-787	K2H81	KY-787	
244	24	KY-787	K2H45	KY-787		KY-787		KY-787	K2H82		
246	93			KO-906				NO DATA			
246	25	KO-906	K2H27	KO-906		KO-906		KO-906	K2H30	KO-789	
180	37	BT-449	K2H34			BT-449				BT-449	
213	20/21	BT-445	J2L02	BT-427				BT-449		BT-427	
2020		BT-579	K2H05	BT-579				BT-579	K2H07	BT-579	
HF10		RC-1	K2H25								
181	33	RT-791	K2H36	RT-791		RT-791				RT-887	
282	38	RT-243	K2H37			RT-243		RT-243	K2H76		
ALM #3		RT-742	K2H38					RT-759	K2H74		
ALM #2		RW-252	K2H03								
260	32			RT-531		RT-531		RT-531		RT-531	
107	36	RT-695	K2H39			RT-695		RT-695	K2H55		
182	35	YT-714	K2H40	YT-714		YT-714		YT-562	K2H78	YT-562	
105											
901	96	RT-698	J2H266	RT-698		RT-698		RT-698	K2H77	RT-698	

V-244

To finish strike on KJ-787-D, K2J99:

- ① check ph V-244: 10.1
- ② add N-27-D thru auto-strike system until ph is in range 9.0-10.0.
- ③ When pH is in range, start N-32-D strike (continue N-27-D). Strike N-32-D for an additional 70 min.

Record: Time start 2:55 PM PM

(10 min) ph = 9.8 9.0-10.0 Time 3:05 PM

(20 min) ph = 9.8 9.0-10.0 Time 3:15

(40 min) ph = 9.8 9.0-10.0 Time 3:35

*1 hr, 10 min) ph = 9.8 9.0-10.0 Time 4:05

(1 hr, 45 min) ph = 9.7 7.5-8.5 Time 4:40 PM

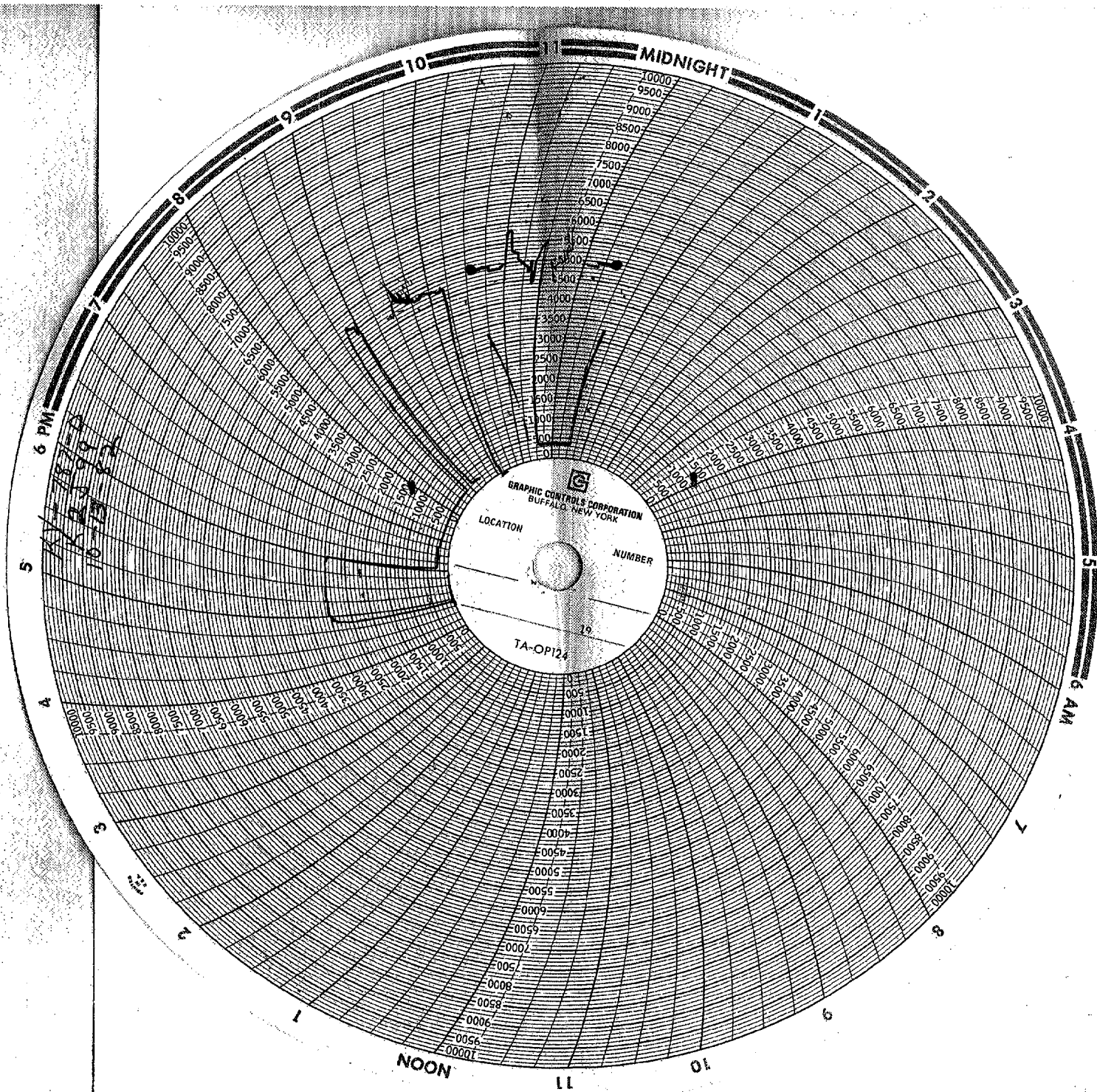
ADJUSTED P.H. 8.2

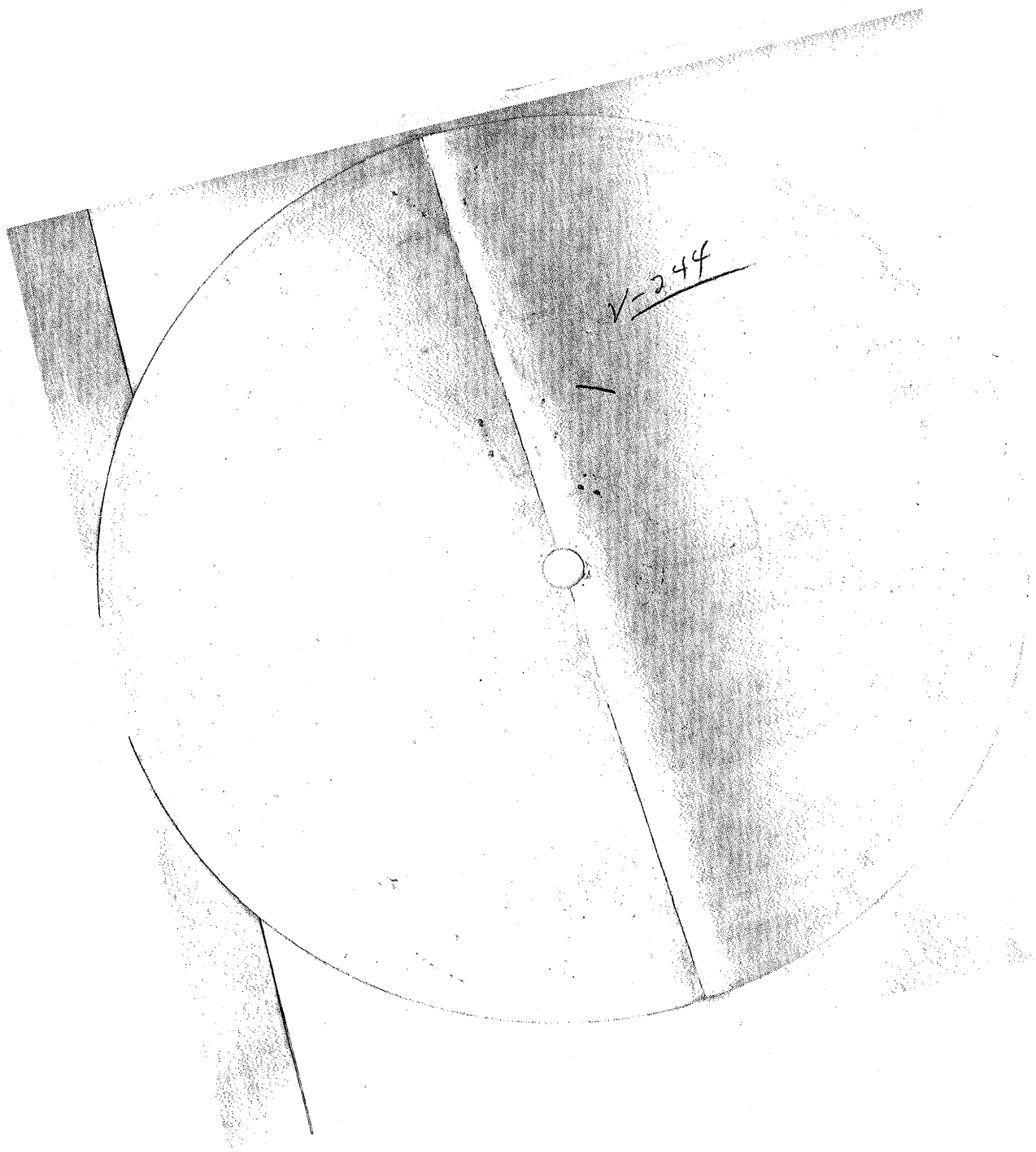
shut off N-32-D. Continue N-27-D for 35 min.

- ④ Step 28 on batch card.

Post

N-27-D pump was extremely loud & noisy, then shut strike off 8 min. early per J. Santos for mech. to check pump.





DUP050102757