

EQUIP MENT	PAGE 2	CG 03	KY-907-D	V-240	USE LBS	N- CODE	ACCT LBS
320	16	OPERATOR STEP PB					
SV	17	RECORD LEVEL 2LG 8.0% IF BELOW 35% FOLLOW SOL'N					
SP	18	MAKE-UP PROCEDURE FOR N-27-D					
CP	19	ADJUST SV TO 48" (2470 G)					
	19	RECORD PH 14.2. ADJ TO 11.1-11.3 W/N-7-D (CAUSTIC					
		SODA SLN) AT 5% (10 PRTS WATER TO 1 PART N-7-D)					
4		SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50%		40	7-D	20	
	20	OPERATOR STEP PB					
SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9					
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		12:50 PM			
	27	DURING STRIKE RECORD:					
		SP STEP					
		V-243/V-244					
		13/46 (30 MIN)	PH 9.0	RANGE 9.0-10.0	TIME 1:20 PM		
		14/47 (60 MIN)	9.0	9.0-10.0	1:50		
		15/48 (2 HRS)	9.3	9.0-10.0	2:50		
		16/49 (3 HRS)	9.3	9.0-10.0	3:50		
		17/50 (FINAL)	7.9	7.5-8.5	4:35 PM		
		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	
	28	SIFT IN (BLANC FIXE N)		55	128-A	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	
	31	DURING STRIKE CHECK LEVEL IN V-387.					
387	32	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35					
7	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.					
	35	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	36	TURN ON STEAM & AGITATOR					
8	37	ADJUST TO 42" (403 GAL) AT 178-182°F					
	38	SET BADGER METER FOR 550#					
	39	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	
	40	SHUT OFF PUMP					
	41	STIR 30 MIN AT 178-182°F FOR S 48					
	42	DO NOT SHUT OFF AGITATOR					

SV 243. ~~244~~ (AUTOMATED)

(240)

CG 03

CODE KY-907-D

EST WGT 4780*

PROCESSES

APPROVED BY:

OCT 14 1982

K2K56

M

() 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		J2D30	2020					
14	YC-2	93		J2D34	1550					
14	YC-2	93								
14	YC-2	93								

EQUIP MENT	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	NON-BLEEDING N- CODE	ACCT LBS
203 & 205	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO-CHLORIC ACID) IF ANY IS BLANKED OFF.* 1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED. 2 WEIGH IN DRUM & POUR IN (SODIUM SILICATE) 3 DUMP IN AND STIR 5 MIN (CHROME YELLOW) RECORD: START <u>11:30 A.M.</u> LOT <u>J2D30</u> FIN <u>12:30 A.M.</u> <u>J2D34</u> 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 <u>56</u> " & ADJ TO 60" (2100 G) 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY	355 71X50	32-D YC-2-B	355 3550
205	1 RUN 10" (514 G) WATER INTO V-240 & START AGITATOR SV 10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. 2 RECORD: TIME START <u>8:00 A.M.</u> TOTAL MINUTES <u>180</u> 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 & CP	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 1 (V-243) OR POSITION 6 (V-244) 13 PRESS SV CAM RESET PR - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F) 3 14 RECORD LEVELS (LIQUID ALUM) & SET R/M COUNTER AS FOLLOWS: 15 11LG <u>7.8</u> % PRESET #3 45 GAL SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER - SULFURIC ACID 60%) IN MANUAL 0.73 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 9.56 GPM 3FR10 (N-27-D/WATER) RATIO 1.31 3FC10 (N-32-D CONTROLLER) IN MANUAL .96 GPM 3FC20 (N-32-D WATER) IN MANUAL LOCAL 8.45 GPM 3FC20 (N-32-D WATER) IN REMOTE 3FR10 (N-32-D/WATER) RATIO 1.76			

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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 <u>3.4</u> (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 <u>4.2</u> (4.2-4.4) & IF NECESSARY, ADJ																							
	TO PH 4.2-4.4 & RECORD: PH <u>4.2</u> ASSUME 50%		7-D																					
	(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%	<u>10</u>	27-D	<u>8</u>																				
	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>OPERATOR</th></tr> <tr> <th>TIME</th><th>SP STEP</th><th>TIME</th><th>SP STEP</th><th></th></tr> <tr> <td><u>7:00 AM</u></td><td>-----</td><td><u>3:00 PM</u></td><td>-----</td><td><u>237</u></td></tr> <tr> <td><u>3:00 PM</u></td><td>-----</td><td><u>6:00 PM</u></td><td>-----</td><td><u>237</u></td></tr> </table>					START		FINISH		OPERATOR	TIME	SP STEP	TIME	SP STEP		<u>7:00 AM</u>	-----	<u>3:00 PM</u>	-----	<u>237</u>	<u>3:00 PM</u>	-----	<u>6:00 PM</u>	-----	<u>237</u>
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