

F2L36

4780*

APPROVED BY
() KY-907-D (H) FWP 06/15/82JUN 23 1982
(DATE)

(LOT)

(EST WGT)

COMTYP JOB NAME: 03KY907DMH

TYPED BY:

STANDARD HRS. 8.9 TIME _____ M

Note

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
14	Y-469-D	92		D2E27	3550	100	71	50	3550	3550
14	YC-2	93								
14	YC-2	93								
14	YC-2	93								

Warehouse Request (10870)

NON-BLEEDING

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

BEFORE USING SV, MAKE SURE THAT N-28-D LINE
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
3 DUMP IN AND STIR 5 MIN
RECORD: START 1:41
FIN 2:50 4.19

LOT
D2E27

355	32-D	355
71X50	Y-469-D	3550
3550		

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 56" & ADJ TO 60" (2100 G)

8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY

205 7 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 4:25 TOTAL MINUTES 75

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 12 PRESS SV CAM RESET PB - SET 22 TC IN AUTO
REMOTE (TEMP IS SET AT 190-194°F)

3 11 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:
A. 11LG 36% PRESET #3 45 GAL

JUL 22 1982

115-D 239

15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:

3FC10 (N-27-D CONTROLLER) IN MANUAL 0.73 GPM

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

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

27-D 302

32-D 2022

JUL 21

EQUIP MENT	PAGE 2 CG 03 KY-907-D	USE LBS	N- CODE	ACCT LBS
120	OPERATOR STEP PB			
320	RECORD LEVEL 2LG 95% IF BELOW 35% FOLLOW SOL 'N			
SV	MAKE-UP PROCEDURE FOR N-27-D			
SP	ADJUST SV TO 48" (2470 G)			
CP	RECORD PH 9.8. ADJ TO 11.1-11.3 WITH N-7-D AT			
	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	SIPHON INTO SV. RECORD: PH 16.4 ASSUME 50%	30	7-D	15
120	OPERATOR STEP PB			
121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8			
SV	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	OPERATOR STEP PB			
124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	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) 9.1 9.0-10.0 9.55A			
	14/47 (60 MIN) 9.6 9.0-10.0 10.25A			
	15/48 (2 HRS) 9.7 9.0-10.0 11.25A			
	16/49 (3 HRS) 9.7 9.0-10.0 12.25A			
	17/50 (FINAL) 8.3 7.5-8.5 1.30P			
	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%			
128	SIFT IN	55	27-D 128-A	55
385	ADD 27" (208 G) WATER TO V-385			
6	ADD & STIR FOR 2 MIN FOR S 57. ASSUME 50%	90	7-D	45
121	DURING STRIKE CHECK LEVEL IN V-387.			
387	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING			
	THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
124	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW			
	STEARATE MAKE-UP PROCEDURE.			
125	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	TURN ON STEAM & AGITATOR			
8	ADJUST TO 42" (403 GAL) AT 178-182°F			
128	SET BADGER METER FOR 550#			
129	PUMP IN FROM V-387 THRU UNDERSURFACE	450	169-A	450
	DISTRIBUTORS AS FAST AS POSSIBLE	50	155-A	50
		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 PAGE 3 CG 03 KY-907-D *V.-244* USE N- ACCT
MENT LBS CODE 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 & 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 <i>3.4</i> (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 <i>3.9</i> (4.2-4.4) & IF NECESSARY, ADJ			
		TO PH 4.2-4.4 & RECORD: PH <i>4.3</i> ASSUME 50%	<i>20</i>	7-D	<i>10</i>
		(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	
<i>3 AM</i>		<i>7 AM</i>		<i>282</i>
<i>7:00 AM</i>		<i>3:00 PM</i>		<i>37</i>
<i>3: PM</i>		<i>4:20 PM</i>		<i>57</i>





