

CG 03

CODE KY-907-D

EST WGT 4780*

PROCESSES

APPROVED BY:

OCT 14 1982

K2K55

M

01/1/82

() KY-907-D (H)

FWF 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	D2D43	2000	---	---	---	---	---
	14	YC-2	93	D2D44	1550	---	---	---	---	---
	14	YC-2	93	---	---	---	---	---	---	---
	14	YC-2	93	---	---	---	---	---	---	---

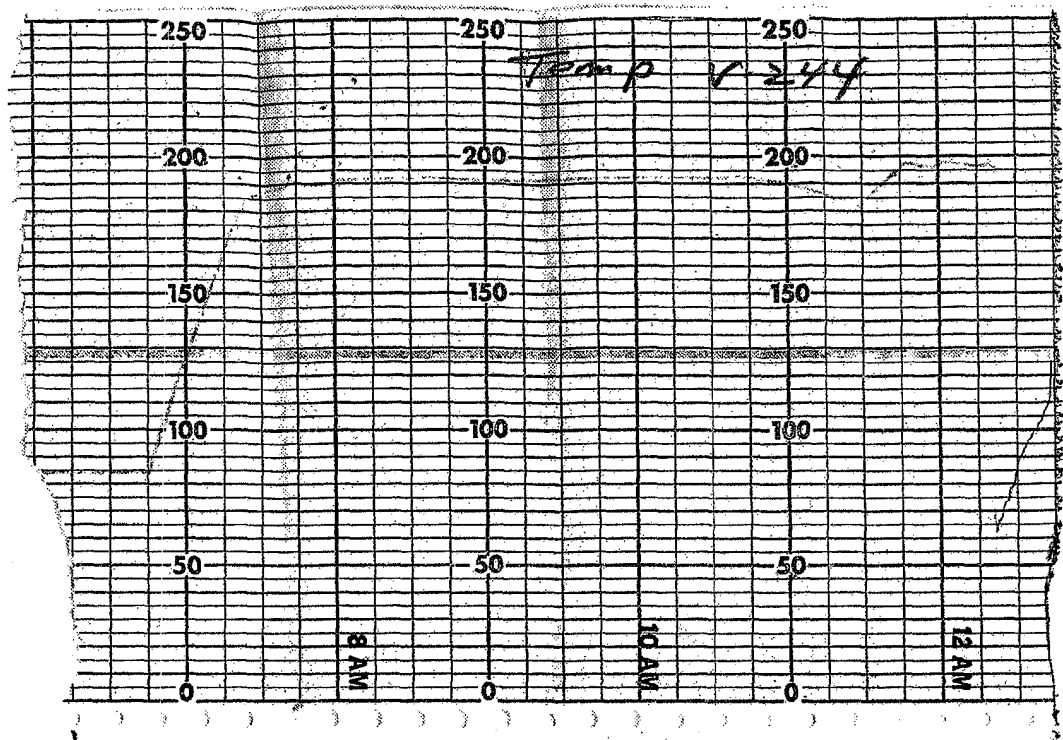
					NON-BLEEDING		
EQUIP MENT		NAME			USE LBS	N- CODE	ACCT LBS
		"KROLOR" YELLOW-MEDIUM					
		"BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO- CHLORIC ACID) IF ANY IS BLANKED OFF."					
203 & 205	1	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.					
	2	WEIGH IN DRUM & POUR IN (SODIUM SILICATE)			355	32-D	355
	3	DUMP IN AND STIR 5 MIN (CHROME YELLOW)			71X50	YC-2-B	3550
		RECORD: START <u>7:14 M.</u> LOT <u>D2D43</u>			<u>2000</u>		
		FIN <u>8:30 AM.</u> <u>D2D44</u>			<u>1550</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>46</u> " & ADJ TO 60" (2100 G)					
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY					
205	9	RUN 10" (514 G) WATER INTO V- <u>244</u> & START AGITATOR					
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>1:15 A</u> TOTAL MINUTES <u>9</u>					
	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 & CP	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 1 (V-243) OR POSITION 6 (V-244)					
	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. 11LC <u>76</u> % PRESET #3 45 GAL				115-D	239
	15	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					
		3PC10 (N-32-D CONTROLLER) IN MANUAL .96 GPM				32-D	2022
		3PC20 (N-32-D WATER) IN MANUAL LOCAL 8.45 GPM					
		3PC20 (N-32-D WATER) IN REMOTE					
		3ER10 (N-32-D/WATER) RATIO 1.76					

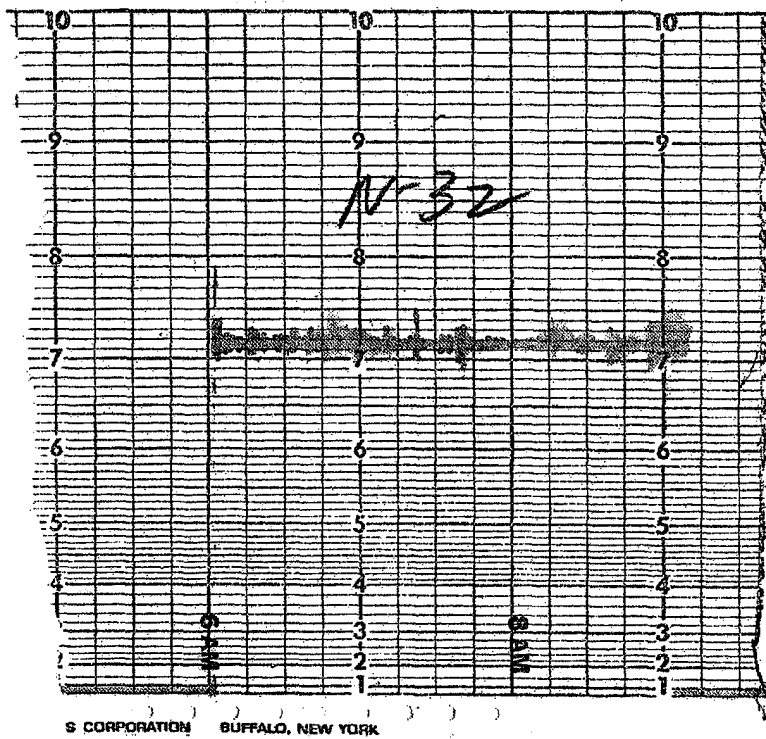
OCT 20 1982

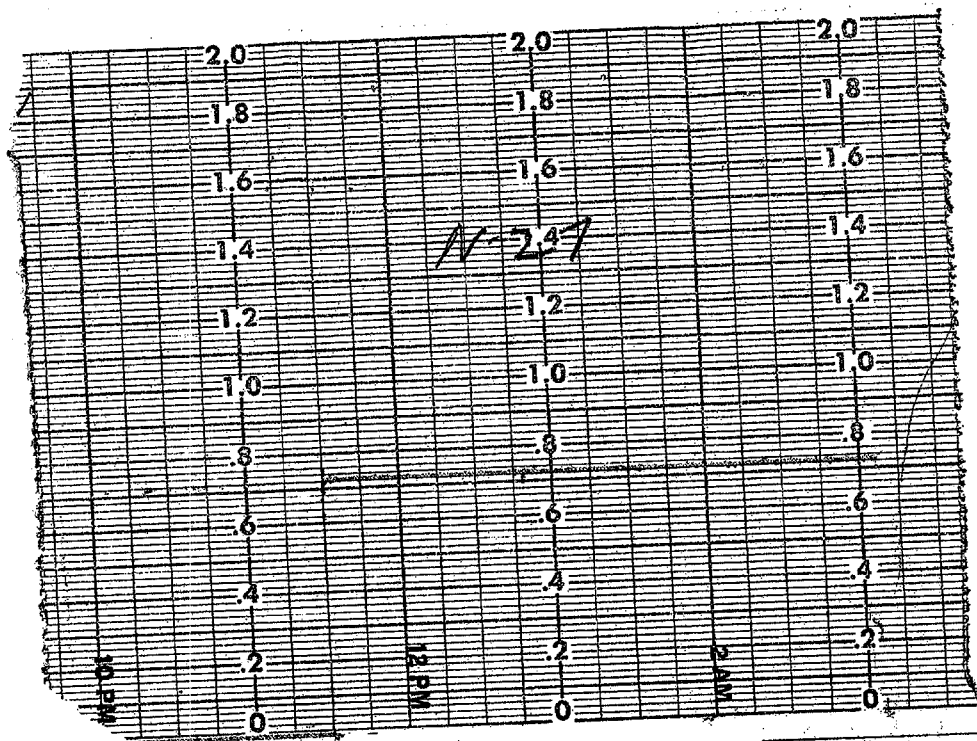
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EQUIP MENT	PAGE 2 CG 03 KY-907-D	USE LBS	N- CODE	ACCT LBS
320	14 OPERATOR STEP PB			
SV	17 RECORD LEVEL 2LG 6% IF BELOW 35% FOLLOW SOL'N			
SP	18 MAKE-UP PROCEDURE FOR N-27-D			
CP	19 ADJUST SV TO 48" (2470 G)			
4	19 RECORD PH 9.6 ADJ TO 11.1-11.3 W/N-7-D (CAUSTIC SODA SLN) AT 5% (10 PRTS WATER TO 1 PART N-7-D)			
	20 SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%		7-D	
	20 OPERATOR STEP PB			
SV	21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5			
SP	22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	23 OPERATOR STEP PB			
5	24 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
	25 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	26 OPERATOR STEP PB			
	27 DURING STRIKE RECORD:			
	SP STEP			
	V-243/V-244			
	13/46 (30 MIN)	PH 9.4 RANGE 9.0-10.0 TIME 5:35		
	14/47 (60 MIN)	9.4 9.0-10.0 6:05		
	15/48 (2 HRS)	9.5 9.0-10.0 7:05		
	16/49 (3 HRS)	9.5 9.0-10.0 8:05		
	17/50 (FINAL)	8.0 7.5-8.5 8:50		
	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 AS FAST AS POSSIBLE (ISOBUTYL STEARATE, BUTYL STEARATE & EMCOL P-10-59)	450	169-A	450
		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 MENT	PAGE 3 CG 03 KY-907-D	USE LBS	N- CODE	ACCT LBS																				
SV	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN																							
&	5 TO 10 MIN																							
SP	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE																							
9	PUMP																							
	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP																							
	INLET																							
	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER																							
	THRU HOMOG AT 2900-3100 PSI TO SEWER																							
SV	WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG																							
&	DISCHARGE VALVE TO SV AND CLOSE VALVE TO																							
SP	SEWER																							
9	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.																							
	WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE																							
	AT STEARATE PUMP ASAP																							
	WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT																							
	WATER FROM HOT WATER MIXER																							
	WHEN S50 COMPLETE TURN OFF HOMOG & STERATE PUMP																							
	STIR 5 MIN AT 198-200°F																							
	SHUT OFF STEAM																							
	WHEN S53 COMPLETE, OPERATOR PB																							
	SP STEP 23/53 RECORD PH <u>3.7</u> (3.3-3.7)																							
	IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)																							
	& RECORD: PH <u> </u>																							
	NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA																							
	BADGER METER. STIR 5 MIN AFTER EACH																							
	ADDITION. ASSUME 50%		115-D																					
	RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN																							
	RECORD: PH <u>4.3</u> (4.2-4.4) & IF NECESSARY, ADJ																							
	TO PH 4.2-4.4 & RECORD: PH <u> </u> ASSUME 50%		7-D																					
	(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%		27-D																					
	SIPHON N-7-D INTO SV																							
	OPERATOR STEP PB																							
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	SP STEP 60 - BATCH COMPLETE																							
<table><tr><td colspan="2">START</td><td colspan="2">FINISH</td><td>OPERATOR</td></tr><tr><td>TIME</td><td>SP STEP</td><td>TIME</td><td>SP STEP</td><td></td></tr><tr><td><u>11P</u></td><td></td><td><u>7A</u></td><td></td><td><u>120</u></td></tr><tr><td><u>7:00 AM</u></td><td></td><td><u>11:00 PM</u></td><td></td><td><u>237-438</u></td></tr></table>					START		FINISH		OPERATOR	TIME	SP STEP	TIME	SP STEP		<u>11P</u>		<u>7A</u>		<u>120</u>	<u>7:00 AM</u>		<u>11:00 PM</u>		<u>237-438</u>
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10N- BUFFALO, NEW YORK

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