

CG 03 CODE KY-781-D PKG.

JAN 25 34022

EST. WGT. 1328-1128 LBS.

STD. HRS. TIME 11 P M

14 YC-3-B 93 4 24411 3100 # JB

14 YC-3-B 93 4 #

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Total Wgt. 4428# (Req )

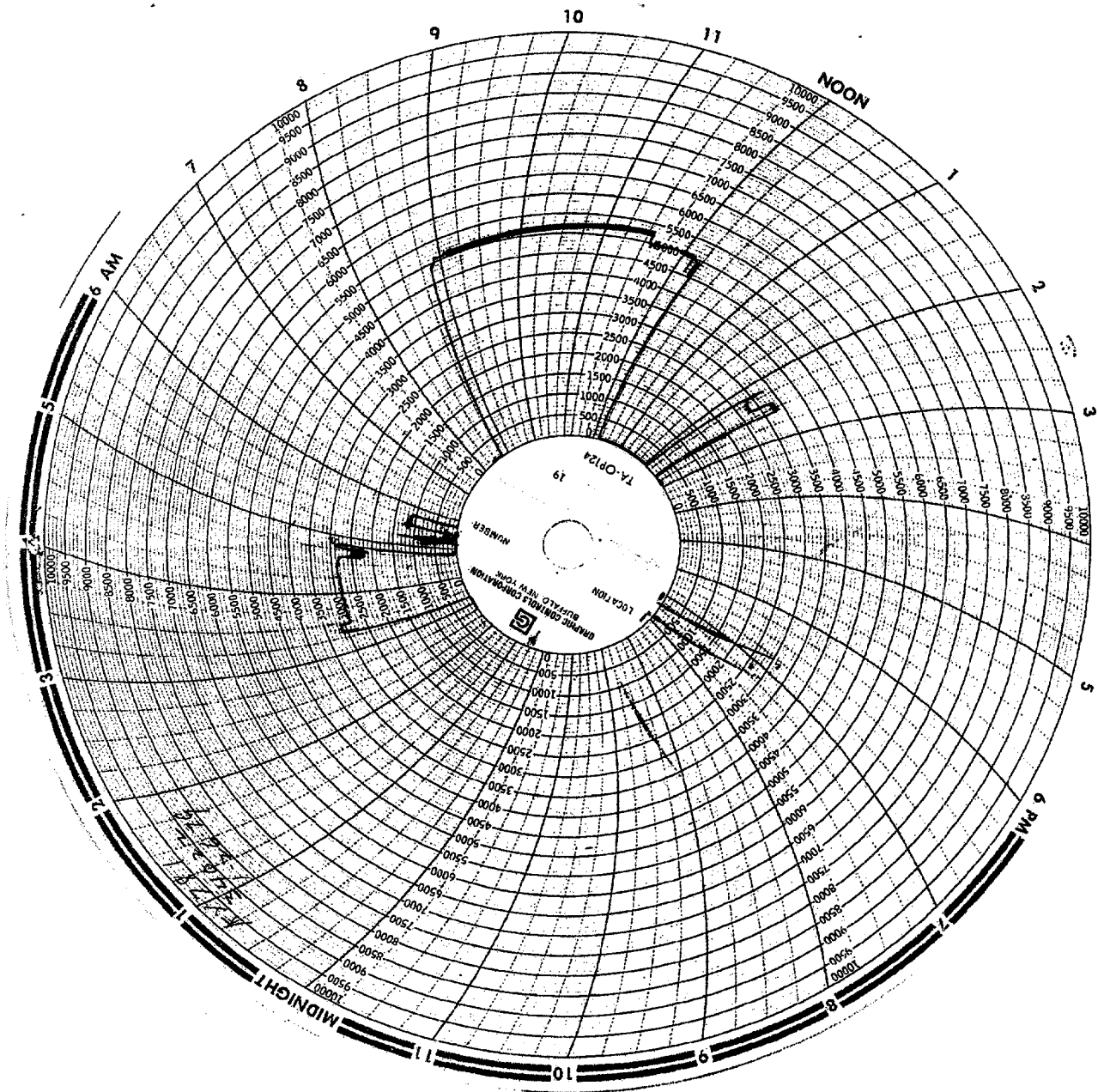
| PROCESSES        | APPROVED BY |
|------------------|-------------|
| ( ) KY-781-D (N) | FWP 101378  |
| ( ) ( )          | AMJ 101378  |
| ( ) ( )          |             |
| ( ) ( )          |             |
| TYPED BY         |             |
| emw101378        |             |

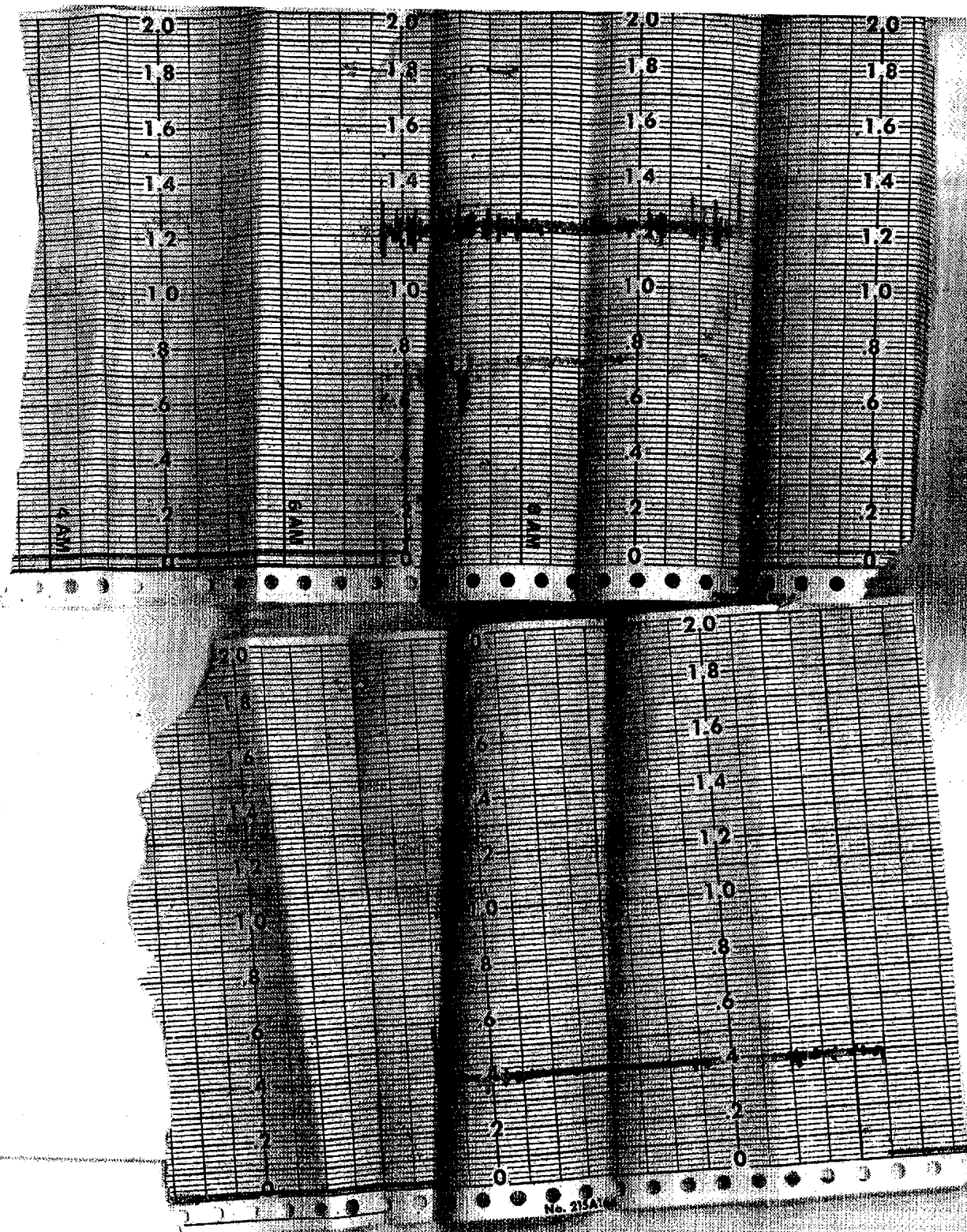
NON-BLEEDING

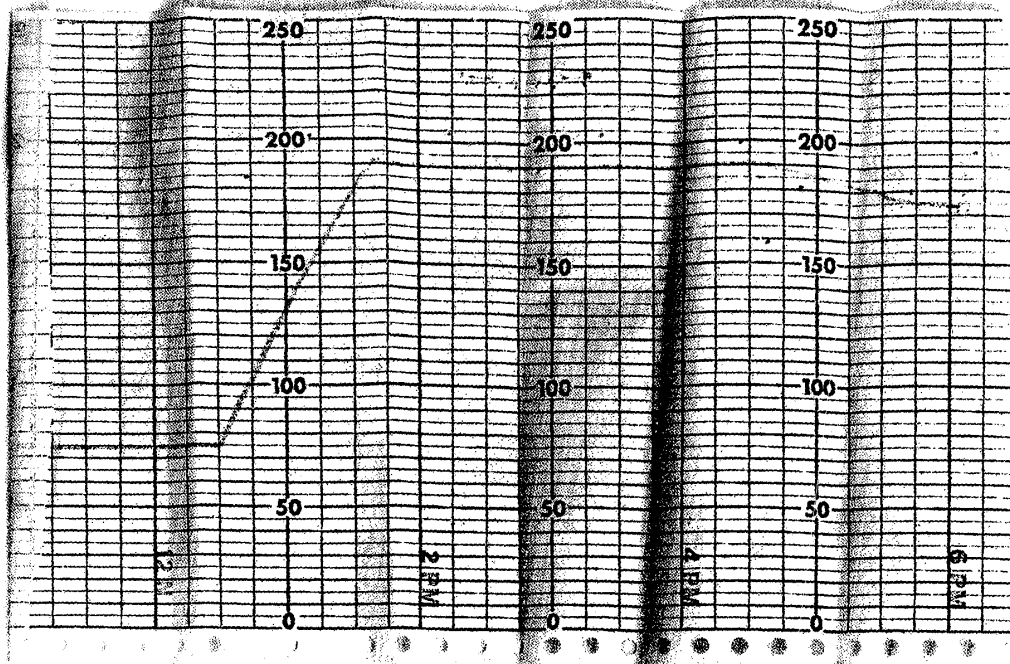
| EQUIPMENT  | NAME:                                                                                      | USE LBS. | N CODE | ACCT. LBS. |
|------------|--------------------------------------------------------------------------------------------|----------|--------|------------|
| 203 & 205  | KROLO® YELLOW LIGHT                                                                        |          |        |            |
| 1          | 1 Run 60" (992 G) water in V-203 & add Assume 50%                                          | 36       | 7-D    | 18         |
|            | 2 Weigh in drum & pour in                                                                  | 442      | 32-D   | 442        |
|            | 3 Dump in & stir 5 min Lot 62                                                              | 66x50    | YC-3-B | 3300       |
|            | Record: Start 12:30 P YC-3 24411                                                           | 3100     |        | 3100       |
|            | Fin 11:50 P                                                                                |          |        |            |
|            | 75" (1275) 2400-2600                                                                       |          |        |            |
|            | 4 Adj to 80" (1360 G) & Record: pH 11.0 (10.5-11.5)                                        |          |        |            |
|            | 5 Pump V-203 thru Homog # at 1800-2200 psi into V-205                                      |          |        |            |
|            | 6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water                |          |        |            |
|            | 7 Record: V-205 Vol 41. " & adj to 45" (1662 G)                                            |          |        |            |
|            | 8 Inspect Homog strainer & clean if necessary                                              |          |        |            |
| 205 & SV   | 9 Run 12" (200 G) water into SV & start agitator                                           |          |        |            |
| 2          | 10 Pump V-205 thru Homog at 4800-5200 psi into V-243                                       |          |        |            |
|            | Record: Time Start 3:15 AM Total Min 190                                                   |          |        |            |
|            | NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205 |          |        |            |
|            | 11 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi            |          |        |            |
| SP & CP    | 12 SP Step 01 - Set Formula Selector to position #1 (V-243) or #6 (V-244)                  |          |        |            |
| 3          | 13 Press SV Cam Reset PB-Set 22TC in Auto Remote (Temperature is set at 190-194°F)         |          |        |            |
|            | 14 Record levels and set Raw Material Counter #1 as follows:                               |          |        |            |
|            | a) 11G.52% - preset #3 187 Gal                                                             |          | 15-A   | 374        |
|            | 15 Set strike flow controllers as follows:                                                 |          |        |            |
|            | a) 3FC10 (N-27-D Controller) in Manual 0.9 GPM                                             |          | 27-D   | 373        |
|            | b) 3FC20 (N-27-D Water) in Manual Local 6.3 GPM                                            |          |        |            |
|            | c) 3FR10 (N-27-D / Water Ratio) 0.7                                                        |          |        |            |
|            | d) 8EC10 (N-32-D Controller) in Manual 1.20 GPM                                            |          | 32-D   | 2527       |
|            | e) 8FC20 (N-32-D Water) in Manual Local 5.4 GPM                                            |          |        |            |
|            | f) 8EC20 (N-32-D Water) in Remote                                                          |          |        |            |
|            | g) 8FR10 (N-32-D / Water Ratio) 0.9                                                        |          |        |            |
| SV SP & CP | 16 Operator Step PB                                                                        |          |        |            |
| 4          | 17 Record Level 2LG 94%. If below 35% follow solution make-up procedure for N-27-D         |          |        |            |
|            | 18 Adj 60 SV to 54" (2800 G)                                                               |          |        |            |
|            | 19 Record: pH 10.4                                                                         |          |        |            |
|            | 20 Adj pH to 11.4-11.6 using Assume 50%                                                    | 38       | 7-D    | 19         |
|            | (Dilute to 5% (10 parts water to 1 part N-7-D)                                             |          |        |            |
|            | Siphon into SV. Record: pH 11.5                                                            |          |        |            |
|            | 21 Operator Step PB                                                                        |          |        |            |

N 27609

| EQUIPMENT | PAGE | CG                                                              | 03 CODE               | KY-781-D     | N EST. WGT. | 1128 LBS. | USE<br>LBS. | N<br>CODE | ACCT<br>LBS. |
|-----------|------|-----------------------------------------------------------------|-----------------------|--------------|-------------|-----------|-------------|-----------|--------------|
| SV        | 22   | SP Step 06/39.                                                  | After heat up Record: | pH 9.9       | (9.6-10.2)  |           |             |           |              |
| SP        | 23   | Switch 3FC20, 8FC10, 8FC20,                                     | to Auto               |              |             |           |             |           |              |
| &         | 24   | Operator Step PB                                                |                       |              |             |           |             |           |              |
| CP        | 25   | SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flow in limits   |                       |              |             |           |             |           |              |
| 5         |      | switch 3FC10 to Auto. Operator Step PB                          |                       |              |             |           |             |           |              |
|           | 26   | SP Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20 |                       |              |             |           |             |           |              |
|           |      | to Remote. Operator Step PB                                     |                       |              |             |           |             |           |              |
|           | 27   | During Strike, Record pH & Time as follows:                     |                       |              |             |           |             |           |              |
|           |      | SP Step                                                         | pH                    | Range        | Time        |           |             |           |              |
|           |      | 13/41 (30 min)                                                  | 9.8                   | 9.3-10.0     | 11:00 AM    |           |             |           |              |
|           |      | 14/47 (60 min)                                                  | 9.8                   | 9.3-10.0     | 11:30 AM    |           |             |           |              |
|           |      | (2 hrs)                                                         | 9.8                   | 9.3-10.0     | 12:30 PM    |           |             |           |              |
|           |      | (3 hrs)                                                         | 9.8                   | 9.3-10.0     | 1:30 PM     |           |             |           |              |
|           |      | 17.50 (Final)                                                   | 8.8                   | 7.5- 8.5     | 2:15 PM     |           |             |           |              |
|           |      | NOTE: If pH not as specified notify Supervisor & note in log.   |                       |              |             |           |             |           |              |
|           |      | If final pH is above (8.5) Adj to pH 7.5-8.5                    |                       |              |             |           |             |           |              |
|           |      | M                                                               | %                     |              |             |           |             | 27-D      |              |
| V-302     | 28   | Add 31" (379 G) water to V-302                                  |                       |              |             |           |             |           |              |
| 6         | 29   | Add & stir 5 min                                                |                       |              | Assume 50%  |           | 124         | 7-D       | 62           |
| SV        | 30   | SP Step 17/50 after checking pH. Operator PB                    |                       |              |             |           |             |           |              |
| SP        | 31   | SP Step 23/53 Record: pH 3.5                                    | (3.3-3.7)             |              |             |           |             |           |              |
| &         | 32   | If necessary adj pH (DOWN ONLY) Record: pH                      |                       |              |             |           |             | 15-A      |              |
| CP        |      | NOTE: Dissolve extra N-15-A in water at 110-120°F in drum       |                       |              |             |           |             |           |              |
| 7         |      | Use ±30 Gal of water to 50% N-15-A. Stir SV 5 min               |                       |              |             |           |             |           |              |
|           |      | after each addition                                             |                       |              |             |           |             |           |              |
|           | 33   | Sift in                                                         |                       |              |             |           | 320-150     | 128-A     | 350          |
|           | 34   | Run in N-7-D from S 29 & stir 5 min                             |                       |              |             |           |             |           |              |
|           | 35   | Record: pH 3.7                                                  | (4.2-4.4)             |              |             |           |             |           |              |
|           | 36   | If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts    |                       |              |             |           |             |           |              |
|           |      | H <sub>2</sub> O to 1 part N-7-D) or N-27                       |                       |              |             |           |             |           |              |
|           |      | M                                                               | %                     |              |             |           |             | 27-D      |              |
|           |      | Siphon (if N-7-D) into SV. Record: pH 4.8                       |                       |              |             |           | Assume 50%  | 36        | 7-D          |
|           | 37   | Operator Step PB                                                |                       |              |             |           |             |           |              |
|           | 38   | SP Step 24/58 - Add N-978-A & stir 15 min                       |                       |              |             |           |             | 20        | 978-A        |
|           | 39   | Operator Step PB                                                |                       |              |             |           |             |           |              |
|           | 40   | SP Step 60 - Batch Complete                                     |                       |              |             |           |             |           |              |
|           |      | START                                                           |                       | FIN          |             | OPTR      |             |           |              |
|           |      | TIME SP STEP                                                    |                       | TIME SP STEP |             |           |             |           |              |
|           |      | 3:00 PM                                                         |                       | 11:00 PM     |             | 409-938   |             |           |              |
|           |      | 7:00 PM                                                         |                       | 3:00 PM      |             | 320-144   |             |           |              |
|           |      | 3:00 PM                                                         |                       | 2:45 PM      |             | 438-909   |             |           |              |
|           |      | <i>Pumped to V-240 via Steam Pump</i>                           |                       |              |             |           |             |           |              |







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