

CG 03
OCT 26 1982

CODE KY-781-D PKG

L2H49

4248*

PROCESSES
() KY-781-D (N)
COMTYP JOB NAME: 03KY781DMNAPPROVED BY:
FWP 10/19/82

(DATE)

(LOT)

(EST WGT)

STANDARD HRS.

TIME ____ M

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	14	YC-3	93							
	14	YC-3	93							
	14	YC-3	93							

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	N- CODE	ACCT LBS
203	*BEFORE USING SV MAKE SURE N-28-D LINE (HYDRO- CHLORIC ACID) IF ANY IS BLANKED OFF*			
205	1 RUN 60" (990 G) WATER IN V-203, ADD CAUSTIC SODA SOLN. SET AGITATOR ON HIGH SPEED. ASSUME 50% 2 WEIGH SODIUM SILICATE IN DRUM & POUR IN 3 DUMP IN MONASTRAL RED B & STIR 5 MIN RECORD: START 8:20 AM LOT D2D12 FIN 9:15 AM JAB 07	36 442 66X50 2600 700	7-D 32-D YC-3-B	18 442 3300
205	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 52" & ADJ TO 45" (1662 G) 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATR PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 9:00 AM 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 (V-243) OR POSITION 6 (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 LIQUID ALUM & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 52% PRESET #3 70 GAL 15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D SULFURIC ACID 60% CONTROLLER IN MANUAL) 0.90 GPM 3EC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM 3FR10 (N-27-D/WATER) RATIO 0.7 8FC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM 8EC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM 8FR10 (N-32-D WATER) IN REMOTE 0.9			
			115-A	374
			27-D	373
			32-D	2527

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EQUIP PAGE 2 CG 03 KY-781-D *V-244* USE N- ACCT
MENT LBS CODE LBS

16 OPERATOR STEP PB
SV 17 RECORD LEVEL 2LG *50%* IF <35% FOLLOW SOLUTION
SP MAKE-UP PROCEDURE FOR N-27-D
CP 18 ADJUST SV TO 54" (2800 G)
19 RECORD PH *9.6*. ADJ TO 11.4-11.6 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 20 SIPHON INTO SV. RECORD: PH *11.6* ASSUME 50% *40* 7-D *20*
20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH *10.0*
SV 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 23 OPERATOR STEP PB *12:45 P*
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
27 DURING STRIKE RECORD:
SP STEP

V-243/V-244

	PH	RANGE	TIME
13/41 (30 MIN)	<i>9.6</i>	9.3-10.0	<i>1:45 P</i>
14/47 (60 MIN)	<i>9.6</i>	9.3-10.0	<i>1:45 P</i>
15/48 (2 HRS)	<i>9.5</i>	9.3-10.0	<i>2:45 P</i>
16/49 (3 HRS)	<i>9.5</i>	9.3-10.0	<i>3:45 P</i>
17/50 (FINAL)	<i>8.0</i>	7.5-8.5	<i>4:13 P</i>

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 _____

385 28 RUN 49" (379 G) WATER INTO V-385
6 29 ADD & STIR 5 MIN ASSUME 50% *124* 7-D *62*

30 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
SV 31 SIFT IN BLANC FIXE N *165* 128-A *165*
32 SP STEP 23/53
33 RECORD: PH *3.7* (3.3-3.7) & IF NECESSARY ADJ
(DOWN ONLY) TO 3.3-3.7 & RECORD: PH _____
NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
BADGER METER. STIR 5 MIN AFTER EACH ADDITION.
ASSUME 50% _____ 115-D _____

SP 34 RUN IN N-7-D FROM S-29 IN 10-12 MIN, STIR 5 MIN
7 35 RECORD: PH *4.2* (4.2-4.4). 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)

36 OPERATOR STEP PB
37 SP STEP 24/54-ADD PLASTOLEIN 9746A & STIR 5 MIN *40* 978-A *40*
38 OPERATOR STEP PB
39 SP STEP 60. BATCH COMPLETE.

START TIME SP STEP	FINISH TIME SP STEP	OPTR
<i>9:00</i>	<i>3:00 P</i>	<i>126</i>
<i>3:00 P</i>	<i>5:15</i>	<i>237-282</i>







