PUNCHED & CHECKED

(AUTOMATED) JUN 17 '80 16 880

S.V. ~~243~~, 244 C.V. MAKING INSTRUCTIONS: BATCH UNIT D.V.

CG 03 CODE KY-795-D PKG

LOT JUN-12 36093

EST'D WGT 880 LBS

STANDARD HRS. 8.2 TIME 7AM

OK/AP

PROCESSES APPROVED BY
( ) KY-795-D (H) FWP 5/1/80
( ) 3/4 N-32-D STRIKE TO
( ) IMPROVE GLOSS
( ) ( )
( ) ( )
TYPED BY: FWP 5/1/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	82204-3	93	3500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

Use re-ground YC-2-B as per warehouse request.

TOTAL EST'D WGT 4380 (Req 3450) NON-BLEEDING

QUIP		NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N-CODE	ACCT LBS
03 & 05	1	RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	475	32-D	475
	3	DUMP IN AND STIR 5 MIN LOT See above.	70X50	YC-2-B	3500
		RECORD: START 12:15 82204-3	3500		
		FIN 1:30pm			
V263	4	ADJUST TO 75" (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-~~205~~ 263			
	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 ____" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
05	9	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 7:10 TOTAL MINUTES 100			
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 5 (V-243) OR POSITION 10 (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 & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG ____% PRESET #1 104 GAL		15-A	208
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.71 GPM		27-D	296
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
		3FR10 (N-27-D/WATER) RATIO 0.8			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM		32-D	1885
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.0			

JM

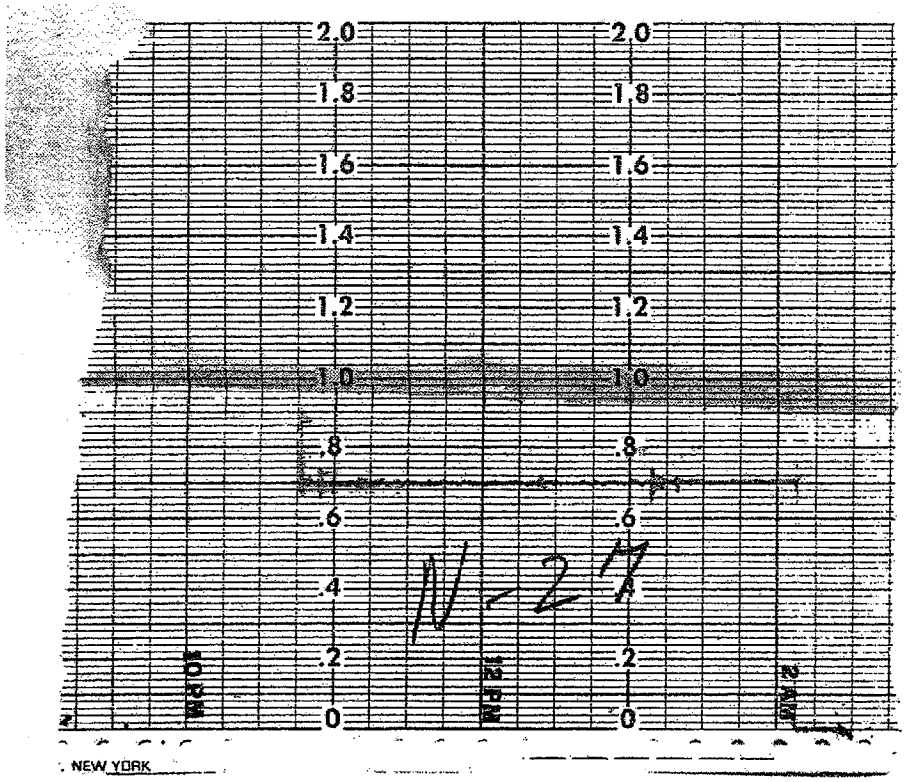
		PAGE 2 CG 03 KY-795-D EST WGT 46124 V-244	USE LBS	N-CODE	USE LBS
	15	OPERATOR STEP PB 60			
	17	RECORD LEVEL 2LG ___% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 68" (3495 G)			
CP	19	RECORD PH 10.7 ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.1. ASSUME 50%	22	7-D	11
	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			
	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: 10.45/P			
		SP STEP / V-243/V-244 — PH — RANGE — TIME			
		13/46 (30 MIN) — 9.7 — 9.0-10.0 — 11:15P			
		14/47 (60 MIN) — 9.65 — 9.0-10.0 — 11:45P			
		15/48 (2 HRS) — 9.6 — 9.0-10.0 — 12:45A			
		16/49 (3 HRS) — 9.55 — 9.0-10.0 — 1:45A			
		17/50 (FINISH) — 8.8 — 7.5-8.5 — 2:30A			
		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	____
DRUM	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	56	7-D	28
	29	FILL WITH WATER & STIR 2 MIN			
	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	31	SP STEP 23/53 - RECORD: PH 3.2 (3.3-3.7)			
SP & CP 7	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7 RECORD: PH ___. NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140°F IN DRUM. USE 30 GAL WATER TO 50# N-15-A. STIR 5 MIN AFTER EACH ADDITION.	____	15-A	____
	33	SIFT IN	150 ✓	128-A	150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
	35	RECORD: PH 3.5 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH 4.0 ASSUME 77%	32	27-D	16
		(DILUTE 10 TO 1 WITH WATER) SIPHON N-7-D INTO SV ASSUME 50%		7-D	
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN & STIR 15 MIN	22 ✓	978-A	22
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	44	OPERATOR STEP PB			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
3:15P	____	4:15P	____	54-120
11:00P	____	3:15A	____	235-323
____	____	____	____	____

DUP050456324

N32035.01

DUP050456325



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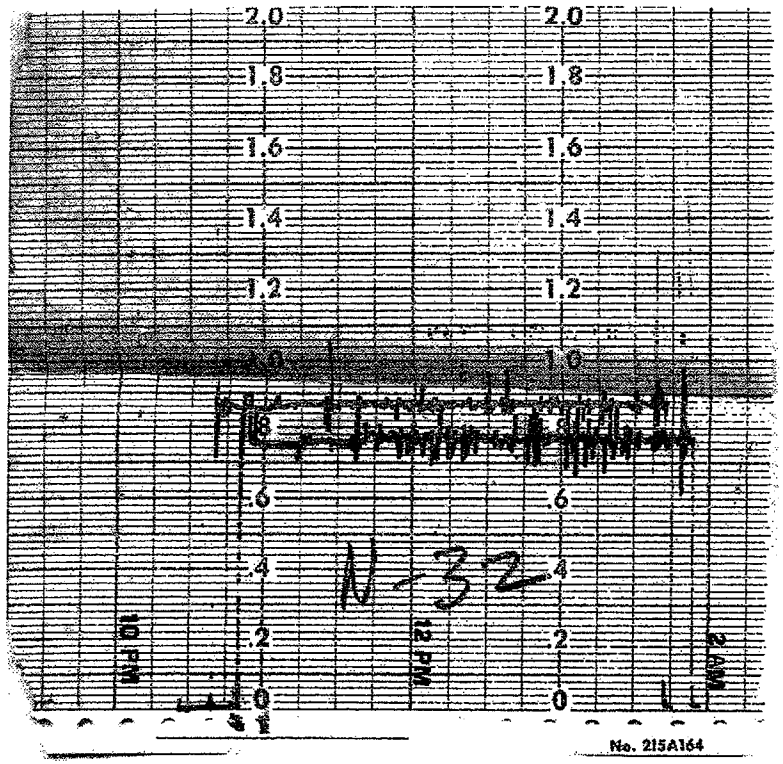

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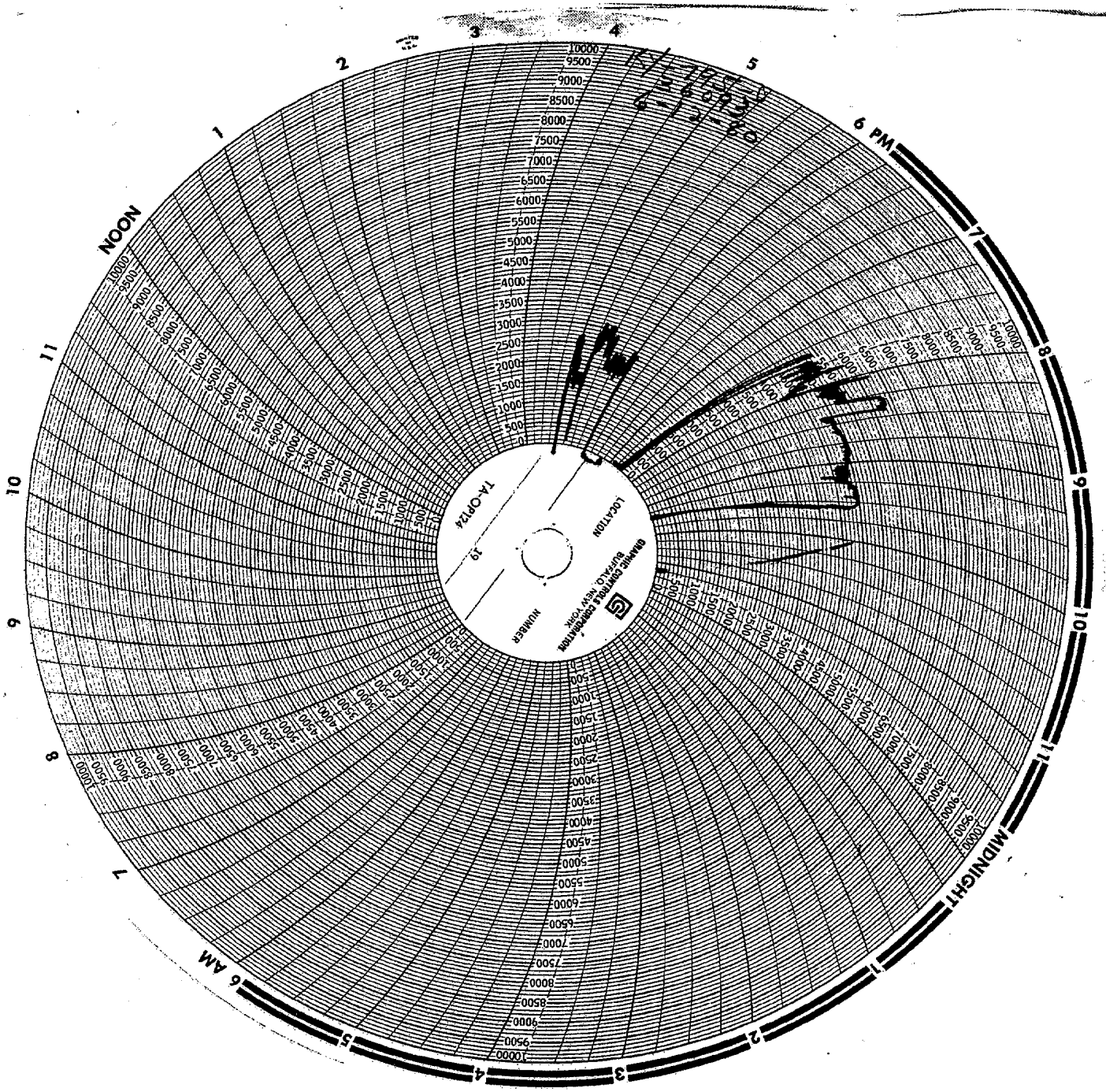

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