

CG 03 CODE KY-795-D PKG
LOT 2415 03815

PROCESSES APPROVED BY

() KY-795-D (I) FWP 5/8/80
() (3/4 N-32-D STRIKE TO
() IMPROVE GLOSS)
() (30 MIN LONGER STRIKE TIL
() STRIKE LINE IS REPLACED)

EST'D WGT 938 LBS

STANDARD HRS. 11.1 TIME 5P M

TYPED BY: FWP 5/8/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	<u>24465</u>	93	<u>2000</u>
14	YC002B		93	
14	YC002B		93	

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14	YC002B		93	
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MAY 16 1980

TOTAL EST'D WGT 4638

NON-BLEEDING

EQUIP	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	500	32-D	500
	3 DUMP IN AND STIR 5 MIN	74X50	YC-2-B	3700
1	RECORD: START <u>9:45 P.M.</u> LOT <u>24465</u>	<u>2000</u>		
	FIN <u>12:30 P.M.</u> <u>24788</u>	<u>1700</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>42</u> & ADJ TO 51" (1874 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
05	9 RUN 2" (514 G) WATER INTO V- <u>205</u> & START AGITATOR			
V	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <u>6:00 P.M.</u> TOTAL MINUTES <u>150</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			
49 & 84	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	14 WEIGH INTO V-384, & PUMP TO V-349	2000	32-D	2000
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 29" (1372 G) & STIR 15 MIN			
	17 RECORD DENSITY: <u>1.052 G/ML</u> (1.049-1.051)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO <u>25</u> (2496 G)			
4	19 RECORD: PH <u>10.8</u> & ADJ TO 11.1-11.3 USING N-7-D DILUTED TO 5% (10 PARTS WATER TO 1 PART N-7-D)			
	ASSUME 50%	<u>14</u>	7-D	<u>7</u>
	SIPHON N-7-D INTO SV & RECORD: PH <u>11.1</u>			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT <u>194</u> °F & RECORD: <u>194</u> °F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

V-262

USE	N-	USE
LBS	CODE	LBS
343	21	312
386	22	
5	23	
	24	

SV	25	WHEN S 20 HEATING COMPLETE, RECORD: PH <u>10.0</u>		
6	26	SET V-343 ACID PUMP AT 82 SETTING (265 MIN)		
	27	SET V-349 SILICATE PUMP AT 70 SETTING (210 MIN)		
	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV		
	29	AT 190-194°F DURING STRIKE.		
		RECORD: START FINISH MINUTES		
		V-343 9:50 2:45 PM		
		V-349 9:10 AM 1:05 PM		
		TIME V-343 V-349 SV NORMAL		
		INCHES PH PH		
		AT 20 MIN 10.10 (65) (26) 10.0 (9.0-10.0)		
		40 MIN 10.30 (59) (23) 10.0 (9.0-10.0)		
		1 HR 10.50 (54) (21) 10.0 (9.0-10.0)		
		2 HRS 11.30 (38) (12) 9.9 (9.0-10.0)		
		3 HRS 12.50 (22) 24 (4) 10.6 (9.0-10.0)		
		3 1/2 HRS 1.20 (15) (0) 10.1 (9.0-10.0)		
		FINISH 2:15 (0) 2.5 (7.5-8.5)		
		NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP PUMPS & SEE SUPV. IF FINAL PH IS ABOVE 8.5, ADJ TO 7.5-8.5 & RECORD: PH		
		ASSUME 77%		
			27-D	

Stopped 10:5 PM
Started 10:25 at 1:10 PM
Stopped 1:32-D at 1:05 PM

356	30	RUN 15" (108 G) WATER INTO V-356 & HEAT TO		
7		135-140°F		
	31	DUMP IN & STIR TO DISSOLVE FOR S-38	220	15-A 220

DRUM	32	WEIGH INTO 55 GAL DRUM	60	7-D 30
8	33	FILL WITH WATER & STIR 2 MIN FOR S-40		

SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &		
		SET PUMP TO ZERO SETTING		
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &		
		TURN OFF PUMP MOTOR		
	36	TURN OFF STEAM		
	37	SIFT IN	150	65 150
	38	RUN IN V-356 FROM S 31 & STIR 5 MIN		
	39	RECORD: PH 3.7 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH		15-A
		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140 °F IN DRUM, USE 30 GAL WATER TO 50% N-15-A. STIR SV 5 MIN AFTER EACH ADDITION		
	40	SIPHON IN N-7-D FROM S-33 IN 4-6 MIN & STIR 5 MIN		
	41	RECORD: PH 4.2 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH		27-D
		DILUTE N-7-D 10 TO 1 WITH WATER		7-D
		SIPHON N-7-D INTO SV		
	42	POUR IN STIR 15 MIN	45	978-A 45
	43	STOP AGITATOR		

START	FINISH	OPERATOR
11 PM	7:00 PM	223
7:10 PM	3:00 PM	54-301
3:00 PM	4:10 PM	235-237
STEP	V-262 (20 RPM)	V-243, 244
9	5"	10"
18	25"	50"

2-262

