

JAN 21 1982

A2J67

KY-787-D (T) FWP 12/09/81

(DATE)

LOT NUMBER

STANDARD HRS. 8.9

TIME

M

JOB NAME 03KY787DMT

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	M1061-1	93	2000	14	YC002B		93	
14	YC002B	M1064-1	93	500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

DO NOT USE LOTS 13839 - 13855

TOTAL EST'D WGT 3394* LBS.

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	250	32-D	250
	3 DUMP IN AND STIR 5 MIN	50X50	YC-2-B	2500
	RECORD: START 2:30 AM M1067-1	2000		
	FIN 3:05 AM M1064-1	500		
	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 46" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	1 RUN 10" (514 G) WATER INTO V-243A START			
SV	2 AGITATOR			
	3 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 2:55 AM TOTAL MINUTES 105			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
14	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 2 (V-243) OR POSITION 7 (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 & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG Broken % PRESET #1 32 GAL		115-A	168
	B. 13LG Broken % PRESET #4 141 GAL		20-A	141
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM		27-D	213
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.31			
	3FC10 (N-32-D CONTROLLER) IN MANUAL .84 GPM		32-D	1425
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
	3FC20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.76			

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16	OPERATOR STEP PB			
320	17 RECORD LEVEL 2LG <u>50</u> % IF BELOW 35% FOLLOW SOL'N			
SV	18 MAKE-UP PROCEDURE FOR N-27-D			
SP	19 ADJUST SV TO 48" (2470 G)			
CP	20 RECORD PH <u>9.6</u> . ADJ TO 11.1-11.3 WITH N-7-D AT			
	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	21 SIPHON INTO SV. RECORD: PH <u>11.3</u> . ASSUME 50%	<u>40</u>	7-D	<u>20</u>
120	22 OPERATOR STEP PB			

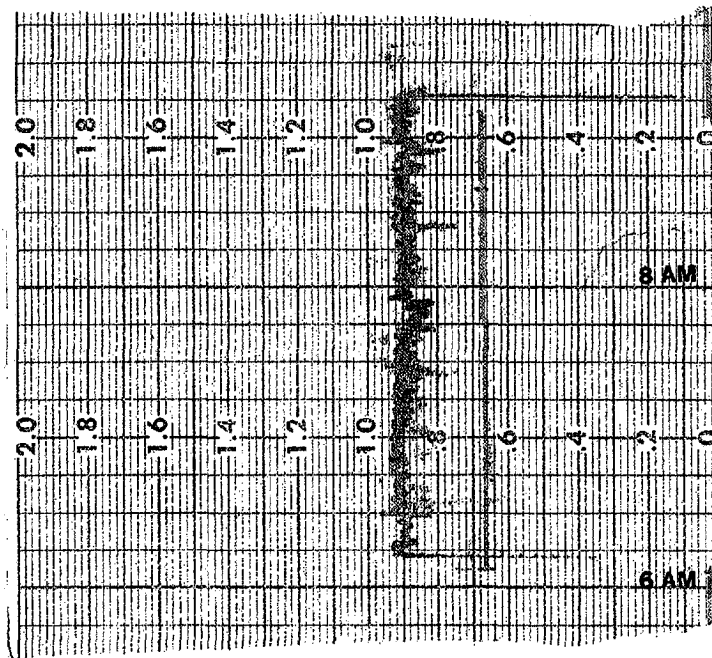
SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.8</u> .		
SP	22	SWITCH 3FC20, 2FC10, & 8FC20 TO AUTO		
	23	OPERATOR STEP PB		
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS		
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB		
5	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN		
		LIMITS, SWITCH 3FC20 TO REMOTE		
	26	OPERATOR STEP PB		
	27	DURING STRIKE RECORD: <u>6:15 AM</u>		
		SP STEP		
		V-243/V-244		
		PH RANGE TIME		
		13/46 (30 MIN) <u>9.4</u> 9.0-10.0 <u>6:45 A</u>		
		14/47 (60 MIN) <u>9.6</u> 9.0-10.0 <u>7:45 A</u>		
		15/48 (2 HRS) <u>9.6</u> 9.0-10.0 <u>8:15 A</u>		
		16/49 (2 HRS, 25 MIN) <u>9.6</u> 9.0-10.0 <u>8:40 A</u>		
		17/50 (FINAL 3 HRS) <u>7.6</u> 7.5-8.5 <u>9:15 A</u>		
		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

28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
29	ADD IN 7-8 MIN	365	530-A	365
339	30 ADJ TO 49" (382 G) AT 80-100#F			
6	31 STIR 5 MIN & RECORD: PH <u>10.1</u> (9.5-10.5)			
	32 STIR 15 MIN OR LONGER FOR SP STEP 26			
	33 RECORD: VOL ____ & CALC ____ X 0.78 = ____ GAL			
	34 SET PRESET #8 TO ____ GAL FROM S 33			

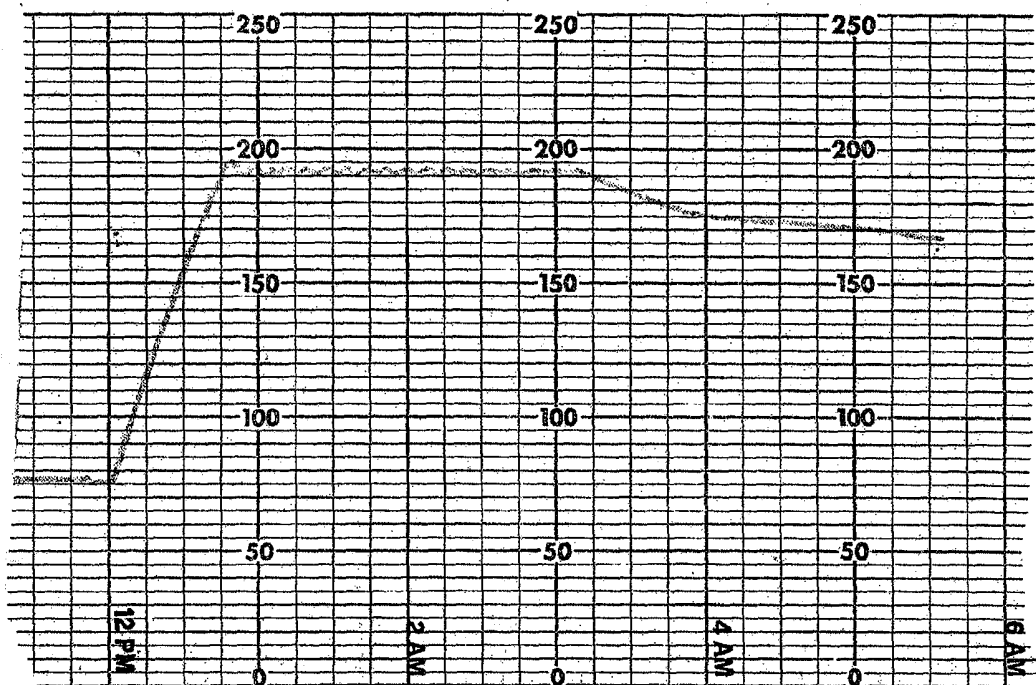
385	35 RUN 47" (360 G) WATER INTO V-385			
7	36 ADD & STIR 2 MIN FOR S 40 ASSUME 50%	160	7-D	80

37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
38	SIFT IN	<u>100</u>	128-A	100
SV	39 SP STEP 23/53. RECORD: PH <u>3.2</u> (3.7-4.2)			
SP	40 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
	MIN			
8	41 RECORD: PH <u>9.3</u> (9.0-9.5). 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)			
42	OPERATOR STEP PB			
43	SP STEP 29/58. RECORD: PH <u>9.3</u> & TIME <u>10:50 A</u>			
44	OPERATOR STEP PB			
45	SP STEP 60. BATCH COMPLETE.			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>8:00 A</u>	<u>3:00 P</u>	<u>126-409</u>
<u>7:00 A</u>	<u>11:00 A</u>	<u>126-301</u>



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