

CG 03 CODE KY-795-D PKG

LOT DEC-18 80 38173

PROCESSES

APPROVED BY

() KY-795-D (H) FWP 11/20/80
 () () (XOB-17: 3/4
 () () N-32-D & 240
 () () MIN STRIKE)
 () ()

STANDARD HRS. 8.2 TIME M

JOB NAME: XOB17:795H

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13176	93	1900	14	YC002B		93	
14	YC002B	13371	93	1600	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

PUNCHED & CHECKED

TOTAL EST'D WGT 4380

DEC 16 1981

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ACCT LBS
203 & 205 263	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED. 2 WEIGH IN DRUM & POUR IN 3 DUMP IN AND STIR 5 MIN RECORD: START 6:35 PM FIN 7:20 PM 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 56" & ADJ TO 60" (2100 G) 8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY	485 70X50 1900 1600	983-D YC-2-B	485 3500
205 263 SV	9 RUN 10" (514 G) WATER INTO V-244 & START AGITATOR 10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 8:30 A TOTAL MINUTES 145 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 64% PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM 3FR10 (N-27-D/WATER) RATIO 1.04 3FC10 (N-32-D CONTROLLER) IN MANUAL 0.69 GPM 3FC20 (N-32-D WATER) IN MANUAL LOCAL 5.5 GPM 3FR10 (N-32-D/WATER) RATIO 1.59		27-D 983-D	296 1925

N34772

V-244

SV SP CP	16	OPERATOR STEP PB				
	17	RECORD LEVEL 2LG 60% IF (35% FOLLOW SOLUTION				
	18	MAKE-UP PROCEDURE FOR N-27-D				
4	19	ADJUST SV TO 48" (2980 G)				
	19	RECORD PH 10.4 ADJ TO 11.1-11.3 WITH N-7-D AT				
		5% (10 PARTS WATER TO 1 PART N-7-D)				
	20	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	30	7-D	15	
	20	OPERATOR STEP PB				
SV SP	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8.				
	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
	23	OPERATOR STEP PB				
5	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS				
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB				
	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				
		13/46 (30 MIN) 9.6 9.0-10.0 1.45P				
		14/47 (60 MIN) 9.35 9.0-10.0 2.15P				
		15/48 (2 HRS) 9.5 9.0-10.0 3.15P				
		16/49 (3 HRS) 9.5 9.0-10.0 4.15P				
		16/49 (4 HRS) 9.5 9.0-10.0 5.15P				
		17/50 (FINISH) 7.0 7.5-8.5 6.00P				
		NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE				
		IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.				
		& RECORD: PH 7.0 ASSUME 77%		27-D		
DRUM	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	56	7-D	28	
6	29	FILL WITH WATER & STIR 2 MIN				
SV SP & CP	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.				
	31	SP STEP 23/53 - RECORD: PH 3.6 (3.3-3.7)				
	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7				
		RECORD: PH 3.6		15-A		
	7	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.				
	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 4.2 (4.0-4.2) & IF NECESSARY ADJ TO				
		PH 4.0-4.2 & RECORD: PH 4.2 ASSUME 77%		27-D		
		(DILUTE 10 TO 1 WITH WATER) ASSUME 50%		7-D		
		SIPHON N-7-D INTO SV				
	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				
	40	OPERATOR STEP PB				

START
TIME SP STEP
11 PM
3:00 PM

FINISH
TIME SP STEP
7 AM
7:15 PM

OPTR
282
237-244