S.V. 243, 244 S.V. PUNCHED & CHECKED D.V.

CG 03 CODE KY-788-D PKG JUN 2 4 1980 OK

LOT 20 36249

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME 7:AM M

PROCESSES APPROVED BY
( ) KY-788-D (J) FWP 5/14/80
( ) ( )
( ) ( )
( ) ( )
( ) ( )

TYPED BY: FP 5/14/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	

1st

Homog #3 - 1st Pass

CLEAN UP AS YOU GO ALONG

TOTAL EST'D WGT 3560 NON-BLEEDING

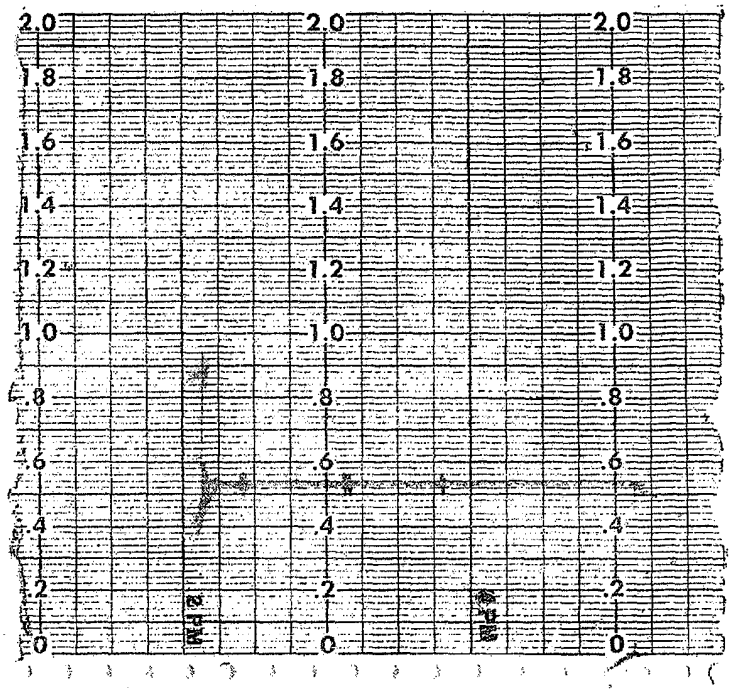
EQUIP		NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N-CODE	ACCT LBS
03 & 05	1	RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	345	32-D	345
	3	DUMP IN AND STIR 5 MIN LOT	52X50	YC-3-B	2600
		RECORD: START 1030AM 23565	2600		
1		FIN 12M 24424	600		
	4	ADJUST TO 75" (1275 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			
263	7	RECORD: V-~~205~~ VOL 263 ____" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
~~205~~ 263	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 11 AM TOTAL MINUTES 130			
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 3 (V-243) OR POSITION 8 (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 90 % PRESET #2 208 GAL		15-A	416
		B. 13LG 45 % PRESET #6 135 GAL		20-A	135
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM		27-D	180
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
		3FR10 (N-27-D/WATER) RATIO 0.8			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM		32-D	[illegible]
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
		8FC30 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.1			

N32200

EQUIP		PHASE 2 LOT 2414 EST. 3.6K	USE LBS	N- CODE	USE LBS
	16	OPERATOR STEP PB 80			
320	17	RECORD LEVEL 2LG ___% IF (35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 47" (2400 G)			
CP	19	RECORD PH 9.6 ADJ TO 11.0-11.2 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)	46		
4		SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%		7-D	23
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7			
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:			
		SP STEP			
		V-243/V-244 PH RANGE TIME (4:00 PM)			
		13/46 (30 MIN) 9.5 9.3-10.0 4:30			
		14/47 (60 MIN) 9.5 9.3-10.0 5:00			
		15/48 (2 HRS) 9.5 9.3-10.0 6:00			
		16/49 (2 HRS, 25 MIN) 9.5 9.3-10.0 6:25			
		17/50 (FINAL 3 HRS) 7.3 7.5-8.5 7:00 PM			
		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	350	530-A	350
339	30	ADJ TO 49" (382 G) AT 80-100*F			
A	31	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26/53			
	33	RECORD: VOL 50" & CALC 50" X 0.78 = 39.0 GAL			
	34	SET PRESET #8 TO 39.0 GAL FROM S 33			
302	35	RUN 40" (440 G) WATER INTO V-302			
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180
	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	38	SIFT IN	100	~~530-A~~	100
SV	39	SP STEP 23/53. RECORD: PH 3.9 (3.7-4.2)		654	
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
		MIN			
-8->	41	RECORD: PH 8.7 (9.0-9.5). ADJ IF NECESSARY &			
		RECORD: PH 9.5 ASSUME 77%	20	27-D	
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%		7-D	10
		(SIPHON N-7-D INTO SV)			
	42	OPERATOR STEP PB			
	43	SP STEP 29. RECORD: PH 9.4 & TIME 9:05 PM			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
12:30P	____	3:00P	____	235-320
3:00P	____	11:00A	____	342-201
7A	____	3P	____	120
3:00PM		9:15PM		320-322

DUP050457042



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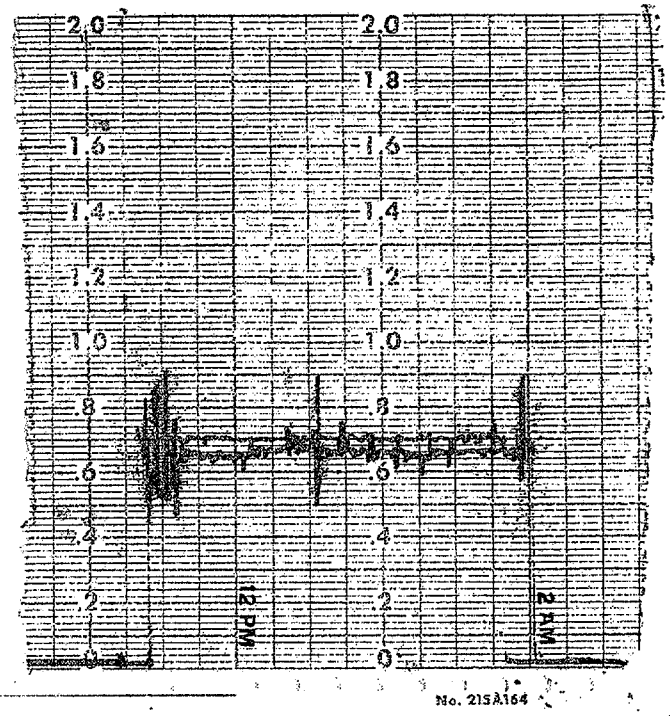

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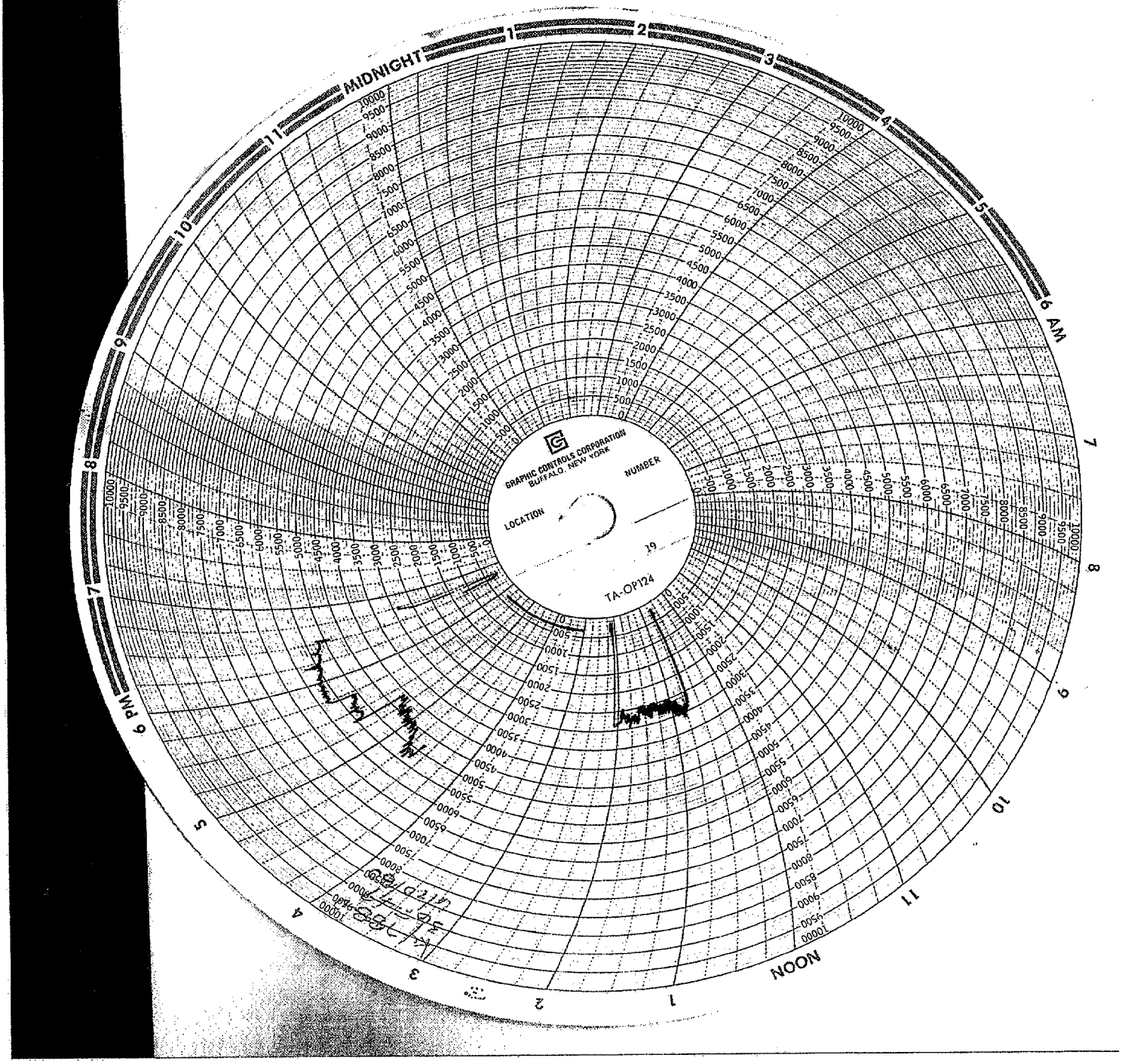

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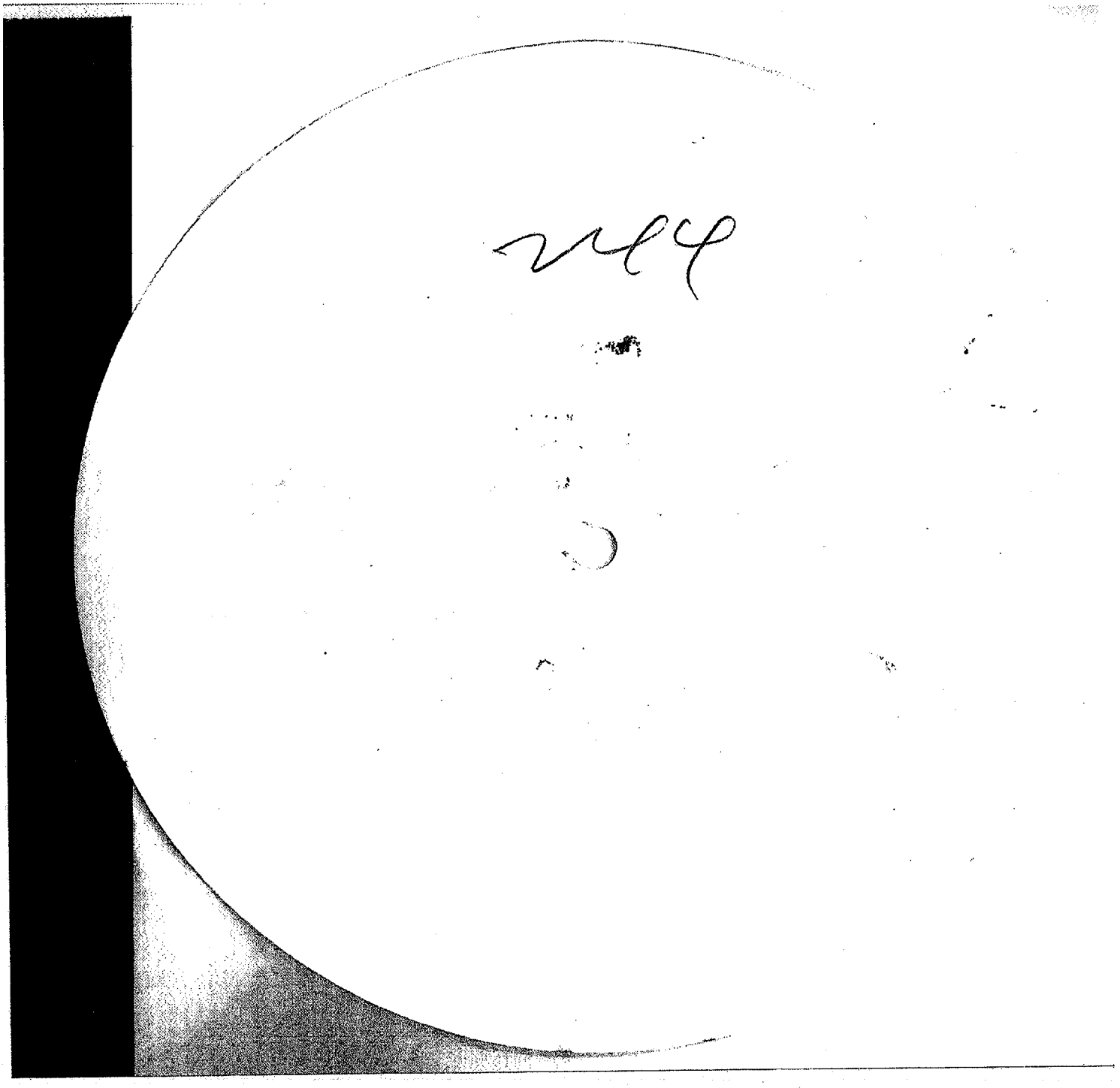

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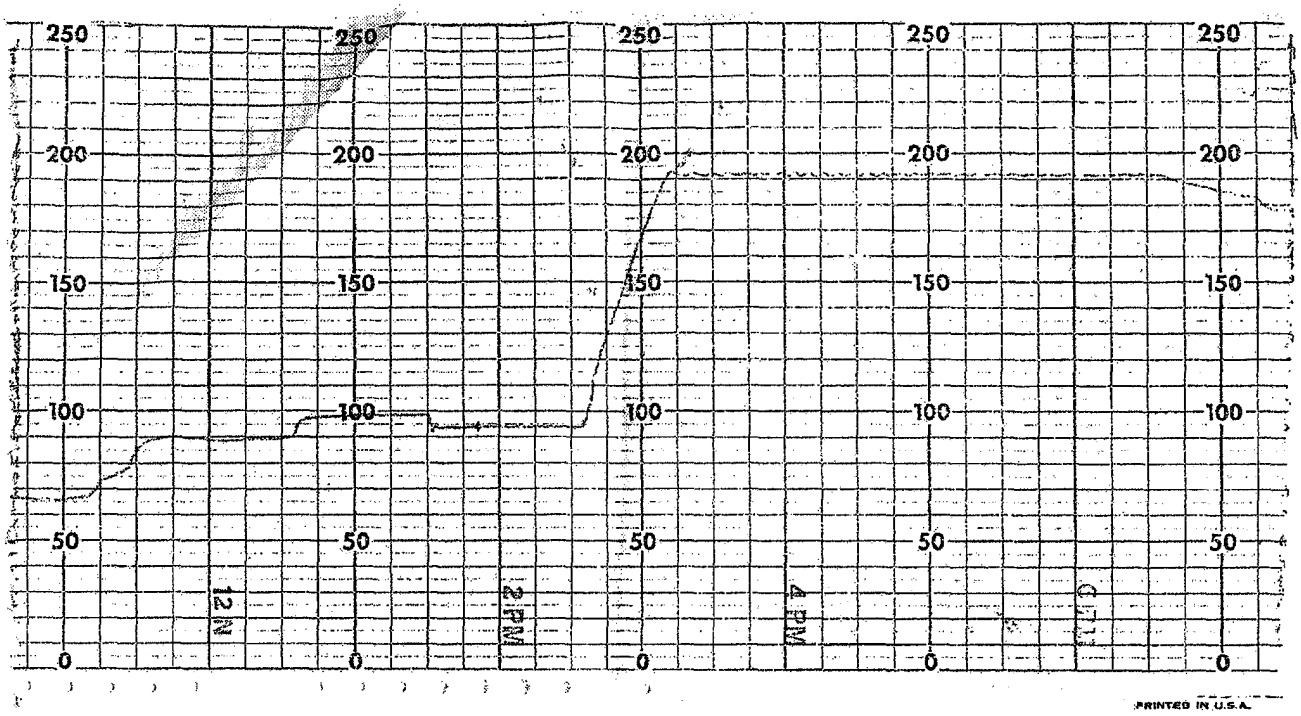

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