

CG 03 CODE KY-795-D PKG

LOT OCT 15 80 37457

EST'D WGT 880 LBS

STANDARD HRS. 8.2 TIME 7A M

PROCESSES

APPROVED BY

() KY-795-D (H) FWP 7/24/80

() () (XDB-17: 3/4

() () N-32-D & 240

() () MIN STRIKE)

() ()

TYPED BY: FWP 7/24/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	82813-1	93	3000	14	YC002B		93	
14	YC002B	82813-2	93	500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

OCT 15 1980

HOMO #4 1ST PASS
11 4-22 11

TOTAL EST'D WGT 4630 4680 4730

NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
	NAME : "KROLOR" YELLOW MEDIUM			
203	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON			
&	HIGH SPEED.			
205	WEIGH IN DRUM & POUR IN	475	32-D	475
	DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3750
	RECORD: START 12:20 PM LOT 82813-1	60		3500
1	FIN 2:00 PM 82813-2	10		
	ADJUST TO 75" (1275 G)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	HOMOGENEOUS AT 2400-2600 PSI INTO V-205			
	WHEN V-203 MT, WASH COLOR THRU HOMOGENEOUS WITH MIN			
	OF HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL 14" & ADJ TO 60" (2100 G)			
	INSPECT HOMOGENEOUS STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-243 START			
	AGITATOR			
SV	PUMP V-205 THRU HOMOGENEOUS AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 11:40 PM TOTAL MINUTES 135			
2	NOTE: IF HOMOGENEOUS PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP			
	THRU HOMOGENEOUS AT 4800-5200 PSI INTO SV			
SP	SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
&	5 (V-243) OR POSITION 10 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 46% PRESET #1 104 GAL		15-A	208
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM		27-D	296
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.04			
	BFC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM		32-D	1885
	BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	BFC20 (N-32-D WATER) IN REMOTE			
	BFR10 (N-32-D/WATER) RATIO 1.59			

N34833

SV	16	OPERATOR STEP PB			
SP	17	RECORD LEVEL 2LG 89% IF <35% FOLLOW SOLUTION			
CP	18	MAKE-UP PROCEDURE FOR N-27-D			
	19	ADJUST SV TO 68" (3495 G)			
	20	RECORD PH 10.3. 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%	30	7-D	15
	20	OPERATOR STEP PB			

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8			
SP	22	SWITCH 3FC20, 8FC10, & 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:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) 9.65 9.0-10.0 6:00			
		14/47 (60 MIN) 9.6 9.0-10.0 6:30			
		15/48 (2 HRS) 9.6 9.0-10.0 7:30			
		16/49 (3 HRS) 9.4 9.0-10.0 8:30			
		16/49 (4 HRS) 9.4 9.0-10.0 9:30			
		17/50 (FINISH) 8.4 7.5-8.5 10:15			
		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	

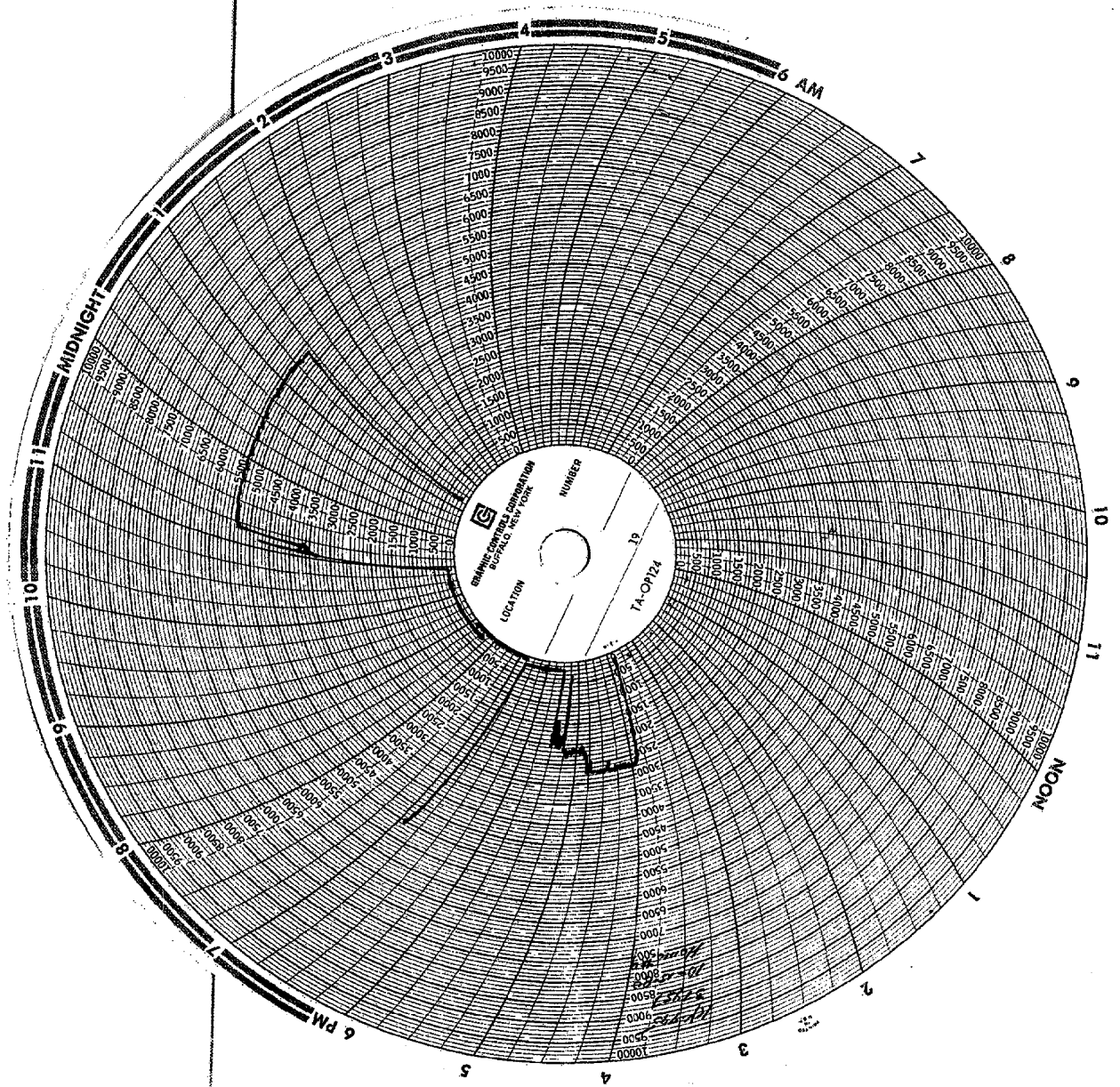
DRUM	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	56	7-D	28
6	29	FILL WITH WATER & STIR 2 MIN			

SV	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SP	31	SP STEP 23/53 - RECORD: PH 3.7 (3.3-3.7)			
	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
		RECORD: PH 15-A			
CP		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7		*F IN DRUM. USE 30 GAL WATER TO 50% N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			
	33	STIR IN	450	128-A	150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
	35	RECORD: PH 4.1 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH ASSUME 77%		27-D	
		(DILUTE 1 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	✓ 122	978-A	22 45
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	40	OPERATOR STEP PB			

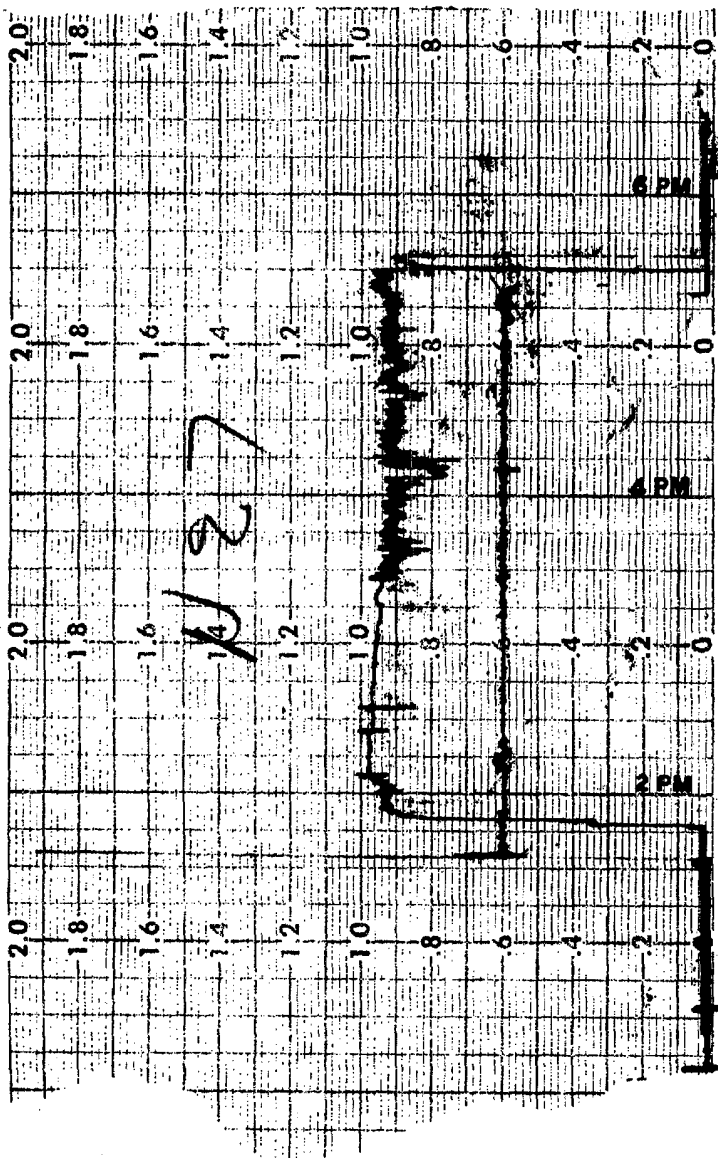
41 pump to 240

START TIME SP STEP	FINISH TIME SP STEP	OPTR
3:00 P	11:00 P	126-259
11:00 P	7:00 AM	235 + 244
7:00 AM		282 - 223

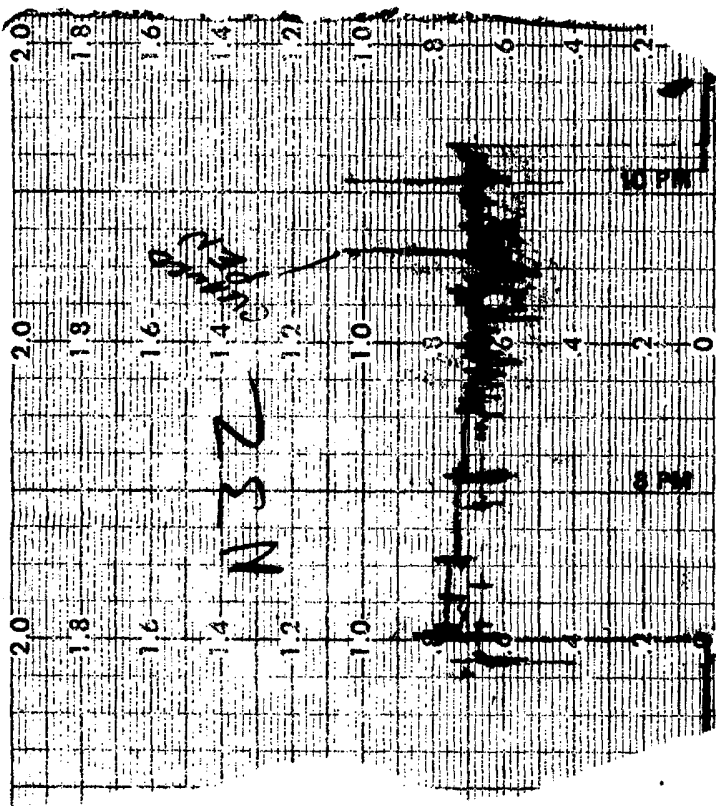
CRANZ
Pump to V-240



V-243



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