

JUN 25 1982

(DATE)

E2L45

(LOT)

4780*

(EST WGT)

KY-907-D (H) FWP 06/15/82

COMTYP JOB NAME: 03KY907DMH

TYPED BY:

STANDARD HRS. 8.9

TIME

M

LOCATN	CG	CODE	PG	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
14		YC-2	93	14558	3550					
14		YC-2	93							
14		YC-2	93							
14		YC-2	93							

NON-BLEEDING

EQUIP MENT	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
203	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
205	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	WEIGH IN DRUM & POUR IN	355	32-D	355
3	DUMP IN AND STIR 5 MIN	71X50	YC-2-B	3550
1	RECORD: START 710 AM	3550		
	FIN 800 AM			
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 47" & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 445 TOTAL MINUTES 150			
3	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
4	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			

SP STEP 01 - SET FORMULA SELECTOR TO POSITION

& (V-243) OR POSITION 6 (V-244)

CP 13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO

3 14 REMOTE (TEMP IS SET AT 190-194°F)

RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:

A. 11LG 36% PRESET #3.

45 GAL

JUL 20 1982

115-D

239

15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:

3FC10 (N-27-D CONTROLLER) IN MANUAL 0.73 GPM

27-D

302

3FC20 (N-27-D WATER) IN MANUAL LOCAL 9.56 GPM

3FR10 (N-27-D/WATER) RATIO 1.31

8FC10 (N-32-D CONTROLLER) IN MANUAL .96 GPM

32-D

2022

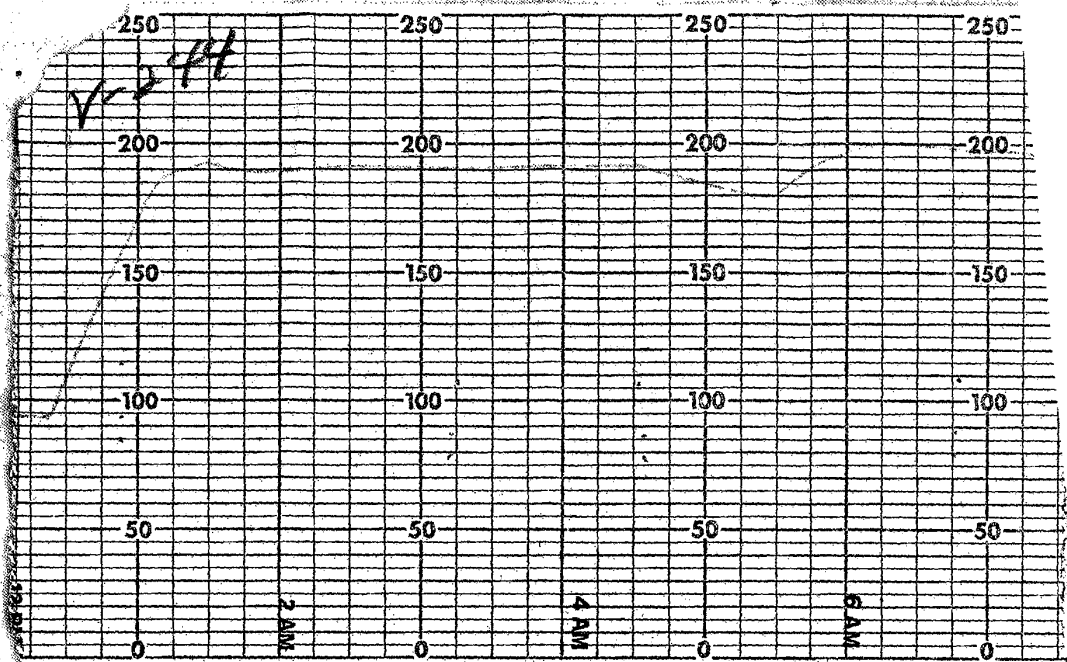
8FC20 (N-32-D WATER) IN MANUAL LOCAL 8.45 GPM

8FR10 (N-32-D/WATER) RATIO 1.76

1.76

JUL 20 1982

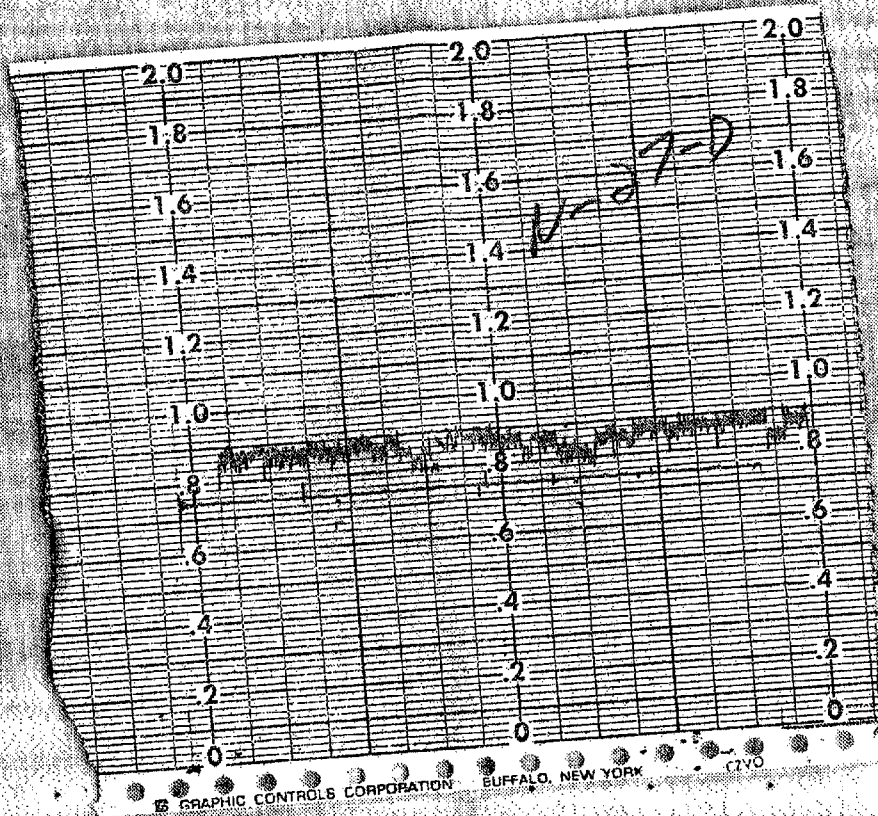
EQUIP MENT	PAGE 2 CG 03 KY-907-D	USE LBS	N- CODE	ACCT LBS
320	16 OPERATOR STEP PB			
SV	17 RECORD LEVEL 2LG 88% IF BELOW 35% FOLLOW SOL'N			
SP	18 MAKE-UP PROCEDURE FOR N-27-D			
CP	19 ADJUST SV TO 48" (2470 G)			
4	20 RECORD PH 10.5 ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)	30	7-D	15
	21 SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50%			
	22 OPERATOR STEP PB			
SV	23 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5			
SP	24 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	25 OPERATOR STEP PB			
5	26 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
	27 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	28 OPERATOR STEP PB			
	29 DURING STRIKE RECORD:			
	SP STEP			
	V-243/V-244			
	13/46 (30 MIN)	9.5	9.0-10.0	11:25
	14/47 (60 MIN)	9.5	9.0-10.0	11:55
	15/48 (2 HRS)	9.5	9.0-10.0	12:55
	16/49 (3 HRS)	9.5	9.0-10.0	1:55
	17/50 (FINAL)	10	7.5-8.5	2:40
	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%			
	128. SIFT IN	55	27-D 128-A	55
385	29 ADD 27" (208 G) WATER TO V-385			
6	30 ADD & STIR FOR 2 MIN FOR S 57+ ASSUME 50%	90	7-D	45
	31 DURING STRIKE CHECK LEVEL IN V-387.			
387	32 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	33 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
	34 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			
	35 RUN IN 32" (317 GAL). DO NOT MAKE UP THIS SOLUTION MORE THAN 30 MINUTES IN ADVANCE. DELAY BETWEEN END OF STEP 41 HEAT-UP AND START OF STEP 48 HOMOGENIZATION SHOULD BE LESS THAN 30 MINUTES.			
388	36 TURN ON STEAM & AGITATOR			
8	37 ADJUST TO 42" (403 GAL) AT 178-182°F			
	38 SET BADGER METER FOR 550			
	39 PUMP IN FROM V-387 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE	450	169-A	450
		50	155-A	50
		50	160-A	50
	40 SHUT OFF PUMP			
	41 STIR 30 MIN AT 178-182°F FOR S 48			
	42 DO NOT SHUT OFF AGITATOR			

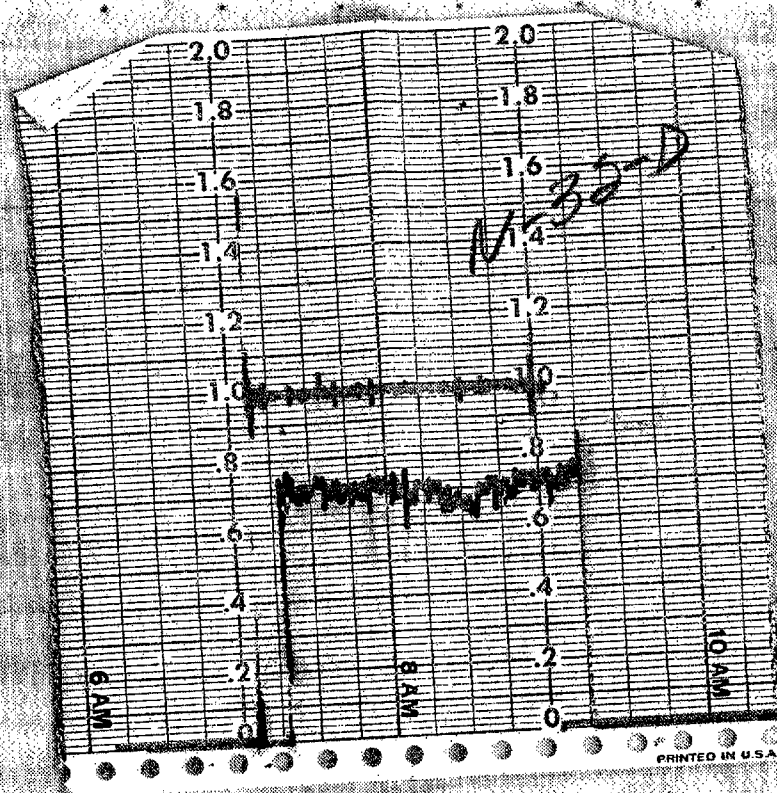


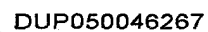
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EQUIP MENT	PAGE 3 CG 03 KY-907-D	USE LBS	N- CODE	ACCT LBS															
SV & SP 9	43 WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN																		
	44 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP																		
	45 OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET																		
	46 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER																		
SV & SP 9	47 WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG DISCHARGE VALVE TO SV AND CLOSE VALVE TO SEWER																		
CONT	48 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE, TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100 PSI. MAINTAIN SV AT 198-200°F.																		
	49 WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE AT STEARATE PUMP ASAP																		
	50 WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT WATER FROM HOT WATER MIXER																		
	51 WHEN S50 COMPLETE TURN OFF HOMOG & STERATE PUMP																		
	52 STIR 5 MIN AT 198-200°F.																		
	53 SHUT OFF STEAM																		
	54 WHEN S53 COMPLETE, OPERATOR PB																		
	55 SP STEP 23/53 RECORD PH <u>3.4</u> (3.3-3.7)																		
	56 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY) & RECORD: PH _____																		
	NOTE: USE LIQUID ALUM, N-115-D. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION.																		
	57 RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN		115-D																
	58 RECORD: PH <u>4.2</u> (4.2-4.4) & IF NECESSARY, ADJ TO PH 4.2-4.4 & RECORD: PH _____ ASSUME 50% (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%		7-D																
	SIPHON N-7-D INTO SV		27-D																
	59 OPERATOR STEP PB																		
	60 OPERATOR STEP PB																		
	61 SP STEP 60 - BATCH COMPLETE																		
<table border="1"> <thead> <tr> <th>START</th> <th>FINISH</th> <th>OPERATOR</th> </tr> <tr> <th>TIME SP STEP</th> <th>TIME SP STEP</th> <th></th> </tr> </thead> <tbody> <tr> <td><u>3:11 PM</u></td> <td><u>4:00 PM</u></td> <td><u>54</u></td> </tr> <tr> <td><u>3:11 PM</u></td> <td><u>3:00 PM</u></td> <td><u>320</u></td> </tr> <tr> <td></td> <td><u>3:05 PM</u></td> <td><u>54</u></td> </tr> </tbody> </table>					START	FINISH	OPERATOR	TIME SP STEP	TIME SP STEP		<u>3:11 PM</u>	<u>4:00 PM</u>	<u>54</u>	<u>3:11 PM</u>	<u>3:00 PM</u>	<u>320</u>		<u>3:05 PM</u>	<u>54</u>
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