

JAN 18 1982

A2J58

() KY-907-D (D) FWP 12/17/81

DATE

LOT NUMBER

STANDARD HRS. 8.9

TIME 11 P. M.

COMTYP JOB NAME 03KY907DMD

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-2-B	MIU64-1	93	-----	14	YC-2-B	-----	93	-----
14	YC-2-B	MIU64-2	93	-----	14	YC-2-B	-----	93	-----
14	YC-2-B	-----	93	-----	14	YC-2-B	-----	93	-----

DO NOT USE LOTS 13839 - 13855

1st PASS # of Homo
2nd " 43 "

TOTAL EST'D WGT 3381* LBS.

NON-BLEEDING

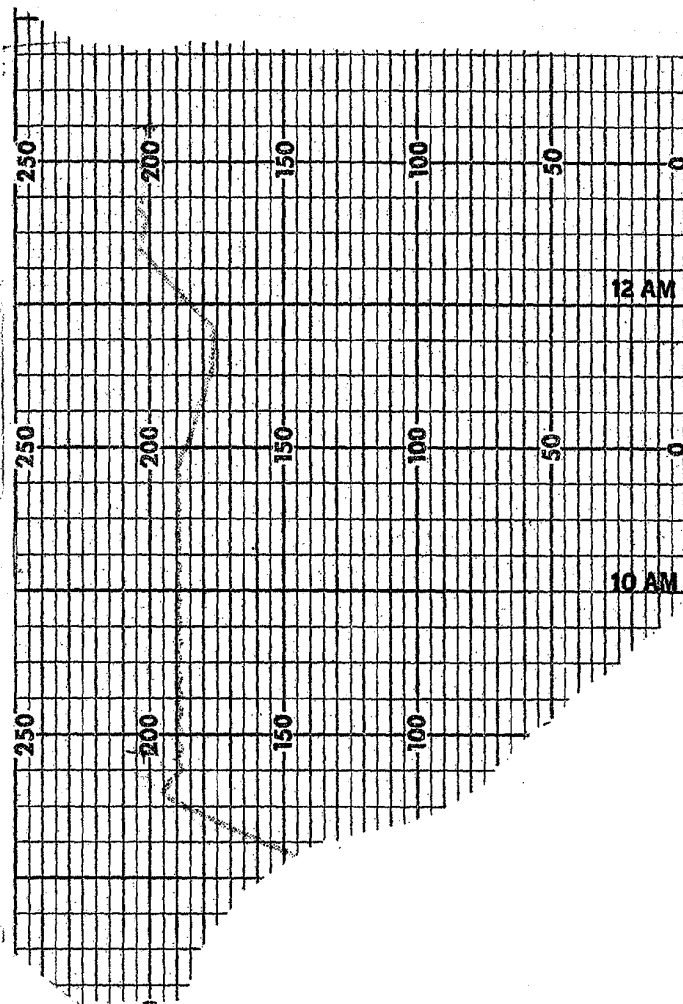
EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON & HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	250	32-D	250
	3 DUMP IN AND STIR 5 MIN	50X50	YC-2-B	2500
	RECORD: START 11:15	MIU64-1		
	FIN 12:05	MIU64-2		
	4 ADJUST TO 75" (1275 G)			
	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 43 " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-203 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 1:45 PM TOTAL MINUTES 120			
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	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 100% PRESET #1 32 GAL		115-A	168
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: SFD10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM SFD20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM SFR10 (N-27-D/WATER) RATIO 1.31 SFC10 (N-32-D CONTROLLER) IN MANUAL .24 GPM SFD20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM SFR20 (N-32-D WATER) IN REMOTE SFR10 (N-32-D WATER) RATIO 1.76		27-D 32-D	213 1425

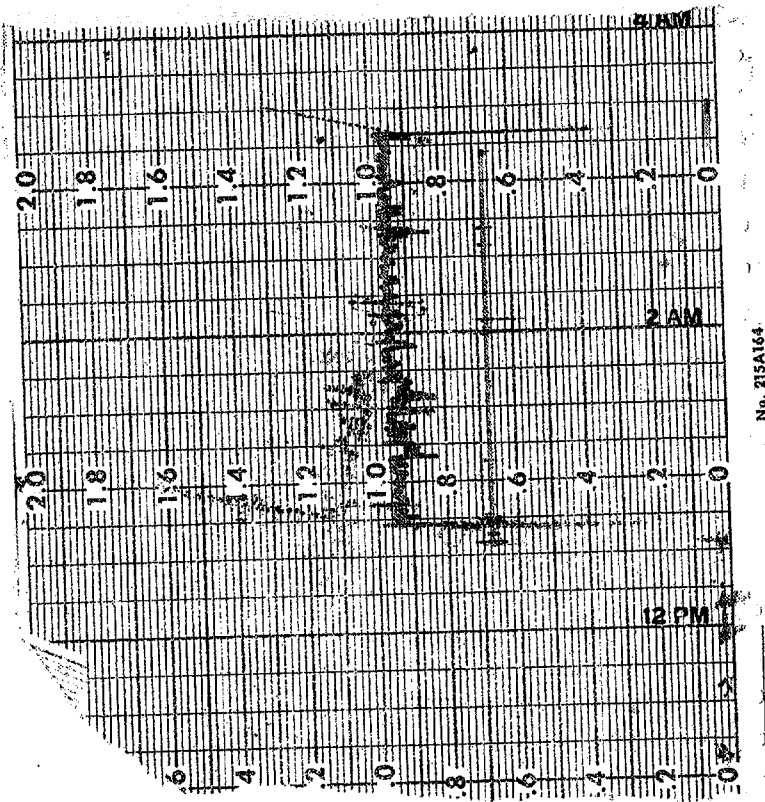
16	OPERATOR STEP PB			
17	RECORD LEVEL 2LG 87% IF BELOW 35% FOLLOW SOL'N			
SV	MAKE-UP PROCEDURE FOR N-27-D			
18	ADJUST SV TO 48" (2470 G)			
19	RECORD PH 12.1 ADJ TO 11.1-11.3 WITH N-7-D AT			
4	5% (10 PARTS WATER TO 1 PART N-7-D)	34	7-D	12
20	SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50%			
21	OPERATOR STEP PB			
22	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8.			
23	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
24	OPERATOR STEP PB			
25	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
5	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
26	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
27	LIMITS, SWITCH 3FC20 TO REMOTE			
28	OPERATOR STEP PB			
29	DURING STRIKE RECORD:			
	SP STEP			
	V-243/V-244	PH	RANGE	TIME
	13/46 (30 MIN)	9.4	9.0-10.0	6:15 PM
	14/47 (60 MIN)	9.4	9.0-10.0	6:45 PM
	15/48 (2 HRS)	9.4	9.0-10.0	7:45
	16/49 (2 HRS, 25 MIN)	9.4	9.0-10.0	8:10
	17/50 (FINAL 3 HRS)	5.8	7.5-8.5	8:45
	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%	
28	SIFT IN	50	27-D	50
385	ADD 27" (208 G) WATER TO V-385			
5	ADD & STIR FOR 2 MIN FOR S 57	ASSUME 50%	60	7-D 30
34	DURING STRIKE CHECK LEVEL IN V-387.			
387	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	IF LOW LEVEL LIGHT IS LIT. VERIFY BY CHECKING			
	THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
36	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW			
	STEARATE MAKE-UP PROCEDURE.			
388	RUN IN 32" (317 GAL)			
8	TURN ON STEAM & AGITATOR			
	ADJUST TO 42" (403 GAL) AT 178-182°F			
	SET BADGER METER FOR 404#			
39	PUMP IN FROM V-387 THRU UNDERSURFACE	330	169-A	330
	DISTRIBUTORS AS FAST AS POSSIBLE	37	155-A	37
		37	160-A	37
40	SHUT OFF PUMP			
41	STIR 30 MIN AT 178-182°F FOR S 48			
42	DO NOT SHUT OFF AGITATOR			
SV	43 WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN			
2	5 TO 10 MIN			
SP	44 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE			
9	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			

EQUIP. | COMTYP JOB NAME: 03KY907DMD | USE | N- | ACCT
 MENTY | PAGE 03 CG 03 KY-907-D (D) EST WGT 3381# | LBS | CODE | LBS

SV	47	WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG			
&		DISCHARGE VALVE TO SV AND CLOSE VALVE TO			
SP		SEWER			
9	48	IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,			
CONT		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-A. ADD TO SV VIA			
		BADGER METER. STIR 5 MIN AFTER EACH			
		ADDITION. ASSUME 50%		115-A	
	57	RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN			
	58	RECORD: PH <u>3.2</u> (4.2-4.4) & IF NECESSARY, ADJ			
		TO PH 4.2-4.4 & RECORD: PH <u>4.3</u> ASSUME 50%	20	7-D	25
		(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%		27-D	
		SIPHON N-7-D INTO SV			
	59	OPERATOR STEP PB			
	60	OPERATOR STEP PB			
	61	SP STEP 60 - BATCH COMPLETE			

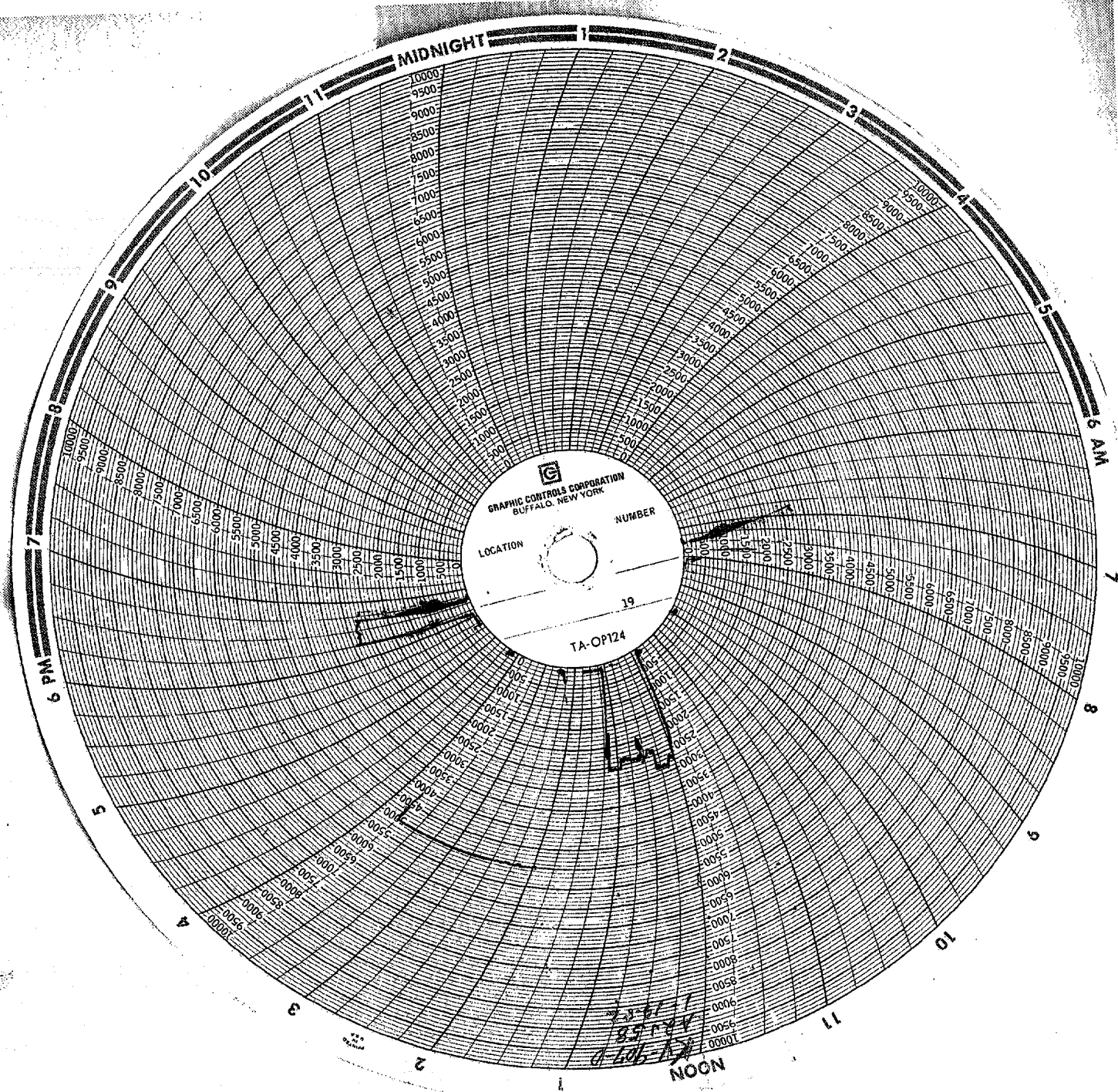
START		FINISH		OPERATOR
TIME	SP STEP	TIME	SP STEP	
12:30 PM		3:00 PM		348-282
3:00 PM		10:45 PM		342





No. 215A164

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