

(AUTOMATED)
S.V. 247 244

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-787-D PKG
LOT

PROCESSES APPROVED BY
() KY-787-D (Q) FWP 5/20/80
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()
()
()
()

EST'D WGT 1090 LBS
STANDARD HRS. 8.9 TIME 3P M

TYPED BY: FP 5/20/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

PUNCHED & CHECKED

TOTAL EST'D WGT 3490

Homog #4 - 2nd Pass

NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
203 & 205	"KROLOR" YELLOW-MEDIUM RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED. WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN RECORD: START 8:05 PM FIN 9:15 PM	320 48X50 2400	32-D YC-2-B	320 2400
205	ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205 RECORD: V-205 VOL 4.3" & ADJ TO 60" (2100 G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
SV 2	RUN 10" (514 G) WATER INTO V-205 & START AGITATOR PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 8:00A TOTAL MINUTES 165 NOTE: IF HOMOG 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 HOMOG AT 4800-5200 PSI INTO SV			
SP & CP	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244) 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 58.2% PRESET #1 80 GAL B. 13LG 50.2% PRESET #6 135 GAL		15-A 20-A	160 135
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM 3FR10 (N-27-D/WATER) RATIO 0.64 BFC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM BFC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM BFC20 (N-32-D WATER) IN REMOTE BFR10 (N-32-D/WATER) RATIO 0.83		27-D 32-D	275 1840

EQUIP | PAGE 2 | CG 03 | KY-737-D | EST WGT 3490# | USE | N- | USE
LBS | CODE | LBS

V-244

320	116	OPERATOR STEP PB			
SV	117	RECORD LEVEL 2LG <u>62%</u> IF BELOW 35% FOLLOW SOL'N			
SP	118	MAKE-UP PROCEDURE FOR N-27-D			
CP	119	ADJUST SV TO 48" (2470 G)			
	120	RECORD PH <u>10.5</u> 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 <u>11.1</u> ASSUME 50%	<u>20</u>	7-D	<u>10</u>
	121	OPERATOR STEP PB			

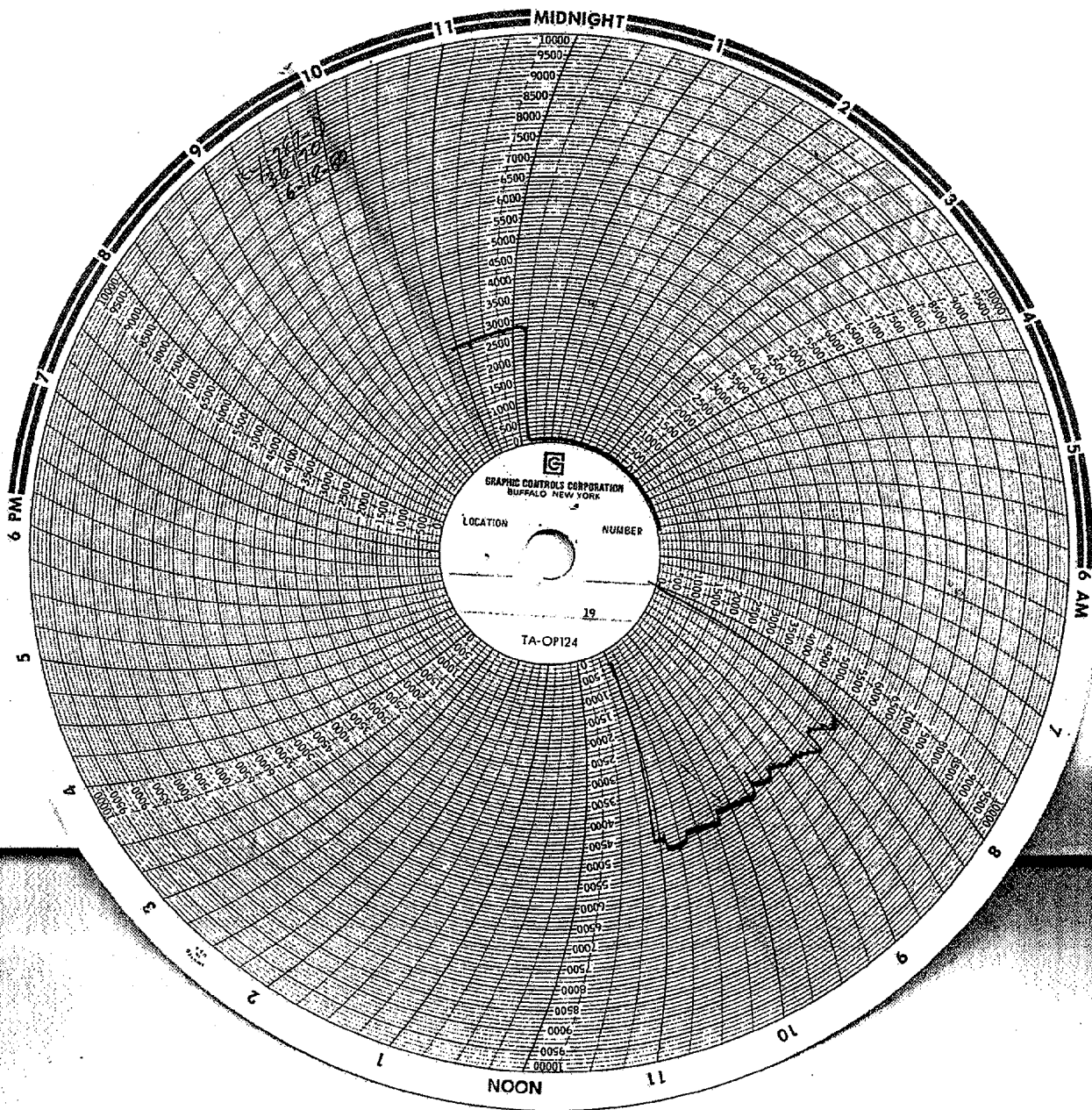
SV	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>10.1</u>			
SP	122	SWITCH 3FC20, 8FC10, & 9FC20 TO AUTO			
	123	OPERATOR STEP PB			
	124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 9FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	125	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	126	OPERATOR STEP PB			
	127	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) <u>9.8</u> 9.0-10.0 <u>2:00</u>			
		14/47 (60 MIN) <u>9.8</u> 9.0-10.0 <u>2:30</u>			
		15/48 (2 HRS) <u>9.8</u> 9.0-10.0 <u>3:30</u>			
		16/49 (2 HRS, 25 MIN) <u>9.8</u> 9.0-10.0 <u>3:55</u>			
		17/50 (FINAL 3 HRS) <u>8.1</u> 7.5-8.5 <u>4:30</u>			
		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	

339	128	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339	350	530-A	350
	129	ADD IN 7-8 MIN			
6	130	ADJ TO 49" (382 G) AT 80-100°F			
	131	STIR 5 MIN & RECORD: PH <u>10.1</u> (9.5-10.5)			
	132	STIR 15 MIN OR LONGER FOR SP STEP 26			
	133	RECORD VOL <u>53</u> " & CALC <u>53</u> " X 0.78 = <u>41.3</u> GAL			
	134	SET PRESET #8 TO <u>41.3</u> GAL FROM S 33			

302	135	RUN 30" (360 G) WATER INTO V-302			
7	136	ADD & STIR 2 MIN FOR S 40 <u>D</u> ASSUME 50%	160	7-D	80

	137	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	138	SIFT IN			
SV	139	SP STEP 23/53. RECORD: PH <u>3.8</u> (3.7-4.2)	<u>100</u>	12B-A	100
SP	140	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
		MIN			
8	141	RECORD: PH <u>9.4</u> (9.0-9.5). ADJ IF NECESSARY &			
		RECORD: PH ____ ASSUME 77%		27-D	
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%		7-D	
		(SIPHON N-7-D INTO SV)			
	142	OPERATOR STEP PB			
	143	SP STEP 29/58. RECORD: PH <u>9.3</u> & TIME <u>5:35R</u>			
	144	OPERATOR STEP PB			
	145	SP STEP 60. BATCH COMPLETE.			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>7:20A</u>	<u>3:00PM</u>	<u>2:35</u> -144
<u>3:00pm</u>	<u>6:00pm</u>	<u>342</u>



N32121.01

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