

CG 03 CODE KY-795-D PKG  
LOT DEC 15 80 38266

PROCESSES APPROVED BY  
( ) KY-795-D (H) FWP 11/20/80  
( ) ( ) (XOB-17: 3/4  
( ) ( ) N-32-D & 240  
( ) ( ) MIN STRIKE)  
( ) ( )

STANDARD HRS. 8.2 TIME \_\_\_\_\_ M

JOB NAME: XOB17:795H

| COMPONENT CONSUMPTION |        |       |    |       |    |        |       |    |       |
|-----------------------|--------|-------|----|-------|----|--------|-------|----|-------|
| CG                    | CODE   | LOT   | PQ | LBS   | CG | CODE   | LOT   | PQ | LBS   |
| 14                    | YC002B | ----- | 93 | ----- | 14 | YC002B | 13410 | 93 | 3500  |
| 14                    | YC002B | ----- | 93 | ----- | 14 | YC002B | ----- | 93 | ----- |
| 14                    | YC002B | ----- | 93 | ----- | 14 | YC002B | ----- | 93 | ----- |

TOTAL EST'D WGT 4380

DEC 16 1980

NON-BLEEDING

| EQUIP     | NAME : "KROLOR" YELLOW MEDIUM                                                              | DOSE LBS | N-CODE | ACCT LBS |
|-----------|--------------------------------------------------------------------------------------------|----------|--------|----------|
| 203 & 205 | 1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.                              |          |        |          |
|           | 2 WEIGH IN DRUM & POUR IN                                                                  | 485      | 983-D  | 485      |
|           | 3 DUMP IN AND STIR 5 MIN                                                                   | 70X50    | YC-2-B | 3500     |
|           | RECORD: START 7:AM 13410                                                                   | 3500     |        |          |
|           | FIN 7:15AM                                                                                 |          |        |          |
|           | 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 40" & 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 MT 4800-5200 PSI INTO SV.                                         |          |        |          |
|           | RECORD: TIME START 110 TOTAL MINUTES                                                       |          |        |          |
| 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 5 (V-243) OR POSITION 10 (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:<br>W. 11LG 37% PRESET #1 104 GAL         |          | 15-A   | 208      |
|           | 15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:                                                 |          |        |          |
|           | 2FC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM                                               |          | 27-D   | 296      |
|           | 2FC20 (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 0.69 GPM                                               |          | 983-D  | 1925     |
|           | BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.5 GPM                                               |          |        |          |
|           | BFC20 (N-32-D WATER) IN REMOTE                                                             |          |        |          |
|           | BFR10 (N-32-D/WATER) RATIO 1.59                                                            |          |        |          |

V-243

|    |    |                                                                                          |    |     |    |
|----|----|------------------------------------------------------------------------------------------|----|-----|----|
| SV | 16 | OPERATOR STEP PB                                                                         |    |     |    |
| SP | 17 | RECORD LEVEL 2LG <u>58</u> % IF <35% FOLLOW SOLUTION                                     |    |     |    |
| CP | 18 | MAKE-UP PROCEDURE FOR N-27-D                                                             |    |     |    |
|    | 19 | ADJUST SV TO <u>58</u> (2980-G) <u>48</u> (2460-G)                                       |    |     |    |
| 4  | 20 | RECORD PH <u>10.6</u> ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D) | 26 | 7-D | 13 |
|    | 21 | SIPHON INTO SV. RECORD: PH <u>11.3</u> ASSUME 50%                                        |    |     |    |
|    | 22 | OPERATOR STEP PB                                                                         |    |     |    |

|    |    |                                                                                         |  |      |  |
|----|----|-----------------------------------------------------------------------------------------|--|------|--|
| SV | 21 | SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.9</u>                                      |  |      |  |
| 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) <u>9.7</u> 9.0-10.0 <u>10 30</u>                                         |  |      |  |
|    |    | 14/47 (60 MIN) <u>9.5</u> 9.0-10.0 <u>11</u>                                            |  |      |  |
|    |    | 15/48 (2 HRS) <u>9.45</u> 9.0-10.0 <u>12</u>                                            |  |      |  |
|    |    | 16/49 (3 HRS) <u>9.35</u> 9.0-10.0 <u>1</u>                                             |  |      |  |
|    |    | 16/49 (4 HRS) <u>9.2</u> 9.0-10.0 <u>2</u>                                              |  |      |  |
|    |    | 17/50 (FINISH) <u>7.6</u> 7.5-8.5 <u>2-45</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 <u>---</u> ASSUME 77%                                                      |  | 27-D |  |

|      |    |                              |    |     |    |
|------|----|------------------------------|----|-----|----|
| DRUM | 28 | WEIGH INTO 55 GAL DRUM       | 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 <u>3.5</u> (3.3-3.7)                                                                             |     |       |     |
| CP | 32 | IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7                                                                                  |     |       |     |
|    |    | RECORD: PH <u>---</u>                                                                                                       |     | 15-A  |     |
| 7  |    | NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140 °F IN DRUM. USE 30 GAL WATER TO 50# N-15-A. STIR 5 MIN AFTER EACH ADDITION. |     |       |     |
|    | 33 | SIFT IN                                                                                                                     | 150 | 128-A | 150 |
|    | 34 | SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN                                                                         |     |       |     |
|    | 35 | RECORD: PH <u>4.2</u> (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH <u>---</u> ASSUME 77%                         |     | 27-D  |     |
|    |    | (DILUTE 10 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                                                                                       | 22  | 978-A | 22  |
|    | 38 | OPERATOR STEP PB                                                                                                            |     |       |     |
|    | 39 | SP STEP 60 - BATCH COMPLETE                                                                                                 |     |       |     |
|    | 40 | OPERATOR STEP PB                                                                                                            |     |       |     |

Pump To V-240

START  
TIME SP STEP

3 PM  
11:00 P

FINISH  
TIME SP STEP

11 PM  
3:30 AM

OPTR

60.54  
235