

CG 03 CODE KY-787-D PKG

PUNCHED & CHECKED

PROCESSES

APPROVED BY

LOT

NOV 12 00 37827

EST'D WGT 932

LBS

STANDARD HRS. 8.9

TIME 11P M

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13172	93	2000	14	YC002B		93	
14	YC002B	13193	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

CLEAN UP

AS YOU GO ALONG

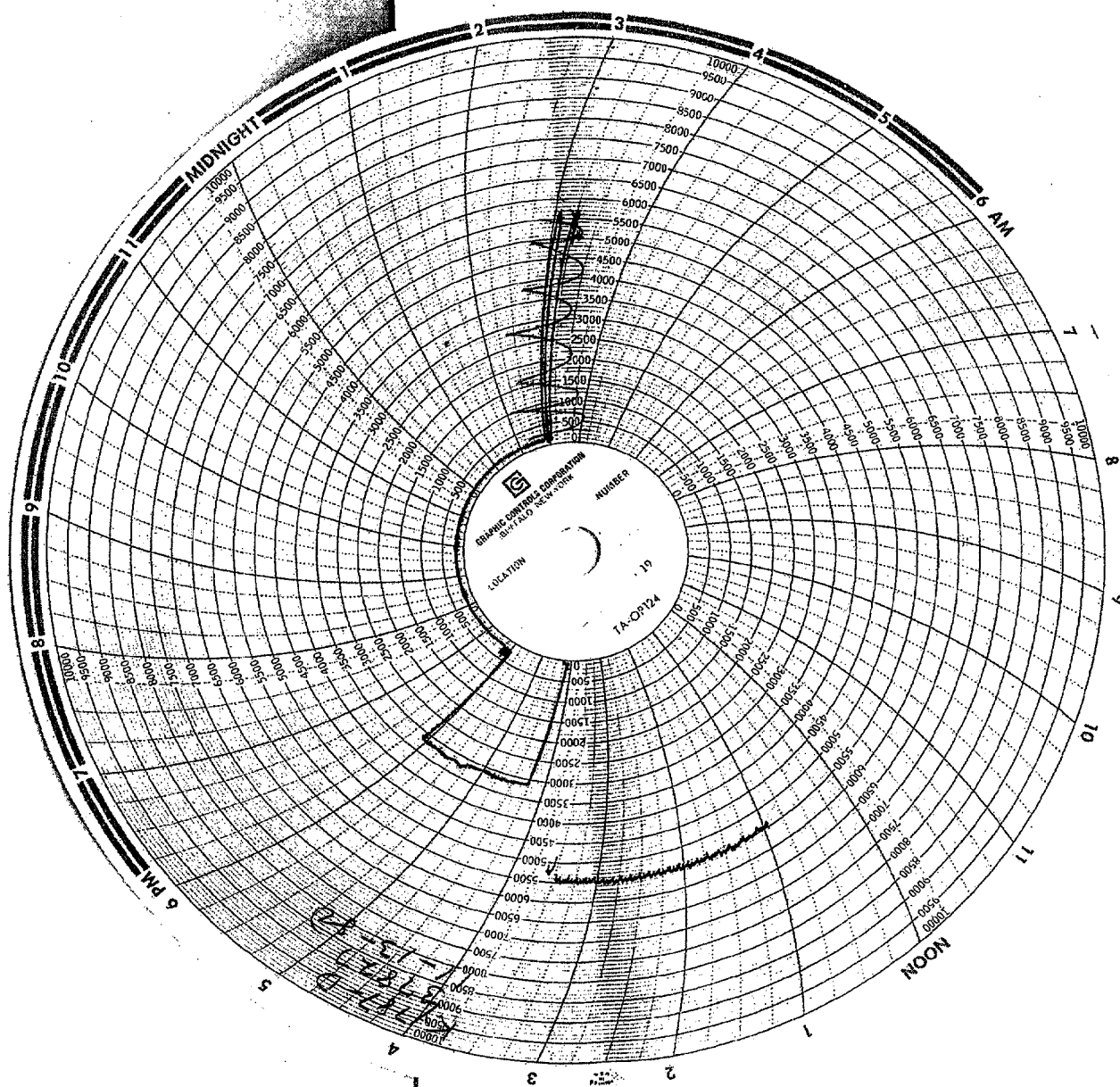
TOTAL EST'D WGT 3332

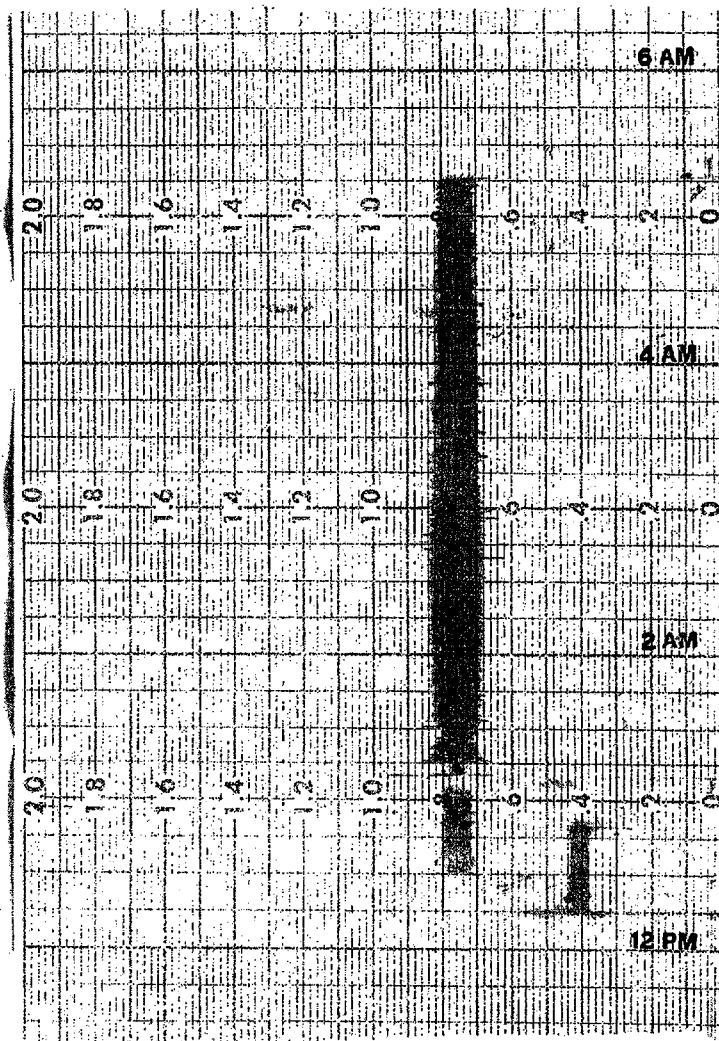
NON-BLEEDING

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	240	983-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 3300			
	FIN 4500			
	1 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 55" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-244 & START			
	AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 12:50P TOTAL MINUTES 110			
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 SET 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 28% PRESET #1 80 GAL	15-A		160
	B. 13LG 24% PRESET #6 135 GAL	20-A		135
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM	27-D		206
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.35			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM	983-D		1376
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	8EC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.82			

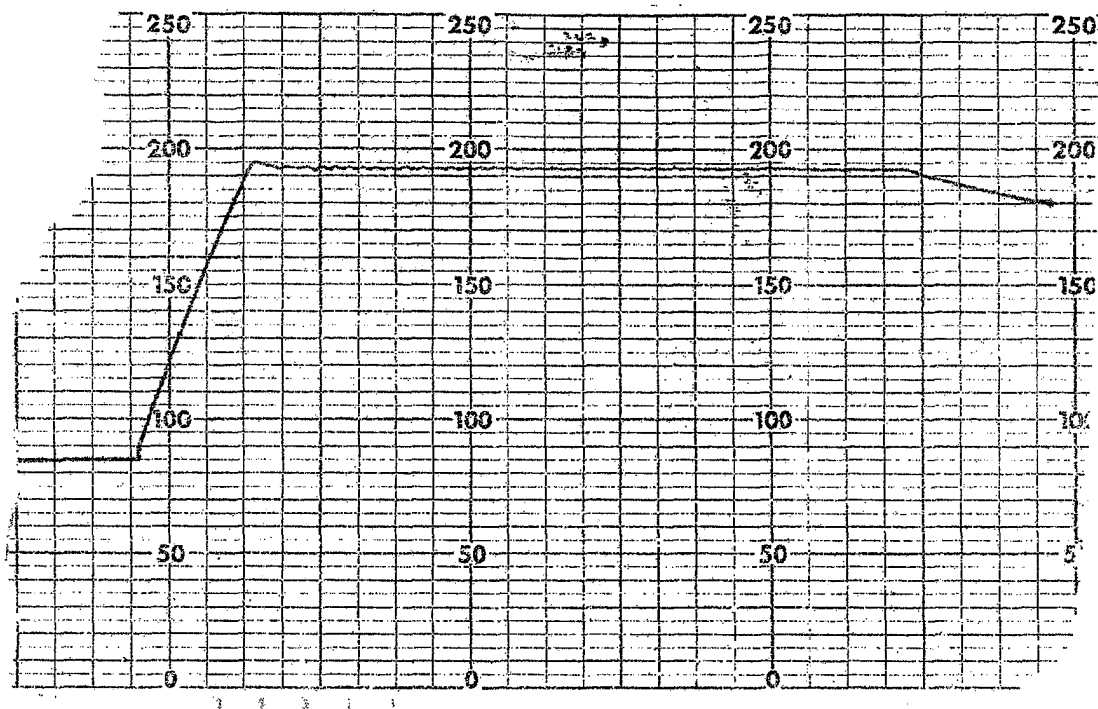
N34755

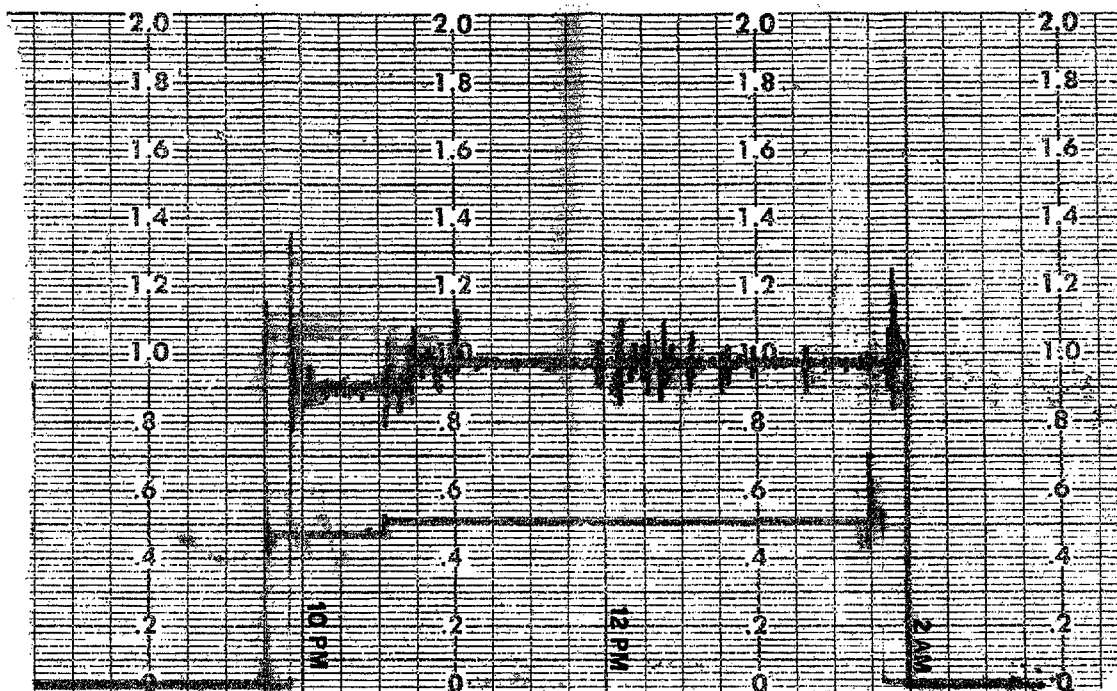
EQUIP		PAGE 2	CG 03	KY-7B-D	EST WGT 3332#	USE LBS	N- CODE	USE LBS
V-244								
116	OPERATOR STEP PB							
320	117 RECORD LEVEL 2LG ____% IF BELOW 35% FOLLOW SOL'N							
SV	MAKE-UP PROCEDURE FOR N-27-D							
SP	118 ADJUST SV TO 48" (2470 G)							
CP	119 RECORD PH <u>9.9</u> . ADJ TO 11.1-11.3 WITH N-7-D AT							
	5% (10 PARTS WATER TO 1 PART N-7-D)							
4	120 SIPHON INTO SV. RECORD: PH <u>11.2</u> ASSUME 50%					20	72-D	20
	120 OPERATOR STEP PB							
	121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.7</u>							
SV	122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO							
SP	123 OPERATOR STEP PB							
	124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 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>9.4</u> 9.0-10.0 <u>1:05 PM</u>							
	14/47 (60 MIN) <u>9.3</u> 9.0-10.0 <u>1:35 PM</u>							
	15/48 (2 HRS) <u>9.4</u> 9.0-10.0 <u>3:35 PM</u>							
	16/49 (3 HRS) <u>9.4</u> 9.0-10.0 <u>4:35 PM</u>							
	16/49 (4 HRS) <u>9.4</u> 9.0-10.0 <u>10:35 PM</u>							
	17/50 (FINISH) <u>1.3</u> 7.5-8.5 <u>11:20 PM</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	
	128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339							
	129 ADD IN 7-8 MIN					350	530-A	350
339	130 ADJ TO 49" (382 G) AT 80-100°F							
6	131 STIR 5 MIN & RECORD: PH ____ (9.5-10.5)							
	132 STIR 15 MIN OR LONGER FOR SP STEP 26							
	133 RECORD: VOL <u>49</u> " & CALC <u>49</u> " X 0.78 = <u>38.2</u> GAL							
	134 SET PRESET #8 TO <u>38.2</u> GAL FROM S 33							
302	135 RUN 30" (360 G) WATER INTO V-302							
7	136 ADD & STIR 2 MIN FOR S 40 ASSUME 50%					160	7-D	80
	137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.							
	138 SIFT IN					100	128-A	100
SV	139 SP STEP 23/53. RECORD: PH <u>9.9</u> (3.7-4.2)							
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>9.2</u> & TIME ____							
	144 OPERATOR STEP PB							
	145 SP STEP 60. BATCH COMPLETE.							
	START TIME SP STEP			FINISH TIME SP STEP		OPTR		
	<u>3:00 PM</u>			<u>12:15</u>		<u>20138</u>		
	<u>11 PM</u>					<u>170</u>		





No. 215A164





No. 215A164