

CG 03 CODE KY-787-D PKG
LOT 4011760 37266

NOV 11 1980

PROCESSES

APPROVED BY

EST'D WGT 932 LBS

() KY-787-D (Q) FWP 11/3/80
() (XOE-17: 25%
() LESS N-32-D
() & 240 MIN
() STRIKE)

STANDARD HRS. 8.9 TIME 11:00 AM

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13180	93	2000	14	YC002B	-----	93	-----
14	YC002B	13185	93	400	14	YC002B	-----	93	-----
14	YC002B	-----	93	-----	14	YC002B	-----	93	-----

PUNCHED & CHECKED (M)

**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 LOT	48X50	YC-2-B	2400
	RECORD: START 11:30 PM 13180	2000		
	FIN 11:55 PM 13185	400		
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	6 HOMOG AT 2400-2600 PSI INTO V-205			
	7 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	8 OF HOT WATER AT 2400-2600 PSI INTO V-205			
	9 RECORD: V-205 VOL " & ADJ TO 60" (2100 G)			
	10 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	11 RUN 10" (514 G) WATER INTO V-243 & START			
	12 AGITATOR			
	13 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 12:00 TOTAL MINUTES 215			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	14 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP			
	THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	15 SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
&	2 (V-243) OR POSITION 7 (V-244)			
CP	16 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	17 RECORD LEVELS & SET R/M COUNTER #1. AS FOLLOWS:			
	A. 11LG 64% PRESET #1 80 GAL 15-A 160			
	B. 13LG 62% PRESET #6 135 GAL 20-A 135			
	18 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			
	3FC10 (N-27-D/WATER) RATIO 1.35			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM 983-D 1376			
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	3FC20 (N-32-D WATER) IN REMOTE			
	3PR10 (N-32-D/WATER) RATIO 1.82			

N34757

EQUIP	PAGE 2	CG 03	KY-787-D	EST WGT 33324	USE LBS	N- CODE	USE LBS
<i>V-243</i>							
13	OPERATOR STEP PB						
320	17 RECORD LEVEL 2LG <i>9.3</i> % IF BELOW 35% FOLLOW SOL'N						
SV	18 MAKE-UP PROCEDURE FOR N-27-D						
SP	19 ADJUST SV TO 48" (2470 G)						
CP	20 RECORD PH <i>9.8</i> . ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)						
4	21 SIPHON INTO SV. RECORD: PH <i>11.2</i> ASSUME 77% <i>70</i>					221-D	<i>20</i>
120	22 OPERATOR STEP PB						
121	23 SP STEP 06/39. AFTER HEAT-UP RECORD: PH <i>9.9</i>						
SV	24 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO						
SP	25 OPERATOR STEP PB						
24	26 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB						
5	27 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE						
26	28 OPERATOR STEP PB						
27	29 DURING STRIKE RECORD: <i>7:35 PM</i>						
	30 SP STEP						
	V-243/V-244						
	13/46 (30 MIN)	PH	RANGE	TIME			
	14/47 (60 MIN)	<i>9.7</i>	9.0-10.0	<i>8:55 P</i>			
	15/48 (2 HRS)	<i>9.6</i>	9.0-10.0	<i>9:25 P</i>			
	16/49 (3 HRS)	<i>9.5</i>	9.0-10.0	<i>9:55 P</i>			
	16/49 (4 HRS)	<i>9.4</i>	9.0-10.0	<i>10:25 P</i>			
	17/50 (FINISH)	<i>9.1</i>	9.0-10.0	<i>11:25 P</i>			
	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.						
	& RECORD: PH <i>7.5</i> ASSUME 77%					27-D	
25	31 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339						
339	32 ADD IN 7-8 MIN				350	530-A	350
6	33 ADJ TO 49" (382 G) AT 80-100°F						
31	34 STIR 5 MIN & RECORD: PH <i>10.0</i> (9.5-10.5)						
32	35 STIR 15 MIN OR LONGER FOR SP STEP 26						
33	36 RECORD: VOL <i>49</i> " & CALC <i>49</i> " X 0.78 = <i>38.2</i> GAL						
34	37 SET PRESET #8 TO <i>38.2</i> GAL FROM S 33						
302	38 RUN 30" (360 G) WATER INTO V-302						
7	39 ADD & STIR 2 MIN FOR S 40 <i>Delay</i> ASSUME 50% <i>50%</i> <i>80</i>					721-A	80
37	40 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.						
38	41 SIFT IN				100	128-A	100
SV	42 SP STEP 23/53. RECORD: PH <i>3.5</i> (3.7-4.2)						
SP	43 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN						
8	44 RECORD: PH <i>7.0</i> (9.0-9.5). ADJ IF NECESSARY & RECORD: PH <i>7.0</i> ASSUME 77%					27-D	
	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%					7-D	
	45 SIPHON N-7-D INTO SV						
42	46 OPERATOR STEP PB						
43	47 SP STEP 29/58. RECORD: PH <i>9.5</i> & TIME <i>12:40 P</i>						
44	48 OPERATOR STEP PB						
45	49 SP STEP 60. BATCH COMPLETE.						
<i>Pump to 240 VBT</i>							
	START		FINISH		OPTR		
	TIME SP STEP		TIME SP STEP				
	<i>9:00 PM</i>		<i>11:00 PM</i>		<i>37</i>		
	<i>11:00 PM</i>		<i>12:40 PM</i>		<i>342</i>		