

(AUTOMATED)
S.V. 243, 244

C.V.

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-795-D PKG
LOT MAY-1 35593

PROCESSES APPROVED BY

() KY-795-D (H) FWP 4/23/80

EST'D WGT 1110 880 LBS

STANDARD HRS. 8.2 TIME 7:11 M

TYPED BY: FWP 4/23/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	24777	93	2000	14	YC002B		93	
14	YC002B	24463	93	1200	14	YC002B		93	
14	YC002B	24776	93	120	14	YC002B		93	

TOTAL EST'D WGT 4612 4380

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ACC LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN	475	32-D	475
	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
	RECORD: START	2000		
	FIN	1400		
	4 ADJUST TO 75" (1275 G)	120		
	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 58" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 1140 TOTAL MINUTES 95			
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 5 (V-243) OR POSITION 10 (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. HLG 40% PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 0.71			296
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.75 GPM		27-D	394
	3EC20 (N-27-D WATER) IN MANUAL LOCAL 7.7 GPM			
	3FR10 (N-27-D/WATI) RATIO 0.90 0.8 5.8			
	BPC10 (N-32-D CON LER) IN MANUAL 1.27 GPM		32-D	267
	BEC20 (N-32-D WATER) IN MANUAL LOCAL 6.2 GPM			1885
	BFR10 (N-32-D WATER) RATIO 1.0			

243

EQUIP PAGE 2 CG 03 KY-795-D EST WGT 4612#

USE N- USE
LBS CODE LBS

SV	16	OPERATOR STEP PB				
SP	17	RECORD LEVEL 2LG <i>42%</i> IF <35% FOLLOW SOLUTION				
CP	18	MAKE-UP PROCEDURE FOR N-27-D				
	19	ADJUST SV TO 68" (3495 G)				
4	20	RECORD PH <i>10.4</i> ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)				
	21	SIPHON INTO SV. RECORD: PH <i>11.2</i> ASSUME 50%	<i>20</i>	7-D	<i>10</i>	
	22	OPERATOR STEP PB				
SV	23	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <i>9.95</i>				
SP	24	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
	25	OPERATOR STEP PB				
5	26	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB				
	27	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE	<i>3:35</i>			
	28	OPERATOR STEP PB				
	29	DURING STRIKE RECORD:				
	30	SP STEP				
	31	V-243/V-244				
	32	13/46 (30 MIN)	<i>9.2</i>	9.0-10.0	<i>4.05</i>	
	33	14/47 (60 MIN)	<i>9.8</i>	9.0-10.0	<i>4.35</i>	
	34	15/48 (2 HRS)	<i>9.5</i>	9.0-10.0	<i>5.35</i>	
	35	16/49 (3 HRS)	<i>8.0</i>	9.0-10.0	<i>6.35</i>	
	36	17/50 (FINAL 3 HRS)	<i>8.0</i>	7.5-8.5	<i>7.20</i>	
	37	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.				
	38	& RECORD: PH				
	39					
	40					
DRUM	41	WEIGH INTO 55 GAL DRUM	ASSUME 50%	56	7-D	28
6	42	FILL WITH WATER & STIR 2 MIN				
SV	43	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.				
SP	44	SP STEP 23/53 - RECORD: PH <i>7.6</i> (3.3-3.7)				
CP	45	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7				
	46	RECORD: PH				
7	47	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140				
	48	*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.				
	49	STIR 5 MIN AFTER EACH ADDITION.				
	50	SIFT IN				
	51	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN	<i>150</i>	128-A	<i>150</i>	
	52	RECORD: PH <i>4.1</i> (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH				
	53	(DILUTE 10 TO 1 WITH WATER)	ASSUME 77%		27-D	
	54	SIPHON N-7-D INTO SV	ASSUME 50%		7-D	
	55	OPERATOR STEP PB				
	56	SP STEP 24/54 - POUR IN & STIR 15 MIN	<i>22</i>	978-A	<i>22</i>	
	57	OPERATOR STEP PB				
	58	SP STEP 60 - BATCH COMPLETE				
	59	OPERATOR STEP PB				

START
TIME SP STEP

10AM

3PM

FINISH

TIME STEP

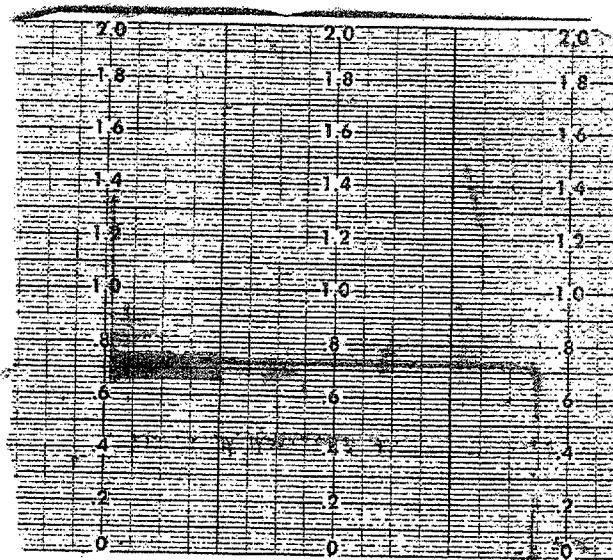
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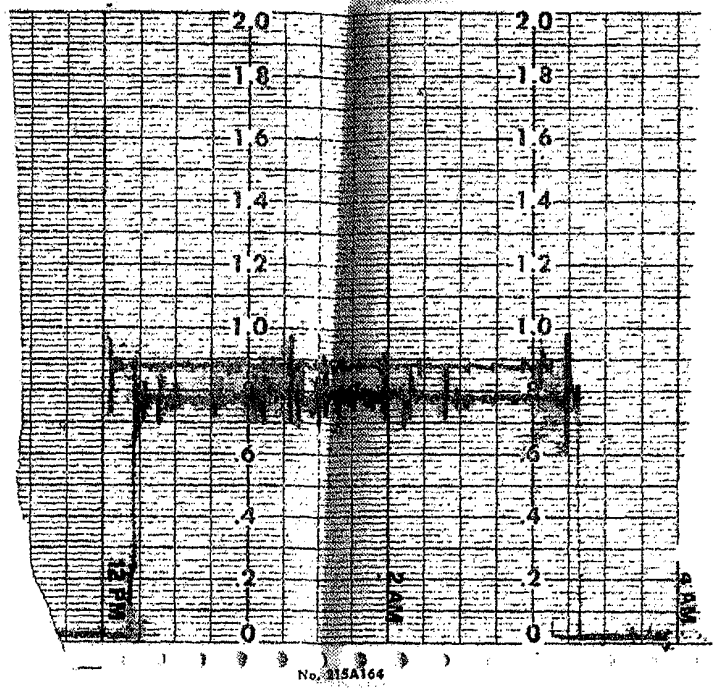
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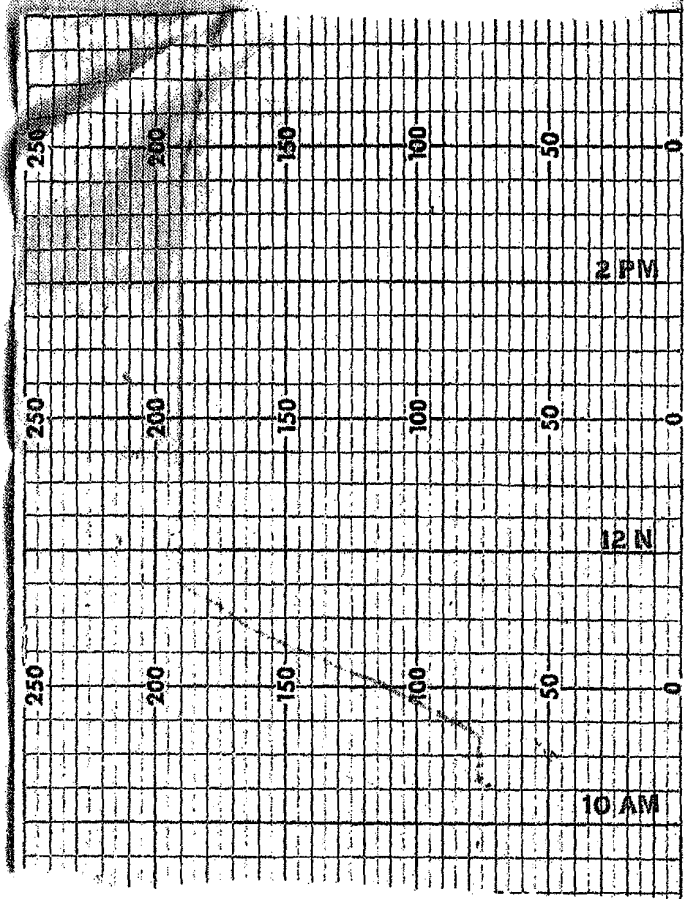
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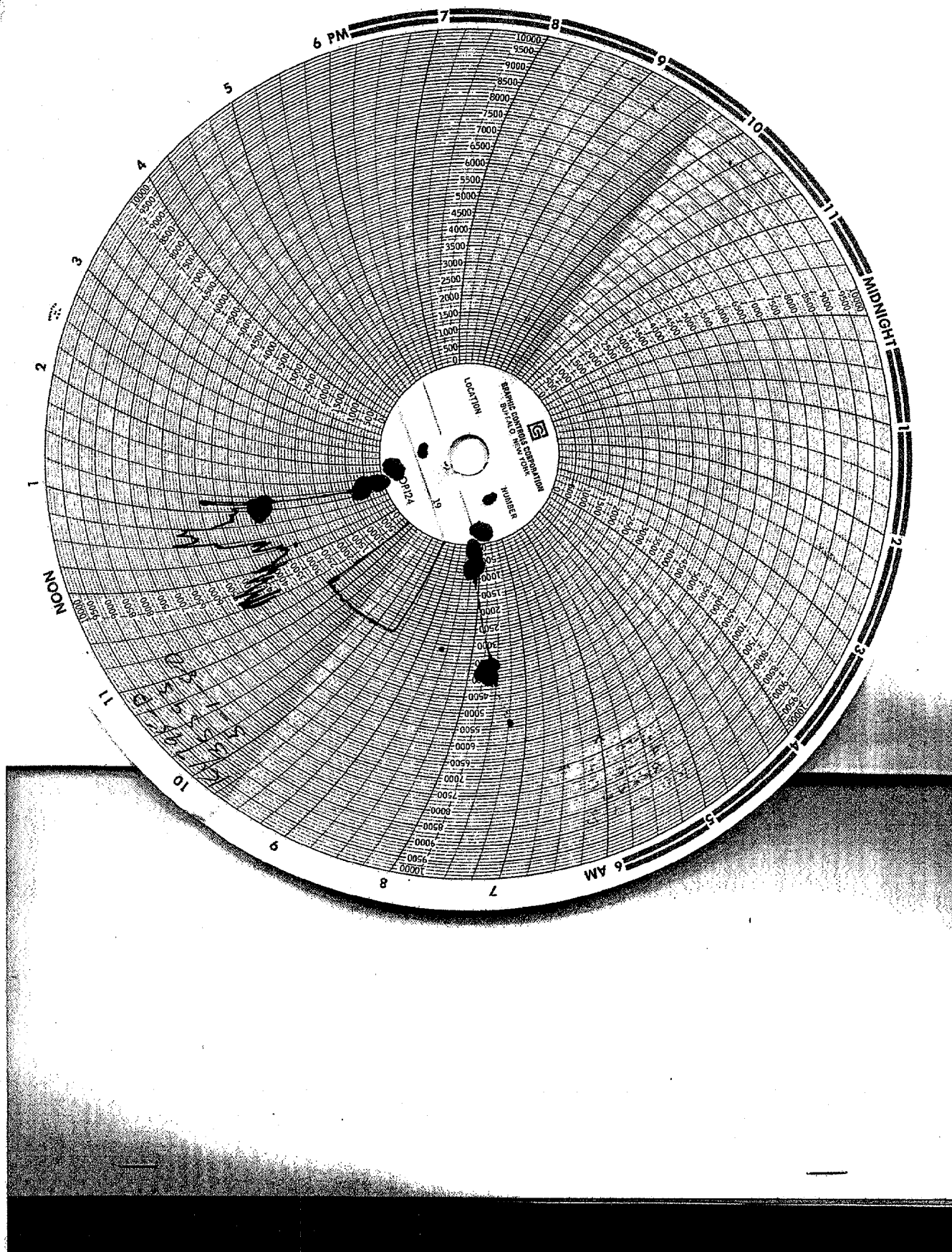


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