

CG 03 CODE KY-788-D PKG

LOT MAY -0-81-21316

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 5/14/80

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JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	13416	93	345	14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	

03 KY788-D 82946-1

DO NOT USE YC-3-B LOTS 14001 THRU 14004

HOMOG #3-TSPASS
H 3-2nd

TOTAL EST'D WGT 3560 3610

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	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	345	32-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START			
	FIN			
	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 42" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START TO STOP 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	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)			
&	13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
CP	REMODE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 33% PRESET #2 208 GAL	15-A		416
	B. 13LG 61% PRESET #6 135 GAL	20-A		135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FD10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM	27-D		180
	3FD20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.8			
	3FE10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM	32-D		1215
	3FE20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	3FR20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.1			

EQUIP	PAGE 2	CG 2	KY-788-D	EST WGT 3560#	USE LBS	N- CODE	USE LBS
V-244							
320	16	OPERATOR STEP PB					
SV	17	RECORD LEVEL 2LG 82% IF <35% FOLLOW SOLUTION					
SP	18	MAKE-UP PROCEDURE FOR N-27-D					
CP	19	ADJUST SV TO 47" (2400 G)					
	19	RECORD PH 9.1. ADJ TO 11.0-11.2 WITH N-7-D AT					
4		5% (10 PARTS WATER TO 1 PART N-7-D)					
		SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	50		7-D	25	
	20	OPERATOR STEP PB					
SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5					
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO					
	23	OPERATOR STEP PB					
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS					
5		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB					
	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) 9.1 9.3-10.0 3:40/p					
		14/47 (60 MIN) 9.2 9.3-10.0 4:10/p					
		15/48 (2 HRS) 9.3 9.3-10.0 5:10/p					
		16/49 (2 HRS, 25 MIN) 9.3 9.3-10.0 5:35/p					
		17/50 (FINAL 3 HRS) 7.3 7.5-8.5 6:10/p					
		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	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339					
	29	ADD IN 7-8 MIN	350		530-A	350	
6	30	ADJ TO 49" (382 G) AT 80-100*F					
	31	STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)					
	32	STIR 15 MIN OR LONGER FOR SP STEP 26/56					
	33	RECORD: VOL 42" & CALC 42" X 0.78 = 38.2 GAL					
	34	SET PRESET #8 TO 38.2 GAL FROM S 33					
302	35	RUN 40" (440 G) WATER INTO V-302					
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360		7-D	180	
	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.					
SV	38	SIFT IN	100		128-A	100	
SP	39	SP STEP 23/53. RECORD: PH 3.7 (3.7-4.2)					
	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5					
		MIN					
8	41	RECORD: PH 9.2 (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)					
	42	OPERATOR STEP PB					
	43	SP STEP 29. RECORD: PH 9.5 & TIME 2:11 PM					
	44	OPERATOR STEP PB					
	45	SP STEP 60. BATCH COMPLETE.					

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
7:00 AM	3:00 PM	381.223
3:00 PM	2:00 PM	109.54