

S.V. 243, (244)

C.V.

D.V.

CG 03 CODE KY-787-D PKG

LOT

NOV --6 80 37761

EST'D WGT 932 LBS

STANDARD HRS. 8.9

TIME 3P M

PROCESSES

APPROVED BY

() KY-787-D (Q) FWP 11/3/80

() (X08-17: 25%

() () LESS N-32-D

() () & 240 MIN

() () STRIKE)

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13197	93	2000	14	YC002B		93	
14	YC002B	13193	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

PUMPED & CHECKED

NOV 11 1980

NOV 7 1980

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 7:13:00 LOT 13197	2000		
	FIN 10:40:00 400			
	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 14" & 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 2:45 PM TOTAL MINUTES 125			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 7-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			
&	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 62% PRESET #1 80 GAL		15-A	160
	B. 13LG 92% 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			
	8FD10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		983-D	1376
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	8FD20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.82			

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16 OPERATOR STEP PB
 320 17 RECORD LEVEL 2LG 84% IF BELOW 35% FOLLOW SOL'N
 SV MAKE-UP PROCEDURE FOR N-27-D
 SP 18 ADJUST SV TO 48" (2470 G)
 CP 19 RECORD PH 9.5 ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50% 7-D
 20 OPERATOR STEP PB

24 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.4
 SV 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 23 OPERATOR STEP PB
 24 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 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: 8.40
 SP STEP
 V-243/V-244

PH	RANGE	TIME
13/46 (30 MIN)	9.0-10.0	9:10
14/47 (60 MIN)	9.0-10.0	9:40
15/48 (2 HRS)	9.0-10.0	10:40
16/49 (3 HRS)	9.0-10.0	11:40
16/49 (4 HRS)	9.0-10.0	12:40
17/50 (FINISH)	7.5-8.5	1:25

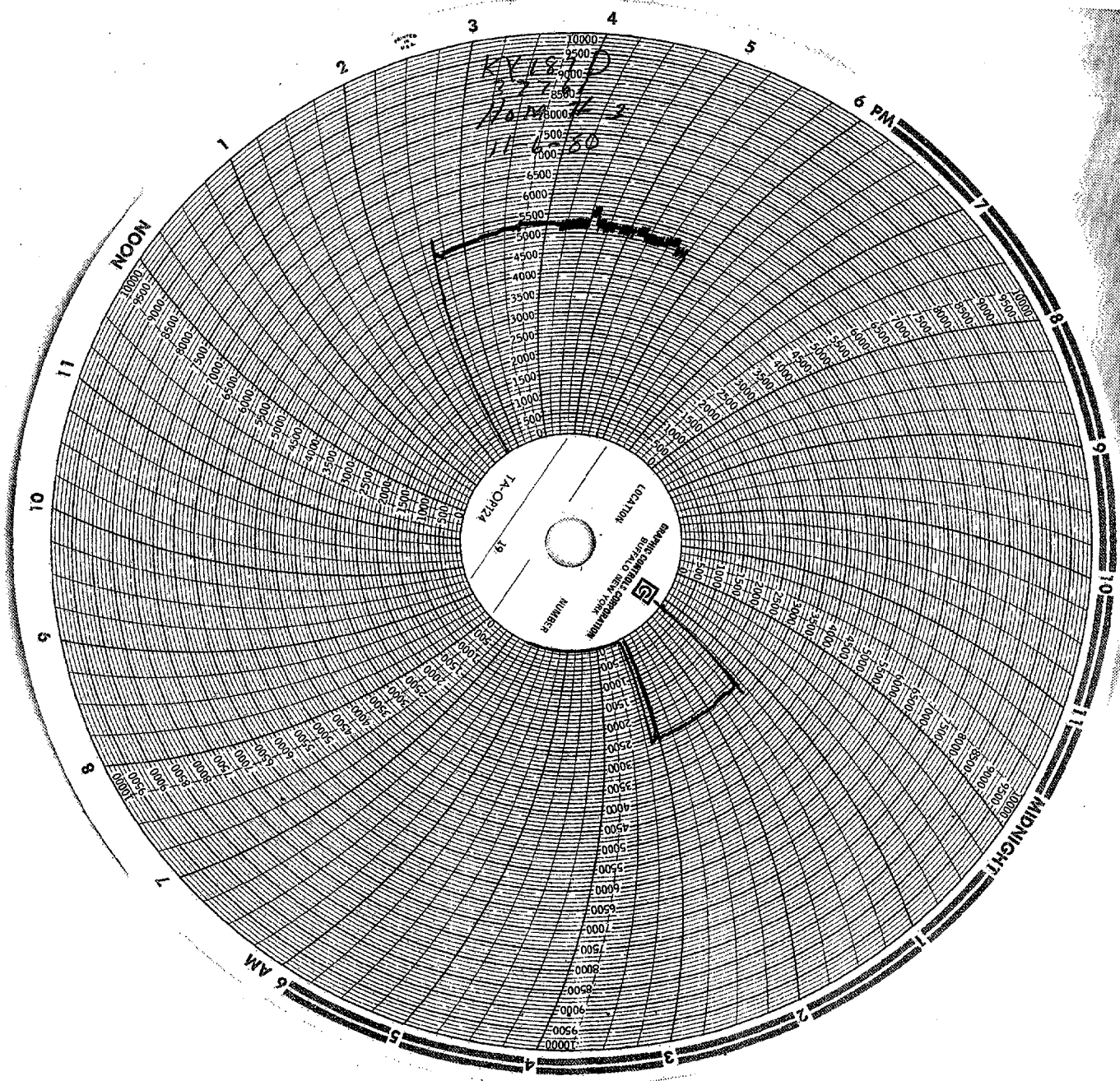
NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE
 IN LOG. IF FINAL PH > 8.5, ADJ TO 7.5-8.5.
 & RECORD: PH ASSUME 77% 27-D

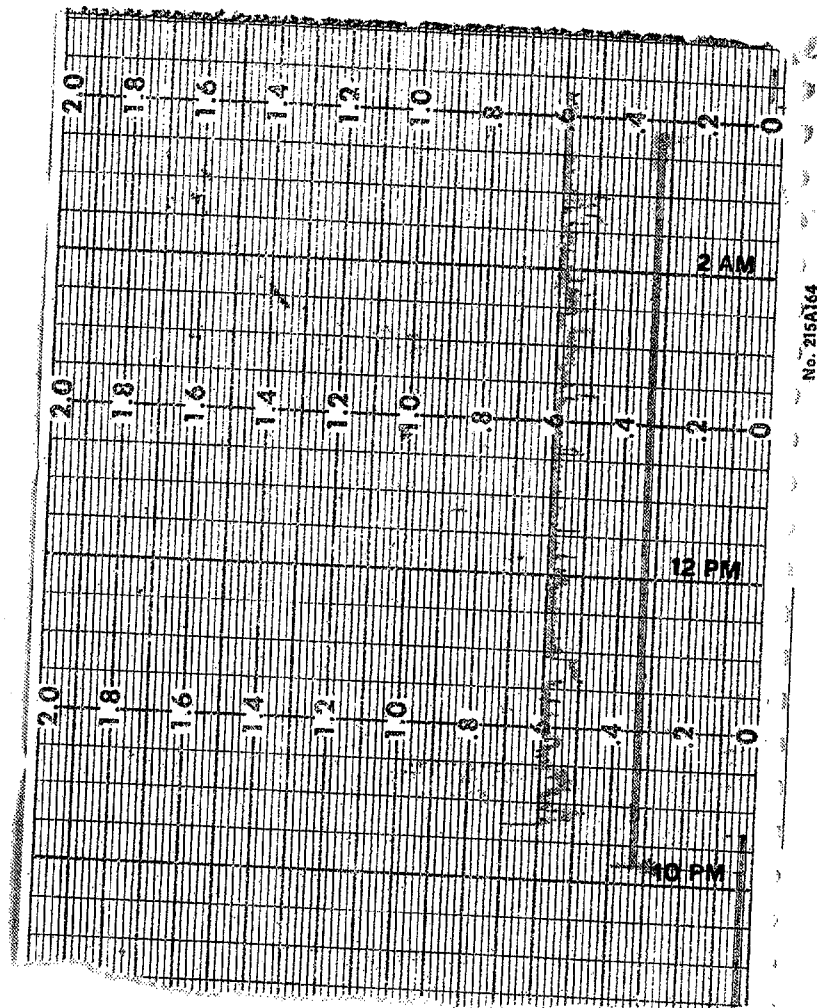
28 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 29 ADD IN 7-8 MIN 350 530-A 350
 339 30 ADJ TO 49" (382 G) AT 80-100°F
 6 31 STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)
 32 STIR 15 MIN OR LONGER FOR SP STEP 26
 33 RECORD: VOL 19" & CALC 19" X 0.78 = 36.2 GAL
 34 SET PRESET #8 TO 36.2 GAL FROM S 33

302 35 RUN 30" (360 G) WATER INTO V-302
 7 36 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

37 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 38 SIFT IN 100 128-A 100
 SV 39 SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)
 SP 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 29/58. RECORD: PH 9.2 & TIME 2:30 AM
 44 OPERATOR STEP PB
 45 SP STEP 60. BATCH COMPLETE.

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
7:00 AM		3:00 PM		201-409
2:30 PM		1:10		120-306
2:30 PM		2:30 AM		237





No. 215A164

