CG 03 CODE KY-788-D PKG

1/7/82 A2H54

DATE LOT NUMBER

OK/10

PROCESSES APPROVED BY

( ) KY-788-D (J) FWP 12/09/81

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STANDARD HRS. 8.8 TIME 7 AM JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	14853	93	2000	14	YC-3-B	_____	93	_____
14	YC-3-B	14860	93	600	14	YC-3-B	_____	93	_____
14	YC-3-B	_____	93	_____	14	YC-3-B	_____	93	_____

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

TOTAL EST'D WGT 3489* LBS. NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N-CODE	ACCT LBS
203 & 205	1	RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	345	32-D	345
	3	DUMP IN AND STIR 5 MIN LOT	52X50	YC-3-B	2600
		RECORD: START 1:45 PM 14853	2000		
1		FIN 2:45 PM 14860	600		
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CUASE DUSTING IN EXHAUST HOOD.			
	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 44" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9	RUN 10" (514 G) WATER INTO V-203 & START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 1:30 PM 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 & CP	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 REMOTE (TEMP IS SET AT 190-194*F)			
3	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
		A. 11LG 46% PRESET #2 78 GAL		115-A	416
		B. 13LG ____% PRESET #6 MK IN-V-3 35 GAL		20-A	135
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM		27-D	180
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
		3FR10 (N-27-D/WATER) RATIO 0.8			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM		32-D	1215
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.1			

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EQUIP MENT		PAGE 2 CG 03 KY-788-D COMTYP JOB NAME: 03KY788DMJ	USE LBS	N-CODE	ACCT LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 36 % IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 47" (2400 G)			
CP	19	RECORD PH 9.7. ADJ TO 11.0-11.2 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	40	7-D	20
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7			
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			
5	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD: 5:30 P.M			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.5 9.3-10.0 6:00 P.M			
		14/47 (60 MIN) 9.5 9.3-10.0 6:30 P.M			
		15/48 (2 HRS) 9.5 9.3-10.0 7:30 P.M			
		16/49 (2 HRS, 25 MIN) 9.5 9.3-10.0 7:55 P.M			
		17/50 (FINAL 3 HRS) 7.9 7.5-8.5 8:30 P.M			
		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 10.0 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	34	SET PRESET #8 TO 38.2 GAL FROM S 33			
~~385~~	35	RUN 57" (440 G) WATER INTO V-~~385~~ 302			
7 302	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180
	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 9.4 (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 9.3 & TIME 9:15 A.M			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			
		48-A PUMP V243 OVER TO V240			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
7:45 P	____	11 P	____	44
7 A.M	____	9:15 A.M	____	54
____	____	____	____	____

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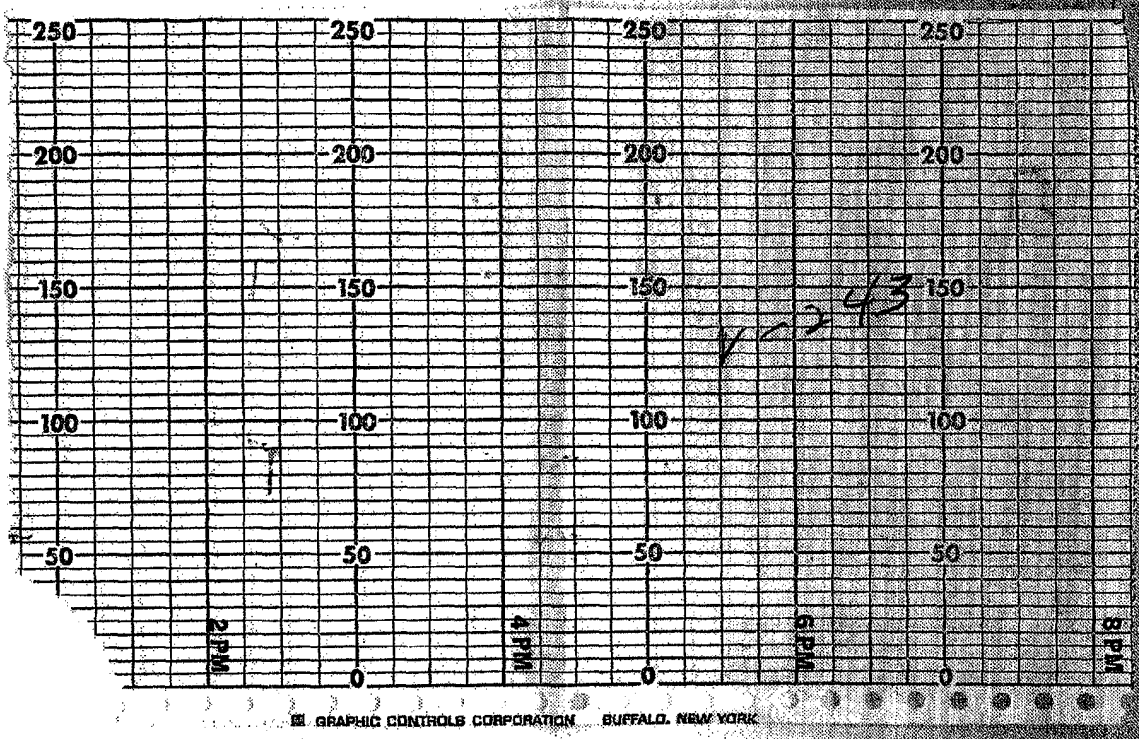

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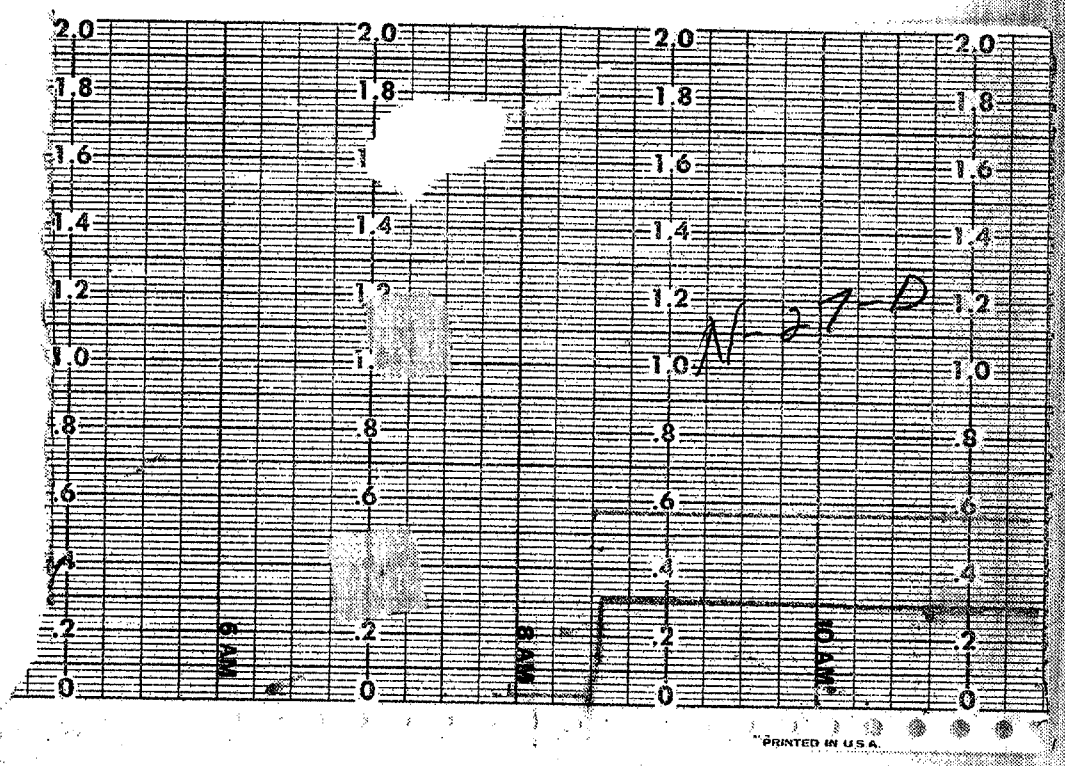

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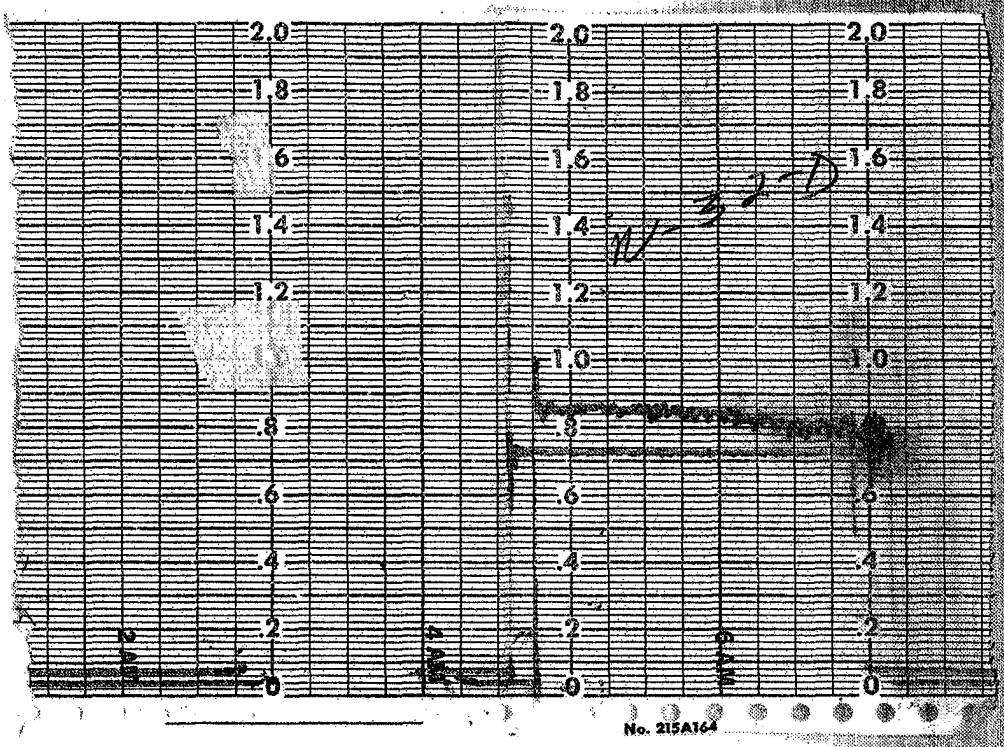

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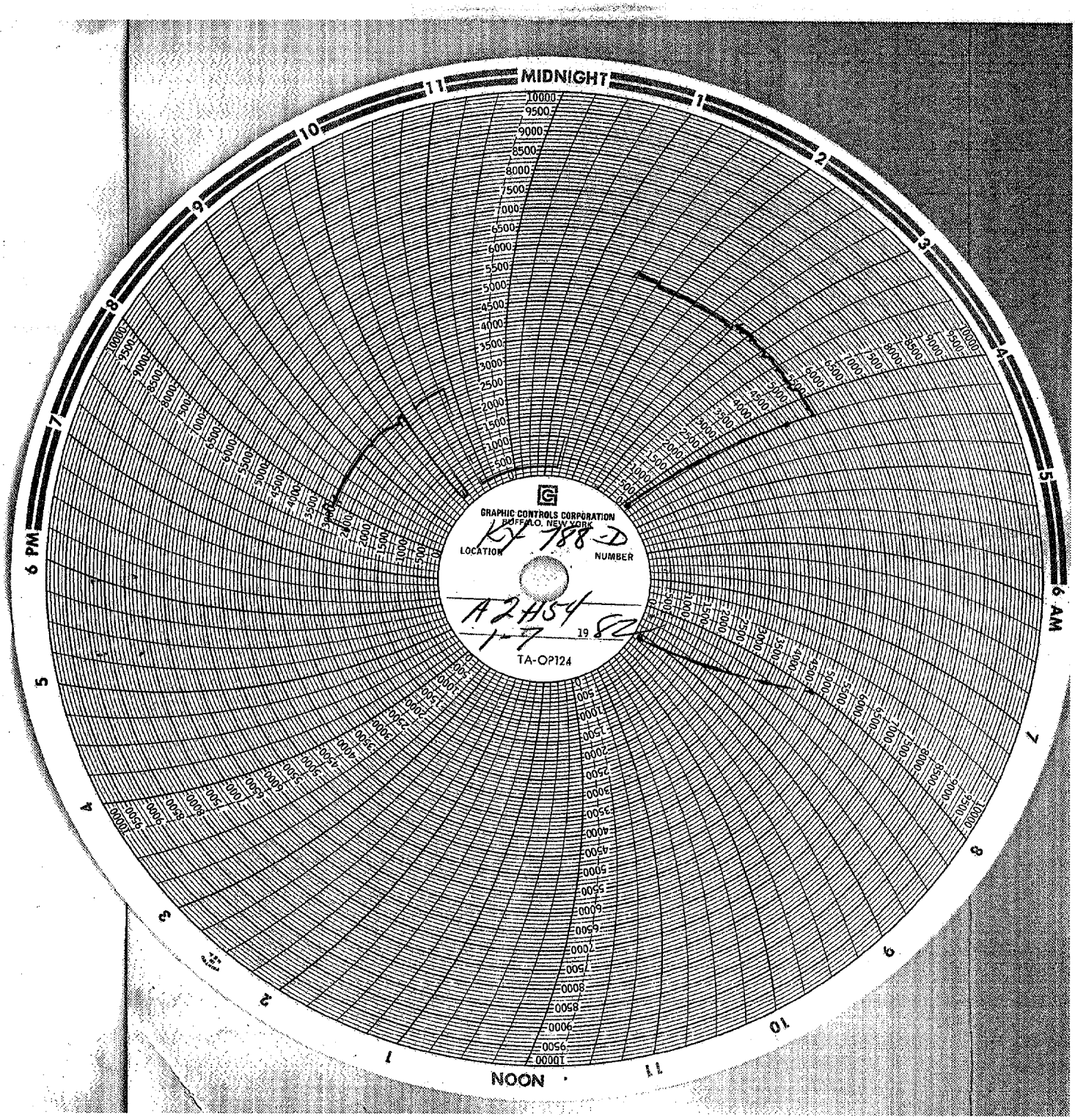

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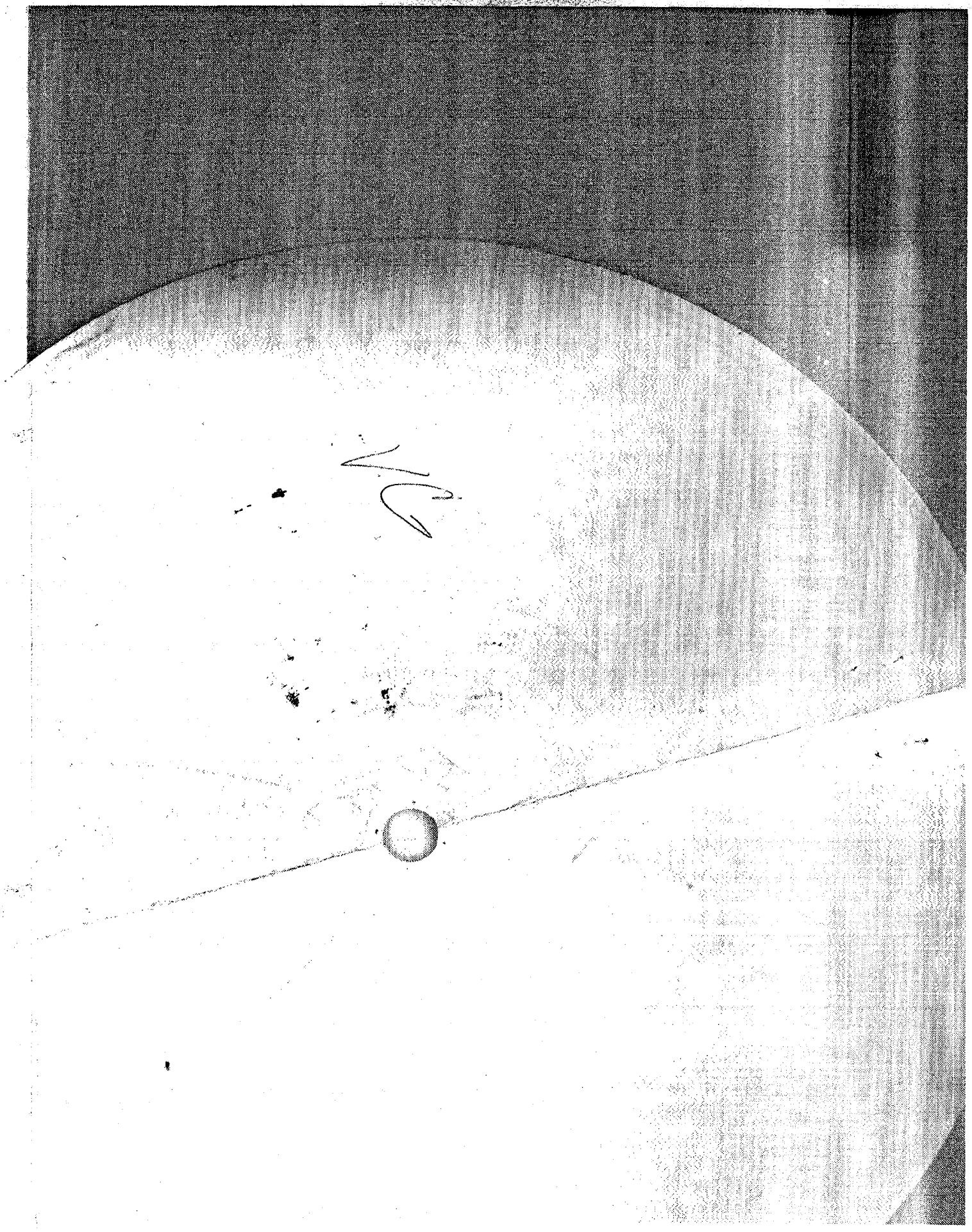

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