

(AUTOMATED)
S.V. (243), 244

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-795-D PKG
LOT
JUN10 30065 PUNCHED & CHECKED
EST'D WGT 880 LBS JUN 16 1980
STANDARD HRS. 8.2 TIME 7 AM

PROCESSES APPROVED BY
() KY-795-D (H) FWP 5/1/80
() 3/4 N-32-D STRIKE TO
() IMPROVE GLOSS
()
()
TYPED BY: FWP 5/1/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	24462	93	2000	14	YC002B		93	
14	YC002B	24464	93	1500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

Note STEP 201 - Heating

Homog #4 - 2nd Pass

TOTAL EST'D WGT 4380

NON-BLEEDING

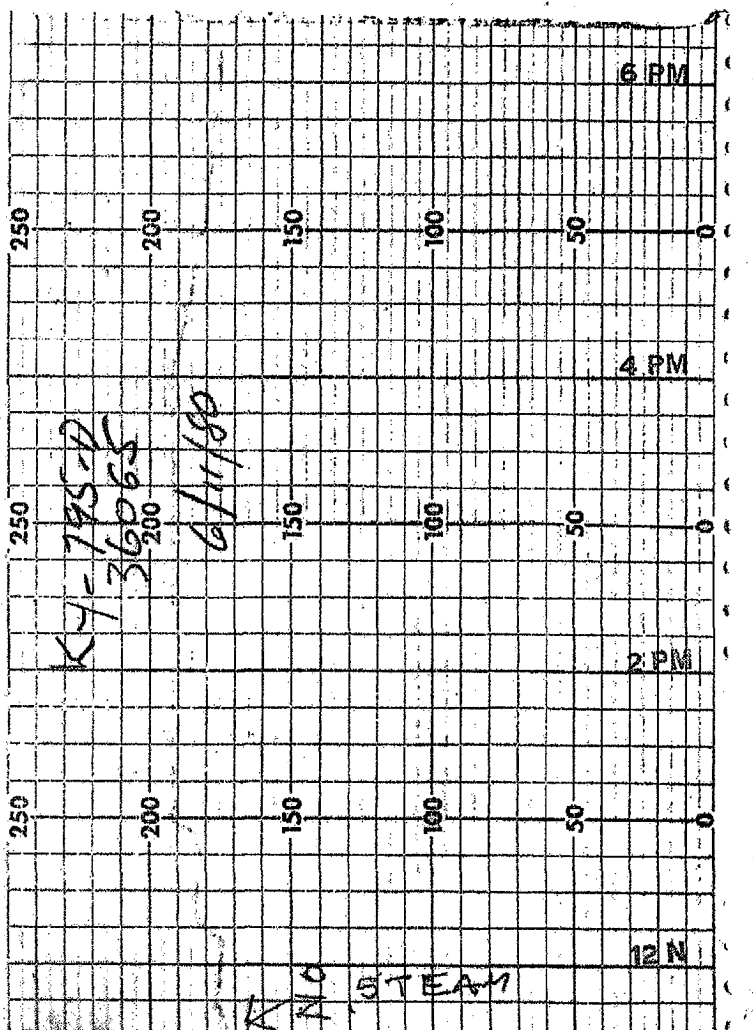
QUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ACCT LBS
03 & 05	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN	475	32-D	475
	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
	RECORD: START 4:00	2000		
	FIN 5:30	1500		
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR 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 & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
05	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
IV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START TOTAL MINUTES 120			
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 112 & CP 113	12 SET STEP 04 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (V-244)			
	13 PRESS SV CAM RESET PB - SET 22 TO IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 65% PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.71 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM 3FR10 (N-27-D/WATER) RATIO 0.8 BFC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM BFL20 (N-32-D WATER) IN REMOTE BFR10 (N-32-D/WATER) RATIO 1.0		27-D 32-D	296 1885

V-243

QUIP	PAGE 2	CG 03	KY-795-D	EST WGT 4812#	USE LBS	N-7 CODE	USE LBS
16	OPERATOR STEP PB						
17	RECORD LEVEL 2LG 62% IF <35% FOLLOW SOLUTION						
SV	MAKE-UP PROCEDURE FOR N-27-D						
18	ADJUST SV TO 48" (3495 G)						
19	RECORD PH 11.3 ADJ TO 11.1-11.3 WITH N-7-D AT						
20	5% (10 PARTS WATER TO 1 PART N-7-D)						
21	SIPHON INTO SV. RECORD: PH 11.1	ASSUME 50%	40	7-D	15		
22	OPERATOR STEP PB						
23	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8						
24	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO						
25	OPERATOR STEP PB						
26	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS						
27	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB						
28	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN						
29	LIMITS, SWITCH 3FC20 TO REMOTE						
30	OPERATOR STEP PB						
31	DURING STRIKE RECORD:						
32	SP STEP						
33	V-243/V-244						
34	PH RANGE TIME						
35	13/46 (30 MIN)	9.6	9.0-10.0	5:10A			
36	14/47 (60 MIN)	9.6	9.0-10.0	5:40A			
37	15/48 (2 HRS)	9.65	9.0-10.0	6:10A			
38	16/49 (3 HRS)	9.6	9.0-10.0	7:40A			
39	17/50 (FINISH)	8.2	7.5-8.5	8:25A			
40	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE						
41	IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.						
42	& RECORD: PH	ASSUME 77%			27-D		
43	WEIGH INTO 55 GAL DRUM	ASSUME 50%	56	7-D	28		
44	FILL WITH WATER & STIR 2 MIN						
45	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.						
46	SP STEP 23/53 - RECORD: PH (3.3-3.7)						
47	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7						
48	RECORD: PH				15-A		
49	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140						
50	*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.						
51	STIR 5 MIN AFTER EACH ADDITION.						
52	SIFT IN		150	128-A	150		
53	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR						
54	5 MIN						
55	RECORD: PH 4.1 (4.0-4.2) & IF NECESSARY ADJ TO						
56	PH 4.0-4.2 & RECORD: PH	ASSUME 77%		27-D			
57	(DILUTE 10 TO 1 WITH WATER)	ASSUME 50%		7-D			
58	SIPHON N-7-D INTO SV						
59	OPERATOR STEP PB						
60	SP STEP 24/54 - POUR IN & STIR 15 MIN		22	978-A	22		
61	OPERATOR STEP PB						
62	SP STEP 60 - BATCH COMPLETE						
63	OPERATOR STEP PB						

Note: STEP 20 - STOPPED HEATING 3:15 AM No S team DOWN 75 MIN

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
11:00 AM	11:00 AM	225-37-322
1:00 AM	10:30 AM	381-223



DUP050456490

N32077.01

