

(AUTOMATED)
S.V. 243 244

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-788-D PKG

LOT NOV-24-80 13012

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 11/3/80

() () 4 HOUR STRIKE

() () AS FOR XOB-17

() ()

() ()

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC003B	13081	93	2600
14	YC003B		93	
14	YC003B		93	

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

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ACCT LBS
203 & 205	✓ RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.	350		350
✓	WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	345	983-D	345
✓	RECORD: START 12:03 LOT 13081	52X50	YC-3-B	2600
✓	FIN 8:45			
✓	ADJUST TO 75" (1275 G)			
✓	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
✓	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
→	RECORD: V-205 VOL 46" & ADJ TO 60" (2100 G)			
✓	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	✓ RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	✓ PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 12:40 TOTAL MINUTES 120			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
✓	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP & CP	✓ SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION B (V-244)			
3	✓ PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
✓	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
✓	A. 11LG 30% PRESET #2 208 GAL		15-A	416
✓	B. 13LG 25% PRESET #4 135 GAL		20-A	135
✓	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
✓	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM		27-D	180
✓	3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM			
✓	3FR10 (N-27-D/WATER) RATIO 0.8			
✓	BFC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM		983-D	4215
✓	BFC20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM			1240
✓	BFC20 (N-32-D WATER) IN REMOTE			
✓	BFR10 (N-32-D/WATER) RATIO 1.1			

EQUIP PAGE 2 CG 03 KY-788-D EST WGT 3560#

USE
LBSN-
CODEUSE
LBS

243

320 13 OPERATOR STEP PB
 SV 14 RECORD LEVEL 2LG 37% IF <35% FOLLOW SOLUTION
 SP 15 MAKE-UP PROCEDURE FOR N-27-D
 CP 16 ADJUST SV TO 47" (2400 G)
 17 RECORD PH 9.8. ADJ TO 11.0-11.2 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 18 SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%
 120 19 OPERATOR STEP PB

20

721-9

20

SV 21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0
 SP 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 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:
 SP STEP

6:35 PM

V-243/V-244

13/46 (30 MIN)

14/47 (60 MIN)

15/48 (2 HRS)

16/49 (3 HRS)

16/49 (4 HRS)

17/50 (FINISH)

PH	RANGE	TIME
9.7	9.3-10.0	7:05 PM
9.5	9.3-10.0	7:25 PM
9.5	9.3-10.0	8:25 PM
9.5	9.3-10.0	9:25 PM
9.5	9.3-10.0	10:25 PM
9.5	9.3-10.0	11:25 PM
11.7	7.5-8.5	11:25 PM

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
 339 30 ADJ TO 49" (382 G) AT 80-100°F
 6 31 STIR 5 MIN & RECORD: PH ____ (9.5-10.5)
 32 STIR 15 MIN OR LONGER FOR SP STEP 26/56
 33 RECORD: VOL 45" & CALC 45" X 0.78 = 35.25 GAL
 34 SET PRESET #8 TO 35.25 GAL FROM S 33

350

530-A

350

302 35 RUN 40" (440 G) WATER INTO V-302

180

721-9

180

7 36 ADD & STIR 2 MIN FOR S 40

ASSUME 50%

240

721-9

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 3.8 (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 9.45 (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 9.4 & TIME 12:40 PM

44 OPERATOR STEP PB

45 SP STEP 60. BATCH COMPLETE.

START

FINISH

OPTR

TIME SP STEP

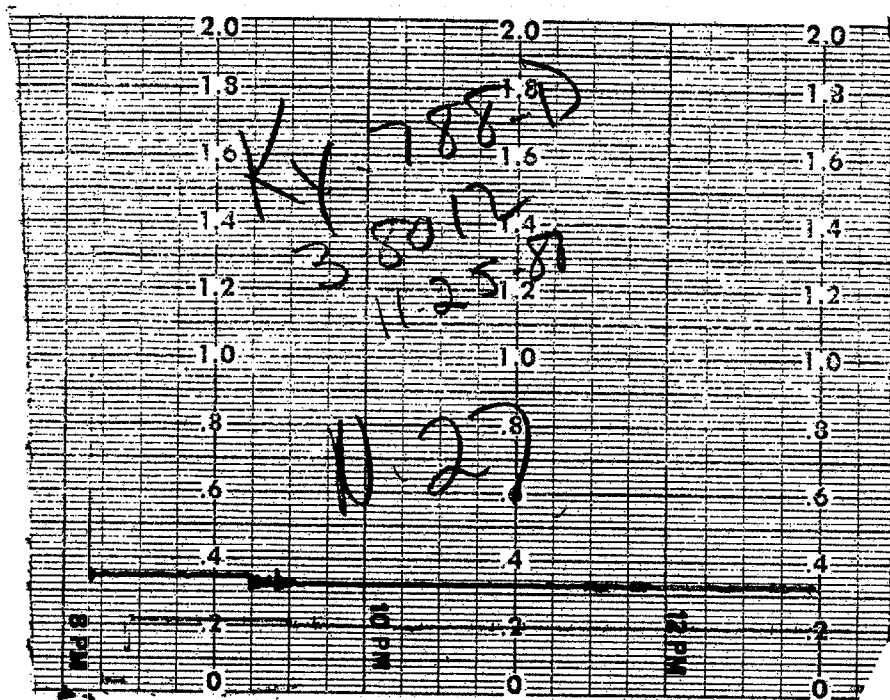
TIME SP STEP

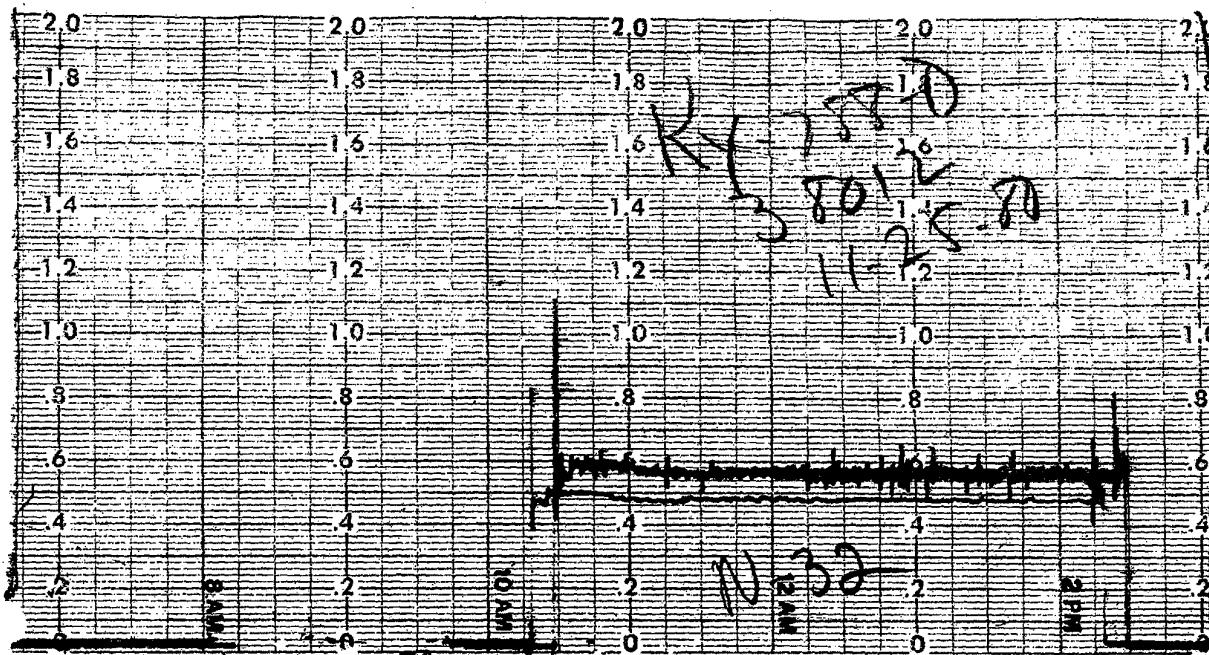
37-240

12:40 PM

12:40 PM

381-201





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