

CG 03 - CODE KY-787-D PKG

PROCESSES APPROVED BY

LOT

OCT-29 80 37639

() KY-787-D (Q) FWP 9/23/80

EST'D WGT 932 LBS

() (XQB-17: 25%

STANDARD HRS. 8.9 TIME 7A M

() LESS N-32-D

() & 240 MIN

() STRIKE)

TYPED BY: FP 9/23/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	10-2-13182	93	2000	14	YC002B		93	
14	YC002B	10-2-13198	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

PUNCHEE & CHECKED

TOTAL EST'D WGT 3332

OCT 3 1 1980

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	32-D	240
	3 DUMP IN AND STIR 3 MIN	48X50	YC-2-B	2400
	RECORD: START 7:24			
	FIN 9:24			
	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-244 & START			
	AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 5:30 PM TOTAL MINUTES 2:20			
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	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 60% PRESET #1 80 GAL		15-A	160
	B 13LG 45% 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	204
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.35			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		32-D	1376
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.82			

Delayed to
Repack Horn.
#4

16 OPERATOR STEP PB
 320 17 RECORD LEVEL 2LG 76% IF BELOW 35% FOLLOW SOL'N
 SV 18 MAKE-UP PROCEDURE FOR N-27-D
 19 ADJUST SV TO 48" (2470 G)
 CP 20 RECORD PH 10.4 ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 21 SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50% 20 7-D 20
 22 OPERATOR STEP PB

23 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.4
 SV 24 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 25 OPERATOR STEP PB
 26 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 27 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE

28 OPERATOR STEP PB
 29 DURING STRIKE RECORD:
 SP STEP

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
9.4	9.0-10.0	11:55
9.5	9.0-10.0	12:25
9.4	9.0-10.0	1:25
9.3	9.0-10.0	2:25 PM
9.4	9.0-10.0	3:25
9.7	7.5-8.5	4:10 AM

NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE
 IN LOG. IF FINAL PH > 8.5, ADJ TO 7.5-8.5.

& RECORD: PH 2.6

ASSUME 77%

14

27-D

11

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 (9.5-10.5)
 32 STIR 15 MIN OR LONGER FOR SP STEP 26 38.2
 33 RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL
 34 SET PRESET #8 TO 3.82 GAL FROM S 33

302 35 RUN 30" (340 G) WATER INTO V-302
 7 36 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 80 72/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 3.3 (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 10.5 (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH ASSUME 77% 15 27-D 12
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 7-D
 (SIPHON N-7-D INTO SV) 7.3
 42 OPERATOR STEP PB
 43 SP STEP 29/58. RECORD: PH 9.8 & TIME
 44 OPERATOR STEP PB
 45 SP STEP 60. BATCH COMPLETE.

START
 TIME SP STEP

FINISH
 TIME SP STEP

OPTR

7A
 11:10 PM

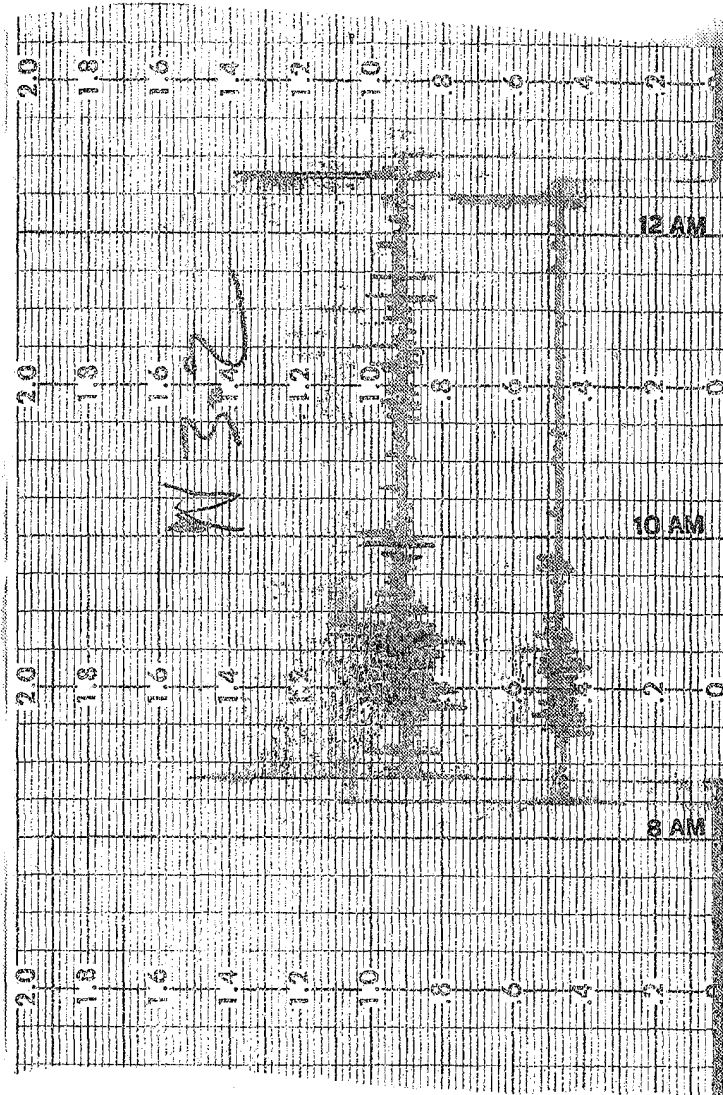
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