

S.V. 243 (243) (AUTOMATED)

DATE PRINTED: 6/25/82

CG 03 CODE KY-787-D PKG

PROCESSES APPROVED BY
() KY-787-D (T) FWP 06/25/82

JUL 26 1982

G2J85

3404*

COMTYP JOB NAME: 03KY787DMT

(DATE) (LOT) (EST WGT)

LOCATN	CG	CODE	PG	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
		VL-2		13490	2000	XX.XX				
		17		62513	200	XX.XX				
		17		14574	300	XX.XX				
						XX.XX				
						XX.XX				

NON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
	NAME: "KROLOR" YELLOW-MEDIUM			
	*BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF.			
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN	250	32-D	250
	3 DUMP IN AND STIR 5 MIN	50X50	YC-2-B	2500
	RECORD: START	2000		
	FIN	200		
	4 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.	2500		
	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 90" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
2	RECORD: TIME START TOTAL MINUTES 17.5			
	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	STEP	DESCRIPTION	USE LBS	N-CODE	ACCT LBS
		1	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
		2	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
		3	REMOTE (TEMP IS SET AT 190-194°F)			
		4	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
			A. 11LG 24% PRESET #1 32 GAL		115-D	168
			B. 12LG 28% PRESET #6 141 GAL		20-A	141
		5	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
			VFC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM		27-D	213
			WFC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM			
			WFR10 (N-27-D/WATER) RATIO 1.31			
			WFC10 (N-32-D CONTROLLER) IN MANUAL .84 GPM		32-D	1425
			WFC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
			WFR20 (N-32-D WATER) IN REMOTE			
			WFR10 (N-32-D/WATER) RATIO 1.76			

N32737

DUP050464113

LOT= COMTYP JOB NAME = 03KY787DMT PAGE 02 DATE PRINTED 6/25/82

EQUIP PAGE 2 CG 03 KY-787-D USE N- USE
MENT) LBS CODE LBS

115 OPERATOR STEP PB
320 17 RECORD LEVEL 2LG 40% 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 10.4 ADJ TO 11.1-11.3 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 20 SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50% 30 7-D 16
120 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:
SP STEP
V-243/V-244
PH RANGE TIME
13/46 (30 MIN) 9.4 9.0-10.0 8:50 A
14/47 (60 MIN) 9.0-10.0 9:20 A
15/48 (2 HRS) 9.0-10.0 10:20 A
16/49 (2 HRS, 25 MIN) 9.4 9.0-10.0 10:55 A
17/50 (FINAL 3 HRS) 6.5 7.5- 8.5 11:20 A
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

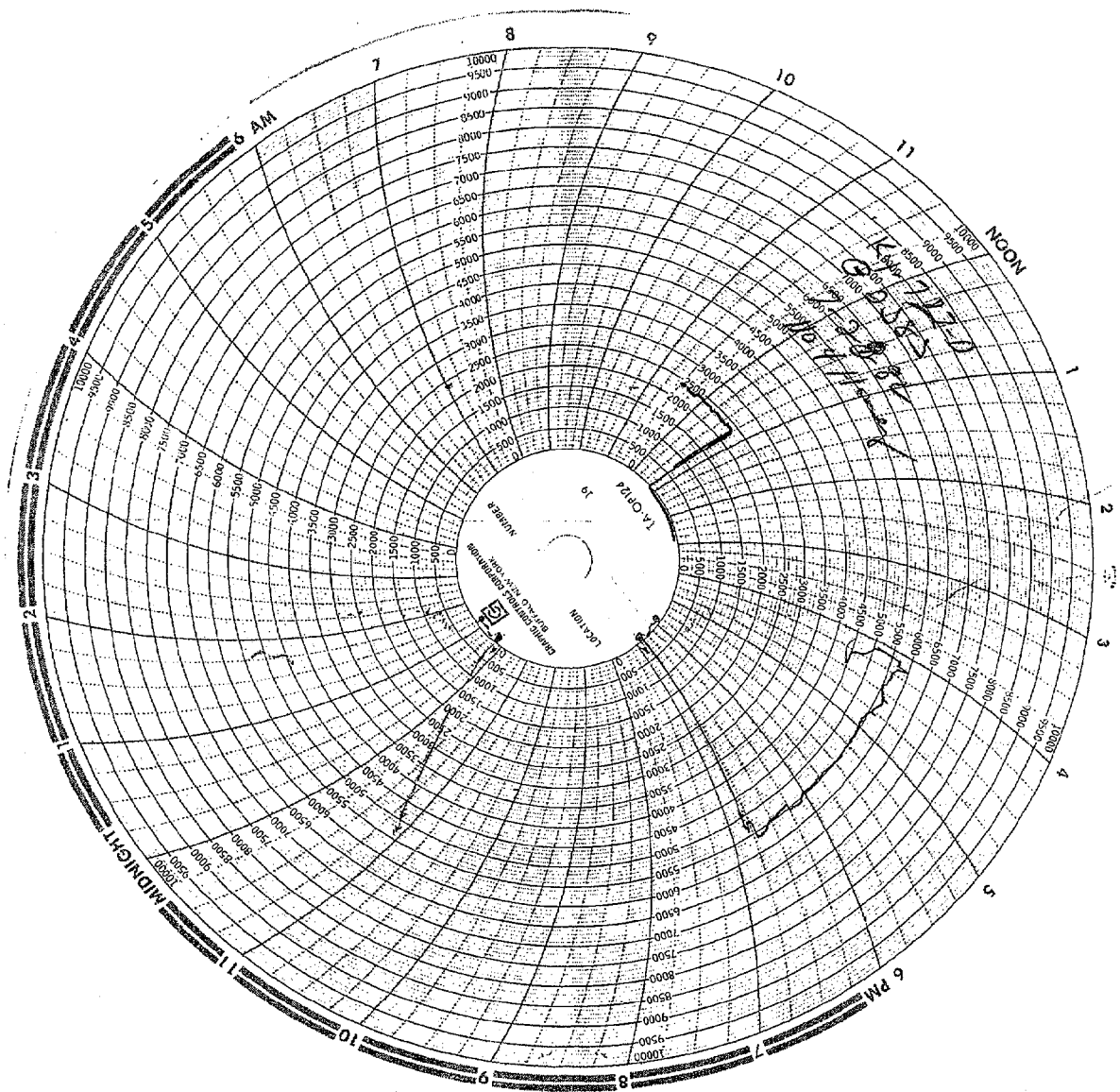
28 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
29 ADD IN 7-8 MIN. CHECK FOR DRAFT IN VENT STACK 365 530-A 365
BEFORE DUMPING.
339 30 ADJ TO 49" (382 G) AT 80-100°F
6 31 STIR 5 MIN & RECORD: PH (9.5-10.5)
32 STIR 15 MIN OR LONGER FOR SP STEP 26 28.7
33 RECORD: VOL 49" & CALC 49" X 0.78 GAL
34 SET PRESET #8 TO 38" GAL FROM S 33

383 35 RUN 47" (360 G) WATER INTO V-385
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 110 128-A 110
SV 39 SP STEP 23/53. RECORD: PH 4.0 (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 8.4 (9.0-9.5). ADJ IF NECESSARY &
RECORD: PH 9.5 ASSUME 77% 27-D
(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 30 7-D 15
(SIPHON N-7-D INTO SV)
42 OPERATOR STEP PB
43 SP STEP 29/58. RECORD: PH 9.5 & TIME 12:30 PM
44 OPERATOR STEP PB
45 SP STEP 60. BATCH COMPLETE.

START
TIME SP STEP
7:00 AM

FINISH
TIME SP STEP
12:30 PM
237-381



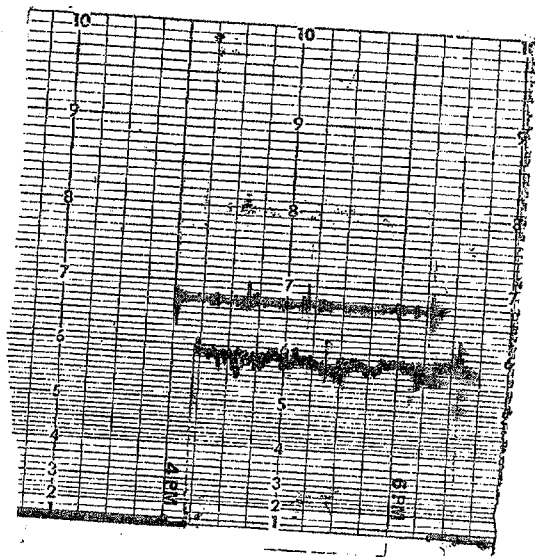
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