

CG 03 CODE KY-787-D PKG

PROCESSES

APPROVED BY

LOT

NOV-10 60 37788

NOV 15 1980

() KY-787-D (Q) FWP 11/3/80

EST'D WGT 932

LBS

() (XOB-17: 25%

() LESS N-32-D

() & 240 MIN

() STRIKE)

STANDARD HRS. 8.9

TIME 11P M

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13172	93	2000	14	YC002B	13172	93	2000
14	YC002B	13193	93	400	14	YC002B	13193	93	400
14	YC002B		93		14	YC002B		93	

CLEAN UP AS YOU GO ALONG

TOTAL EST'D WGT 3332

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	983-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START	2000		
	FIN	400		
	4 ADJUST TO 75" (1275 G)	2400		
	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			
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 1245A TOTAL MINUTES 150			
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	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 TO IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 57% PRESET #1 80 GAL		15-A	160
	B. 13LG 26% 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	206
	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		983-D	1376
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	8FR20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.82			

		V-244				
320	16	OPERATOR STEP PB				
SV	17	RECORD LEVEL 2LG 12% IF BELOW 35% FOLLOW SOL'N				
SP	18	MAKE-UP PROCEDURE FOR N-27-D				
CP	19	ADJUST SV TO 48" (2470 G)				
	19	RECORD PH 9.5 ADJ TO 11.1-11.3 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%	24	7-D	12	
	20	OPERATOR STEP PB				
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7				
SV	22	SWITCH 3FC20, BFC10, & BFC20 TO AUTO				
SP	23	OPERATOR STEP PB 6:30A				
	24	SP STEP 10/43. WHEN 3FC20, BFC10 & BFC20 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) 9.3 9.0-10.0 7:00A				
		14/47 (60 MIN) 9.3 9.0-10.0 7:30A				
		15/48 (2 HRS) 9.5 9.0-10.0 8:30A				
		16/49 (3 HRS) 9.5 9.0-10.0 9:30A				
		16/49 (4 HRS) 9.5 9.0-10.0 10:30A				
		17/50 (FINISH) 8.7 7.5-8.5 11:15A				
		NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE				
		IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.				
		& RECORD: PH 11.2 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"				
6	31	STIR 5 MIN & RECORD: PH 9.8 (9.5-10.5)				
	32	STIR 15 MIN OR LONGER FOR SP STEP 26				
	33	RECORD: VOL 5.1" & CALC 5.1" X 0.78 = 39.8 GAL				
	34	SET PRESET #8 TO 39.8 GAL FROM S 33				
302	35	RUN 30" (360 G) WATER INTO V-302				
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	100	128-A	100	
SV	39	SP STEP 23/53. RECORD: PH 3.7 (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 8.3 (9.0-9.5). ADJ IF NECESSARY &				
		RECORD: PH 9.5 ASSUME 77%		27-D		
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	6	7210	6	
		(SIPHON N-7-D INTO SV)				
	42	OPERATOR STEP PB				
	43	SP STEP 29/58. RECORD: PH 9.2 & TIME 12:50				
	44	OPERATOR STEP PB				
	45	SP STEP 60. BATCH COMPLETE.				

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
11:00P	7:00A	126-259
7:00A	12:50	322