

CG 03 CODE KY-787-D PKG

LOT

OCT--1-80 37295

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 3P M

PROCESSES

() KY-787-D (Q) FWP 9/23/80
() (XOB-17: 25%
() 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	<u>13091</u>	93	<u>2000</u>	14	YC002B		93	
14	YC002B	<u>13096</u>	93	<u>400</u>	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 3332

2M SLOW → *1 Homog #3-1st Pass*
11 #4 - " " "
11 #4 - " " "

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.			
203	2 WEIGH IN DRUM & POUR IN	240	32-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START <u>2:30</u> LOT <u>13091</u>	<u>2000</u>		
	FIN <u>4:30</u> LOT <u>13096</u>	<u>400</u>		
	ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V- 205 263			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN DE HOT WATER AT 2400-2600 PSI INTO V-205			
	7 RECORD: V- 205 263 VOL <u>40</u> " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
2203	9 RUN 10" (514 G) WATER INTO V- 243 243 START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>9:30</u> TOTAL MINUTES <u>120</u>			
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 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)		
3	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:		
		A. 11LG <u>29</u> % PRESET #1 80 GAL	15-A	160
		B. 13LG <u>24</u> % 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	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		

N34935

V-243

116 OPERATOR STEP PB
 320 117 RECORD LEVEL 2LG 65% IF BELOW 35% FOLLOW SOL'N
 SV 118 MAKE-UP PROCEDURE FOR N-27-D
 SP 119 ADJUST SV TO 48" (2470 G)
 CP 120 RECORD PH 10.1 ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 121 SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50% 32 7-D 16
 120 OPERATOR STEP PB

121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0
 SV 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 123 OPERATOR STEP PB
 124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
 126 OPERATOR STEP PB
 127 DURING STRIKE RECORD:
 SP STEP
 V-243/V-244

	PH	RANGE	TIME
13/46 (30 MIN)	9.7	9.0-10.0	2:15
14/47 (60 MIN)	9.65	9.0-10.0	2:45
15/48 (2 HRS)	9.7	9.0-10.0	3:45
16/49 (3 HRS)	9.6	9.0-10.0	4:45
16/49 (4 HRS)	9.6	9.0-10.0	5:45
17/50 (FINISH)	7.9	7.5-8.5	6:30

 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

1:45 PM

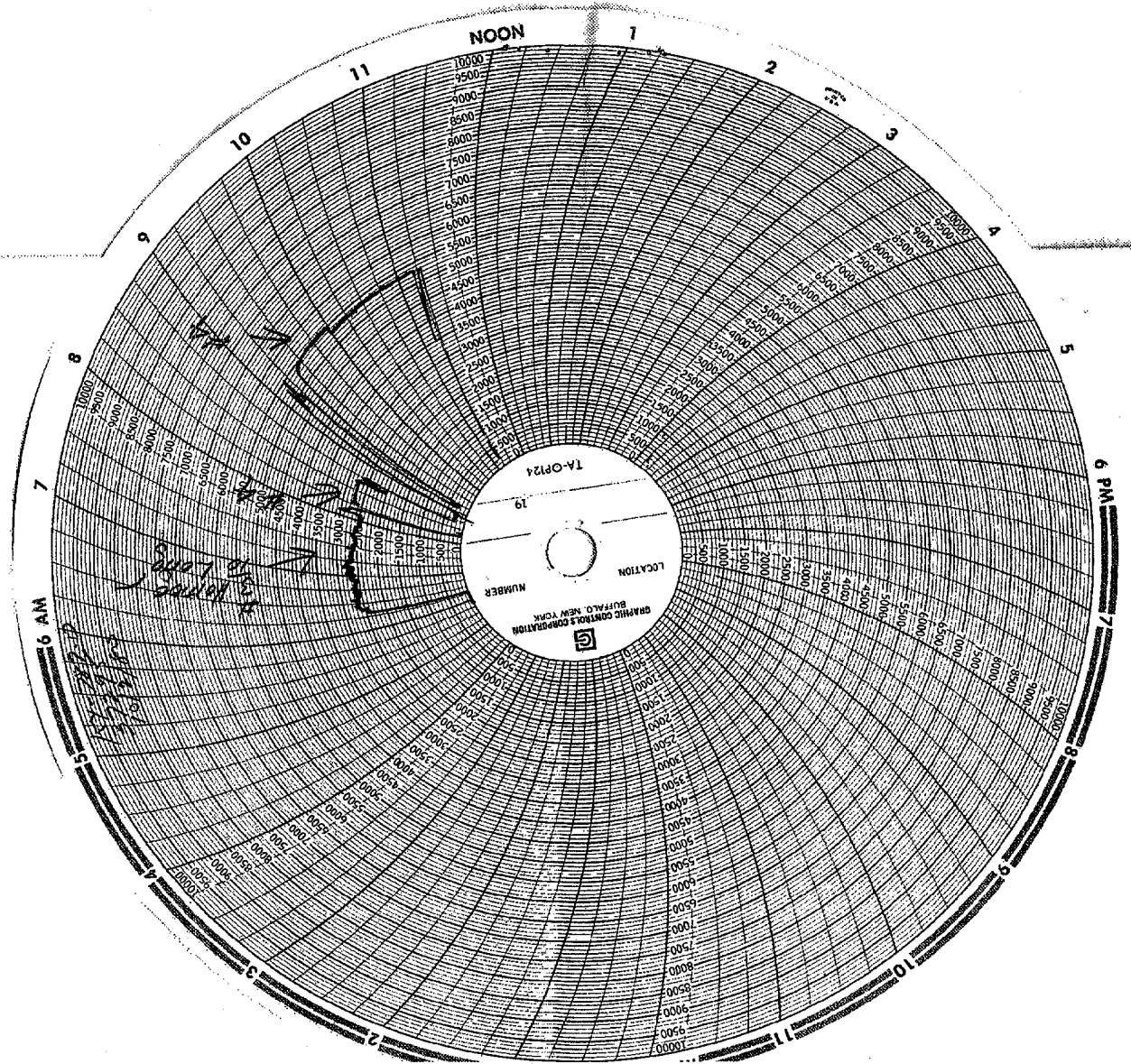
128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 129 ADD IN 7-8 MIN 350 530-A 350
 339 130 ADJ TO 49" (382 G) AT 80-100°F
 6 131 STIR 5 MIN & RECORD: PH 10.0 (9.5-10.5)
 132 STIR 15 MIN OR LONGER FOR SP STEP 26
 133 RECORD: VOL 4.9" & CALC 4.9" X 0.78 = 38.2AL
 134 SET PRESET #8 TO 38.2AL FROM S 33

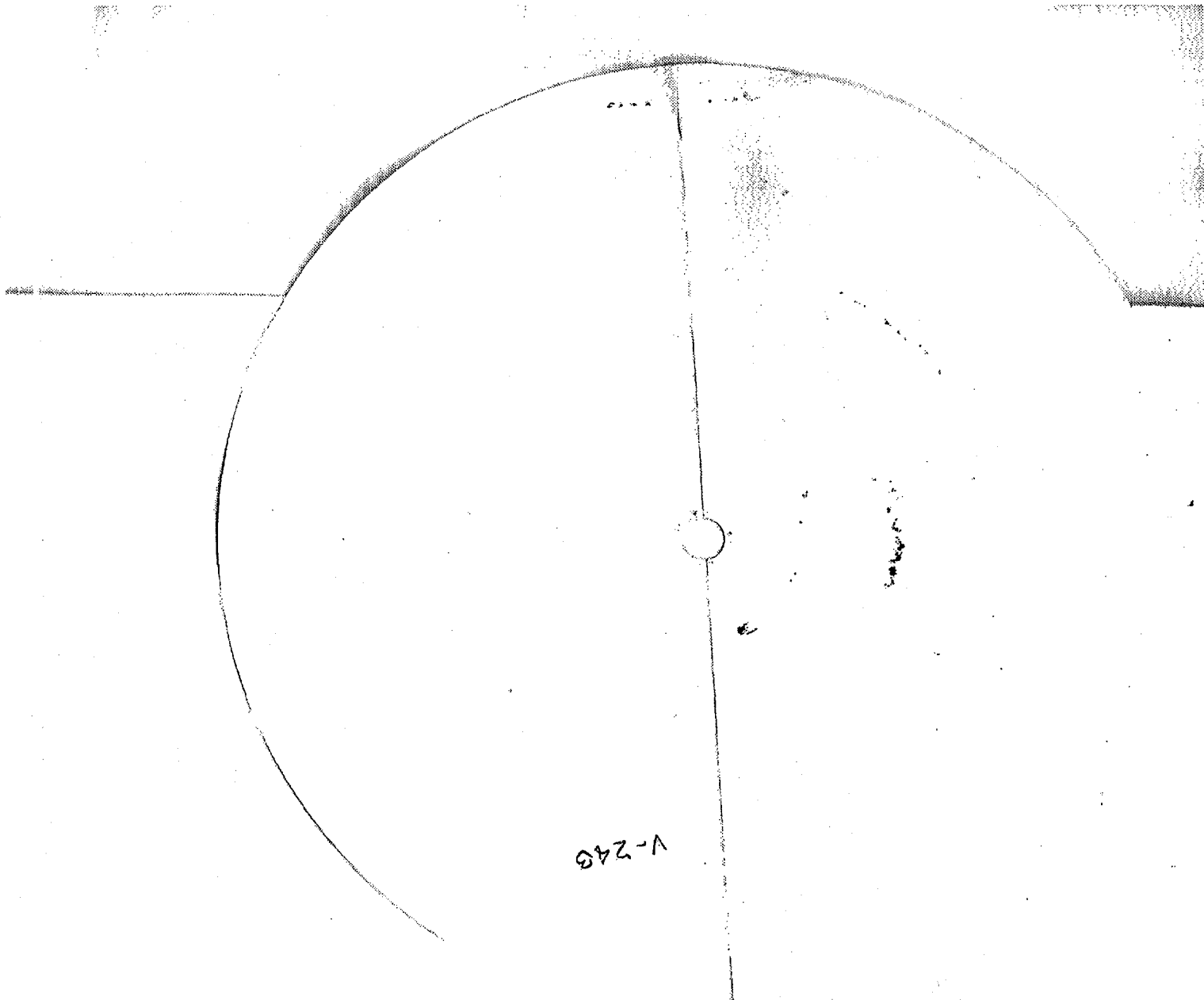
302 135 RUN 30" (360 G) WATER INTO V-302
 7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 138 SIFT IN ✓ 100 128-A 100
 SV 139 SP STEP 23/53. RECORD: PH 4.0 (3.7-4.2)
 SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
 MIN
 8 141 RECORD: PH 9.4 (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)
 142 OPERATOR STEP PB
 143 SP STEP 29/58. RECORD: PH 9.1 & TIME 7:00 PM
 144 OPERATOR STEP PB
 145 SP STEP 60. BATCH COMPLETE.

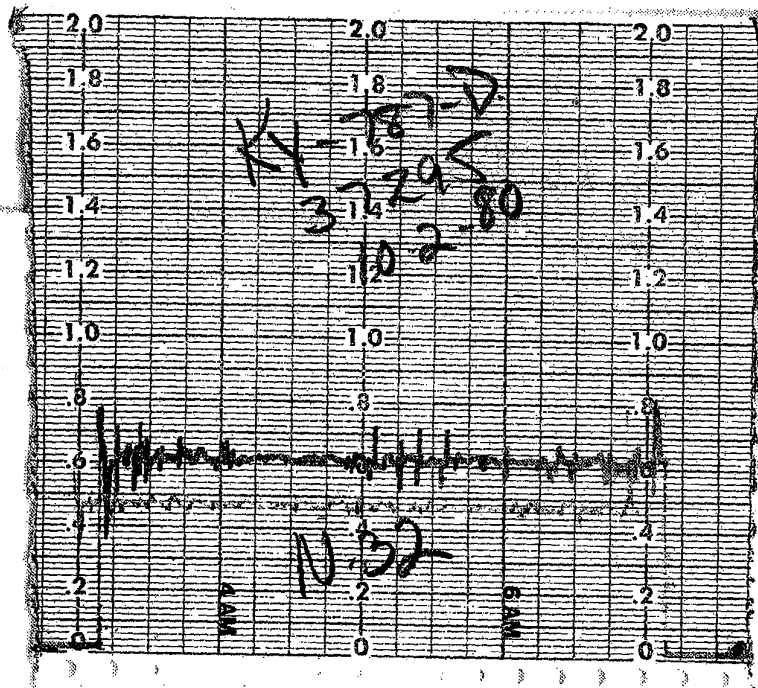
START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
7:00 A		3:00 P		235+323
3:00 PM		8:30 PM		381 342

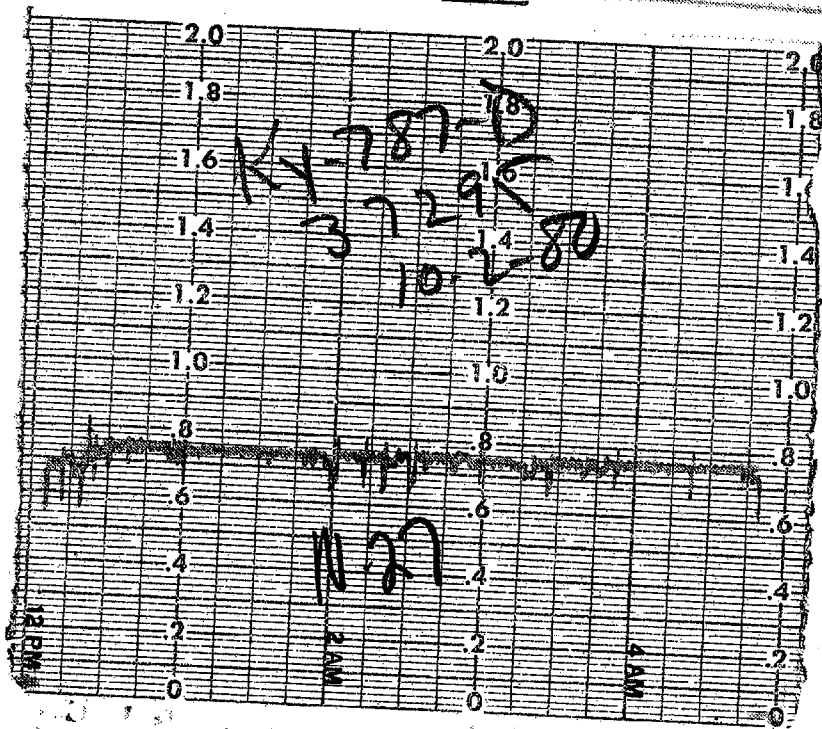
→ PUMP TO VAT 240 →



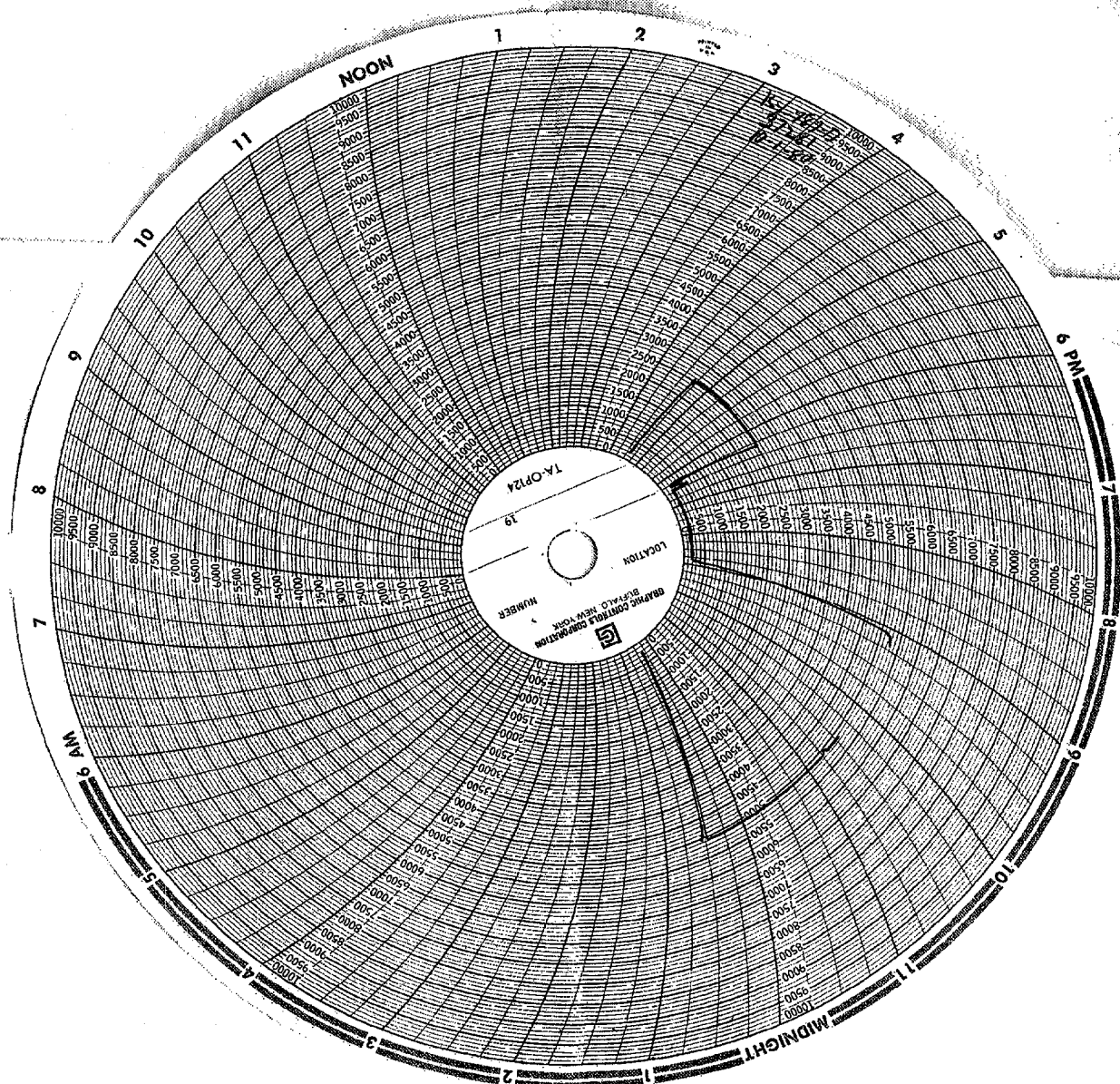


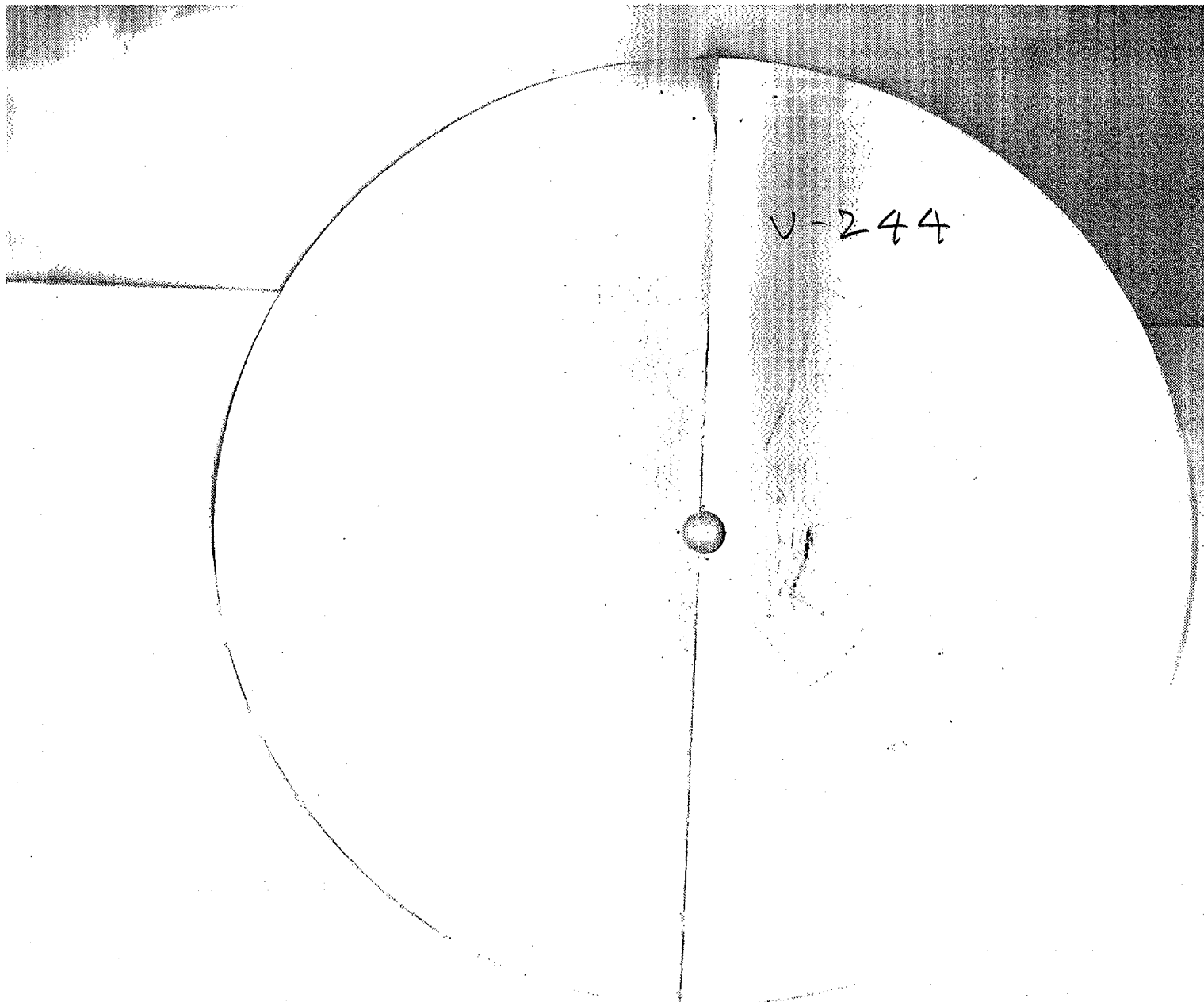
V-249

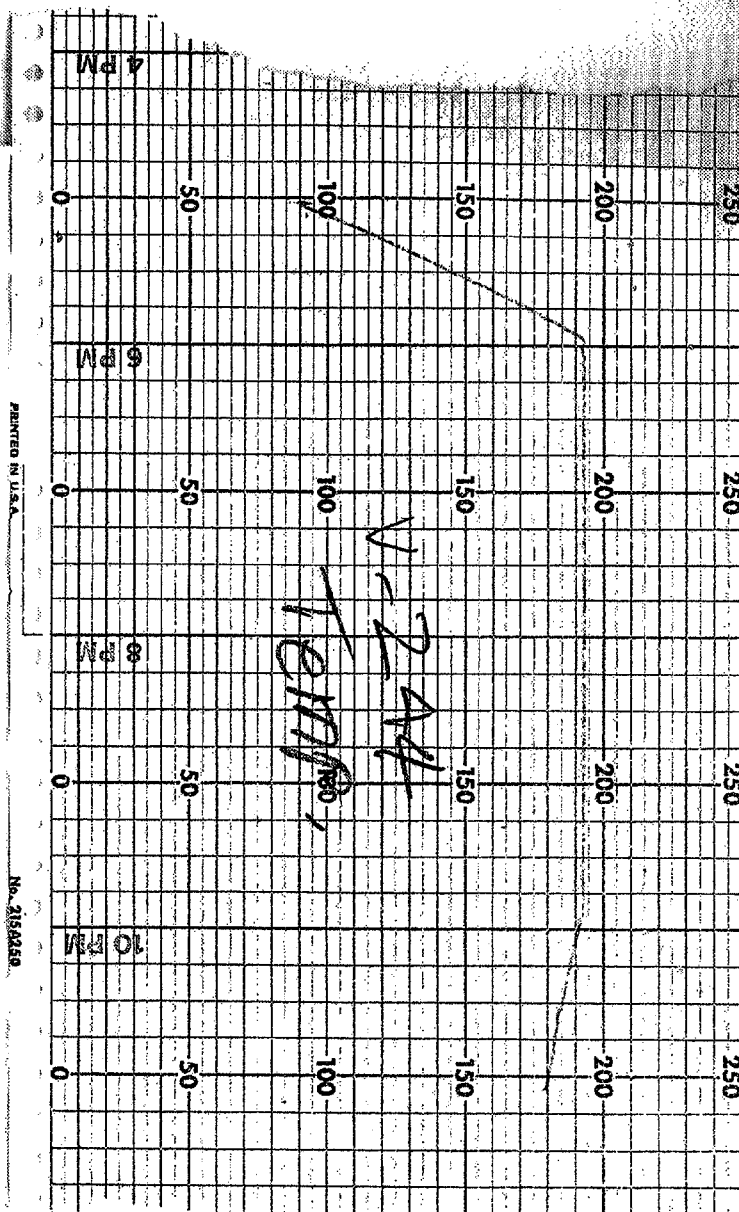




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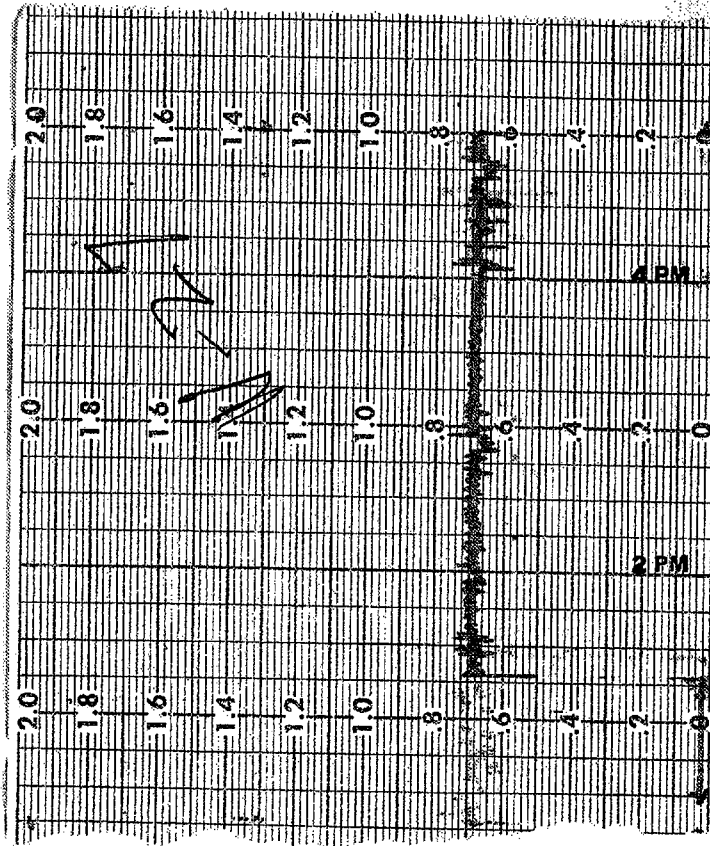






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GRAPHIC CONTROL

