

(AUTOMATED)

S.V. 243 244

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-795-D PKG

LOT MAY 12 35708

EST'D WGT 880 LBS

STANDARD HRS. 8.2 TIME 7A M

PROCESSES

APPROVED BY

() KY-795-D (H) FWP 5/1/80
 () 3/4 N-32-D STRIKE TO
 () IMPROVE GLOSS
 ()
 ()

TYPED BY: FWP 5/1/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	34344	93	2000	14	YC002B		93	
14	YC002B	24790	93	1500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

PUNCHED & CHECKED

MAY 12 1980

TOTAL EST'D WGT 4300 MAY 15 1980

NON-BLEEDING

QUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ACCT LBS
03	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
05	2 WEIGH IN DRUM & POUR IN	475	32-D	475
	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
	RECORD: START 4:30 AM	2000		
	FIN 5:10 AM	1500		
	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 4.2" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
05	9 RUN 10" (514 G) WATER INTO V-203 START AGITATOR			
IV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 3:15 P TOTAL MINUTES 135			
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 5 (V-243) OR POSITION 10 (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 80% PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.71 GPM		27-D	294
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
	3FB10 (N-27-D/WATER) RATIO 0.8			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM		32-D	1885
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	3FC20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.0			

116 OPERATOR STEP PB
 117 RECORD LEVEL 2LG 56% IF (35% FOLLOW SOLUTION
 SV MAKE-UP PROCEDURE FOR N-27-D
 SP 118 ADJUST SV TO 68" (3495 G)
 CP 119 RECORD PH 12.1 ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 120 SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50% 16 7-D 8
 120 OPERATOR STEP PB

121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9
 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 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

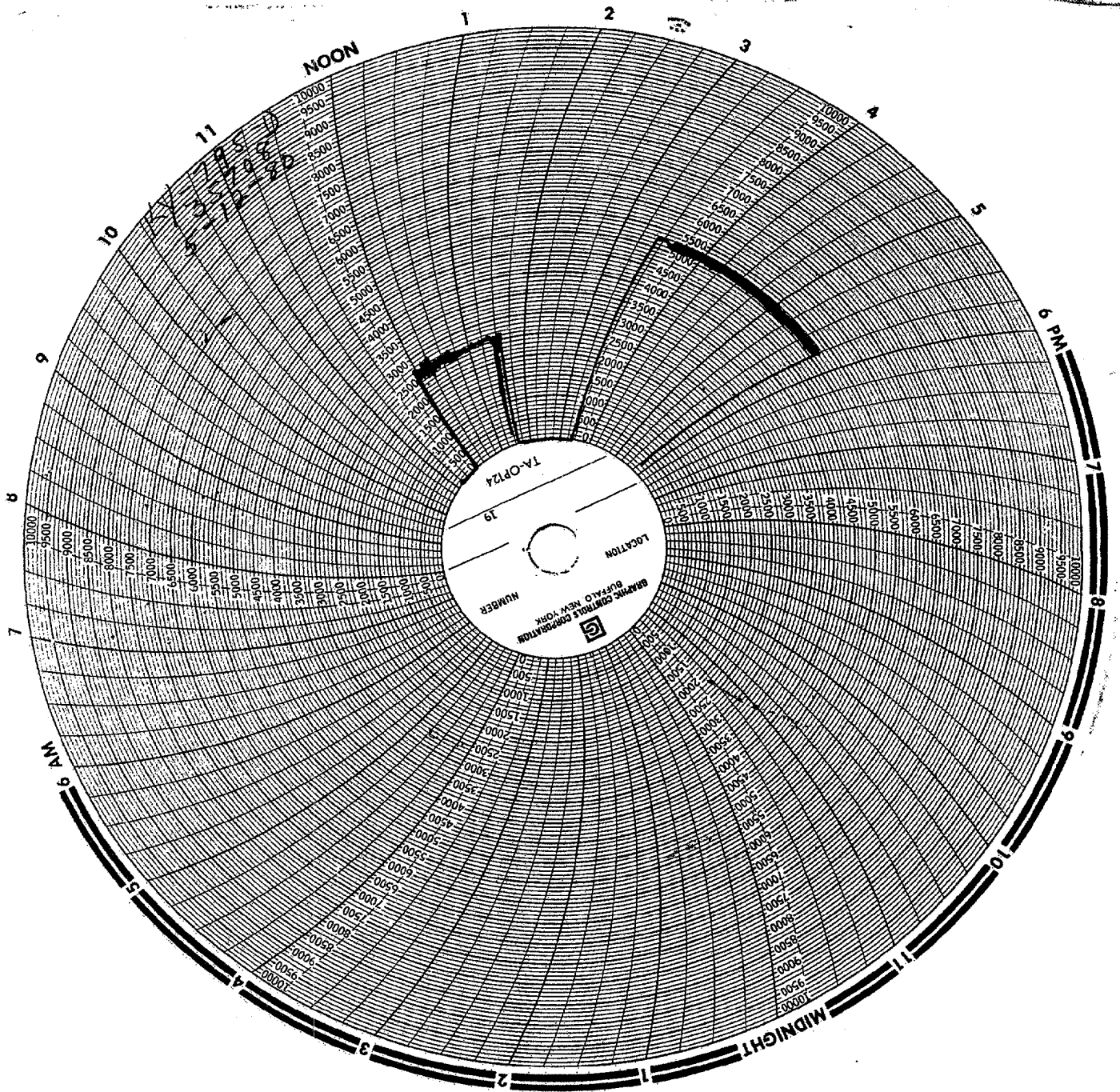
	PH	RANGE	TIME
13/46 (30 MIN)	9.7	9.0-10.0	8:00
14/47 (60 MIN)	9.7	9.0-10.0	8:30
15/48 (2 HRS)	9.7	9.0-10.0	9:30
16/49 (3 HRS)	9.7	9.0-10.0	10:30
17/50 (FINISH)	2.8	7.5-8.5	11:15

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

128 DRUM 128 WEIGH INTO 55 GAL DRUM ASSUME 50% 56 7-D 28
 6 129 FILL WITH WATER & STIR 2 MIN

130 SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.
 SV 131 SP STEP 23/53 - RECORD: PH 3.7 (3.3-3.7)
 SP 132 IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7
 & RECORD: PH ____ 15-A
 CP NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140
 7 *E IN DRUM. USE 30 GAL WATER TO 50% N-15-A.
 133 STIR 5 MIN AFTER EACH ADDITION.
 134 SIFT IN 150 128-A 150
 134 SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR
 5 MIN
 135 RECORD: PH 4.1 (4.0-4.2) & IF NECESSARY ADJ TO
 PH 4.0-4.2 & RECORD: PH ____ ASSUME 77% 8 27-D 6
 (DILUTE 10 TO 1 WITH WATER) ASSUME 50% 7-D
 136 SIPHON N-7-D INTO SV
 136 OPERATOR STEP PB
 137 SP STEP 24/54 - FOUR IN & STIR 15 MIN 22 978-A 22
 138 OPERATOR STEP PB
 139 SP STEP 60 - BATCH COMPLETE
 144 OPERATOR STEP PB

START TIME SP STEP	FINISH TIME SP STEP	OPTR
12:00 P	3:00 P	54
3:00 P	11:00 P	25+23
1:00	12:00 P	22-312



N32032.01

DUP050456314

V-243

N32032.02

DUP050456315