

CG 03 CODE KY-787-D PKG
LOT SEP-30-80 37282

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 7A M

PROCESSES APPROVED BY
() 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	13099	93	2000	14	YC002B		93	
14	YC002B	24983	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

2M

HOMOG #3 - 1st PASS
" " 2nd PASS

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	32-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
1	RECORD: START 3.30 PM FIN 5.00 PM	2000 400		
	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 " & 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.			
	RECORD: TIME START 2:00A TOTAL MINUTES 210			
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 5.0% PRESET #1 80 GAL		15-A	160
	B. 13LG 4.5% 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			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		32-D	1376
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	3FR10 (N-32-D/WATER) RATIO 1.82			

N34934

V-244

320 ~~16~~ OPERATOR STEP PB
~~17~~ RECORD LEVEL 2LG 6.8 IF BELOW 35% FOLLOW SOL 'N'
SV ~~18~~ MAKE-UP PROCEDURE FOR N-27-D
SP ~~19~~ ADJUST SV TO 48" (2470 G)
CP ~~20~~ RECORD PH 10.3 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 11.2 ASSUME 50% 30 7-D 15
~~22~~ OPERATOR STEP PB

~~23~~ SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.1
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
PH RANGE TIME
13/46 (30 MIN) 9.8 9.0-10.0 10:50
14/47 (60 MIN) 9.8 9.0-10.0 11:20
15/48 (2 HRS) 9.7 9.0-10.0 12:20
16/49 (3 HRS) 9.7 9.0-10.0 1:20
16/49 (4 HRS) 9.65 9.0-10.0 2:20
17/50 (FINISH) 8.3 7.5-8.5 3:05
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%
10:20 AM

~~30~~ WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
~~31~~ ADD IN 7-8 MIN 350 530-A 350
339 ~~32~~ ADJ TO 49" (382 G) AT 80-100°F
6 ~~33~~ STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)
~~34~~ STIR 15 MIN OR LONGER FOR SP STEP 26
~~35~~ RECORD: VOL 49 & CALC 49 " X 0.78 = 38.2 GAL
~~36~~ SET PRESET #8 TO 28.2 FROM S 33

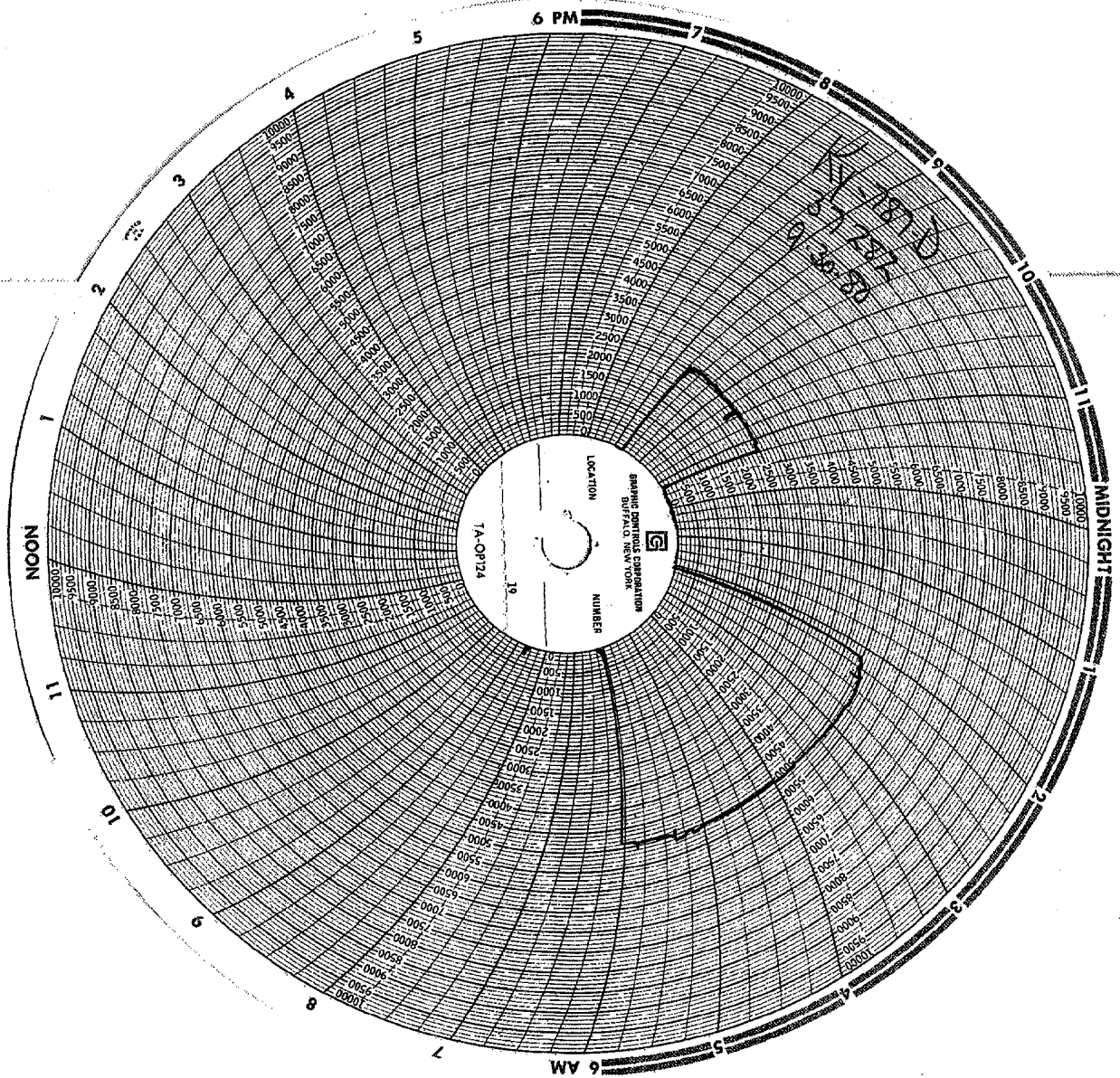
302 ~~37~~ RUN 30" (360 G) WATER INTO V-302
7 ~~38~~ ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

~~39~~ SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
~~40~~ SIFT IN 100 128-A 100
SV ~~41~~ SP STEP 23/53. RECORD: PH 3.6 (3.7-4.2)
SP ~~42~~ RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
8 ~~43~~ RECORD: PH 9.3 (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)
~~44~~ OPERATOR STEP PB
~~45~~ SP STEP 29/58. RECORD: PH 9.3 & TIME 4:00 PM
~~46~~ OPERATOR STEP PB
~~47~~ SP STEP 60. BATCH COMPLETE.

START
TIME SP STEPFINISH
TIME SP STEP

OPTR

2:00 PM
3:00 PM3:00 PM
4:00 PM2:35
2012-23
E. C.



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