

CG 03 CODE KY-795-D PKG

LOT 24166 38013

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	24166	93	1500	14	YC002B		93	
14	YC002B	24167	93	2000	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

PUNCHED & CHECKED

TOTAL EST'D WGT 4380

JUN 10 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 7:30	1500		
	FIN 10:00	2000		
	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" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
05	9 RUN 10" (514 G) WATER INTO V-24 & START AGITATOR			
IV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 6:46 TOTAL MINUTES			
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 142	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (V-244)			
CP 143	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
3	144 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 65% PRESET #1 104 GAL		15-A	208
145	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.71 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM 3FR10 (N-27-D/WATER) RATIO 0.8 BFC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM BFC20 (N-32-D WATER) IN REMOTE BERT0 (N-32-D/WATER) RATIO 1.0		27-D 32-D	296 1885

N32430

	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG <u>86%</u> IF <35% FOLLOW SOLUTION			
SV	18	MAKE-UP PROCEDURE FOR N-27-D			
SP	19	ADJUST SV TO 68" (3495 G)			
CP	19	RECORD PH <u>10.2</u> . 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 <u>11.2</u> . ASSUME 50%	<u>42</u>	7-D	<u>22</u>
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.9</u>			
V	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
P	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) <u>9.6</u> 9.0-10.0 <u>9:20 P</u>			
		14/47 (60 MIN) <u>9.6</u> 9.0-10.0 <u>9:50 P</u>			
		15/48 (2 HRS) <u>9.6</u> 9.0-10.0 <u>10:00 P</u>			
		16/49 (3 HRS) <u>9.6</u> 9.0-10.0 <u>11:50 P</u>			
		17/50 (FINISH) <u>7.2</u> 7.5-8.5 <u>12:35 P</u>			
		NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.			
		& RECORD: PH <u>7.2</u> . ASSUME 77%		27-D	
RUM	28	WEIGH INTO 55 GAL DRUM	56	7-D	28
6	29	FILL WITH WATER & STIR 2 MIN			
	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	31	SP STEP 23/53 - RECORD: PH <u>3.6</u> (3.3-3.7)			
SP	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
&		RECORD: PH <u>3.6</u>		15-A	
CP		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7		*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			
	33	SIFT IN	150	<u>428-A</u>	150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
	35	RECORD: PH <u>4.4</u> (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH <u>4.1</u>		27-D	
		(DILUTE 10 TO 1 WITH WATER) ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN & STIR 15 MIN	22	978-A	22
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	44	OPERATOR STEP PB			

START
TIME SP STEP

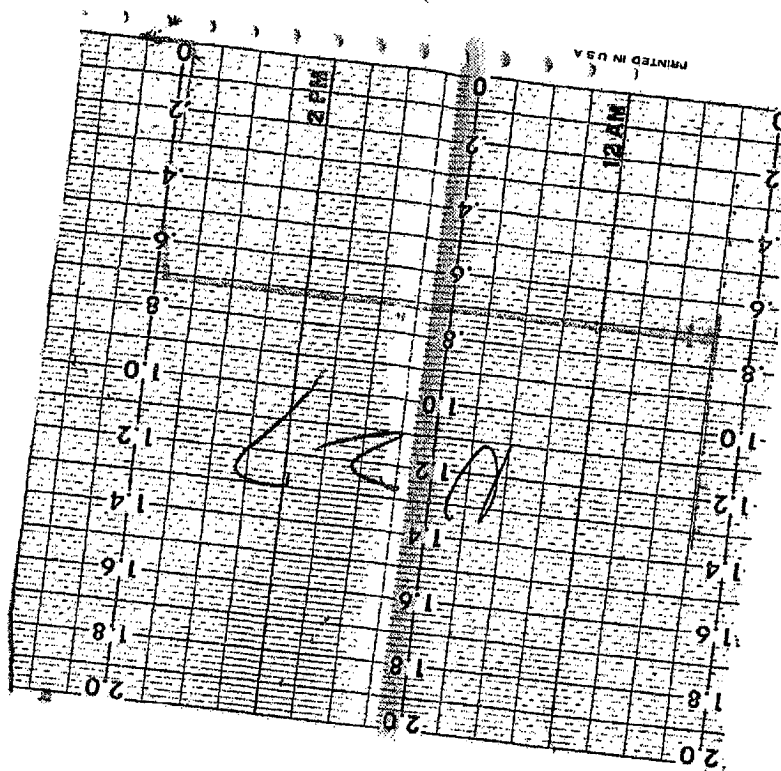
7:00 A
2:00 P

FINISH
TIME SP STEP

3:00 P
11:30 P

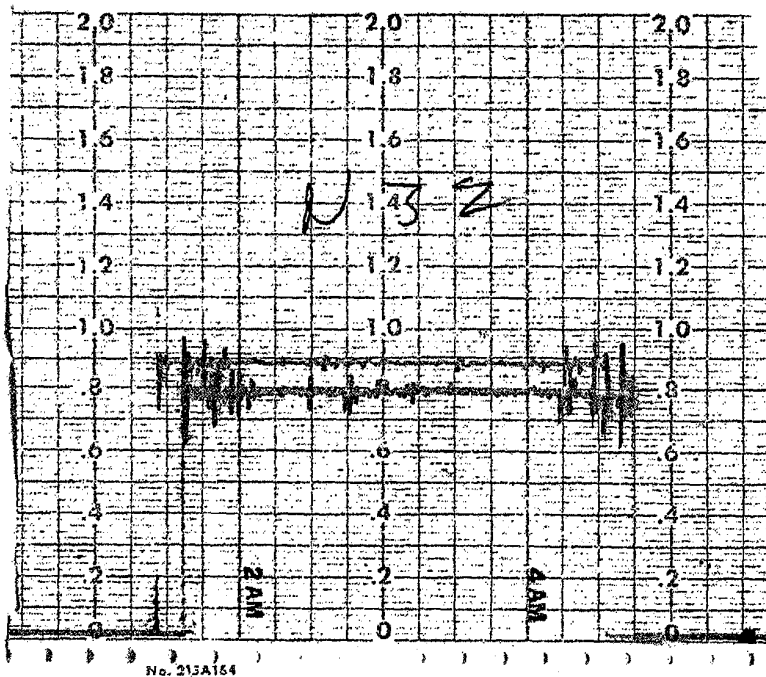
OPTR

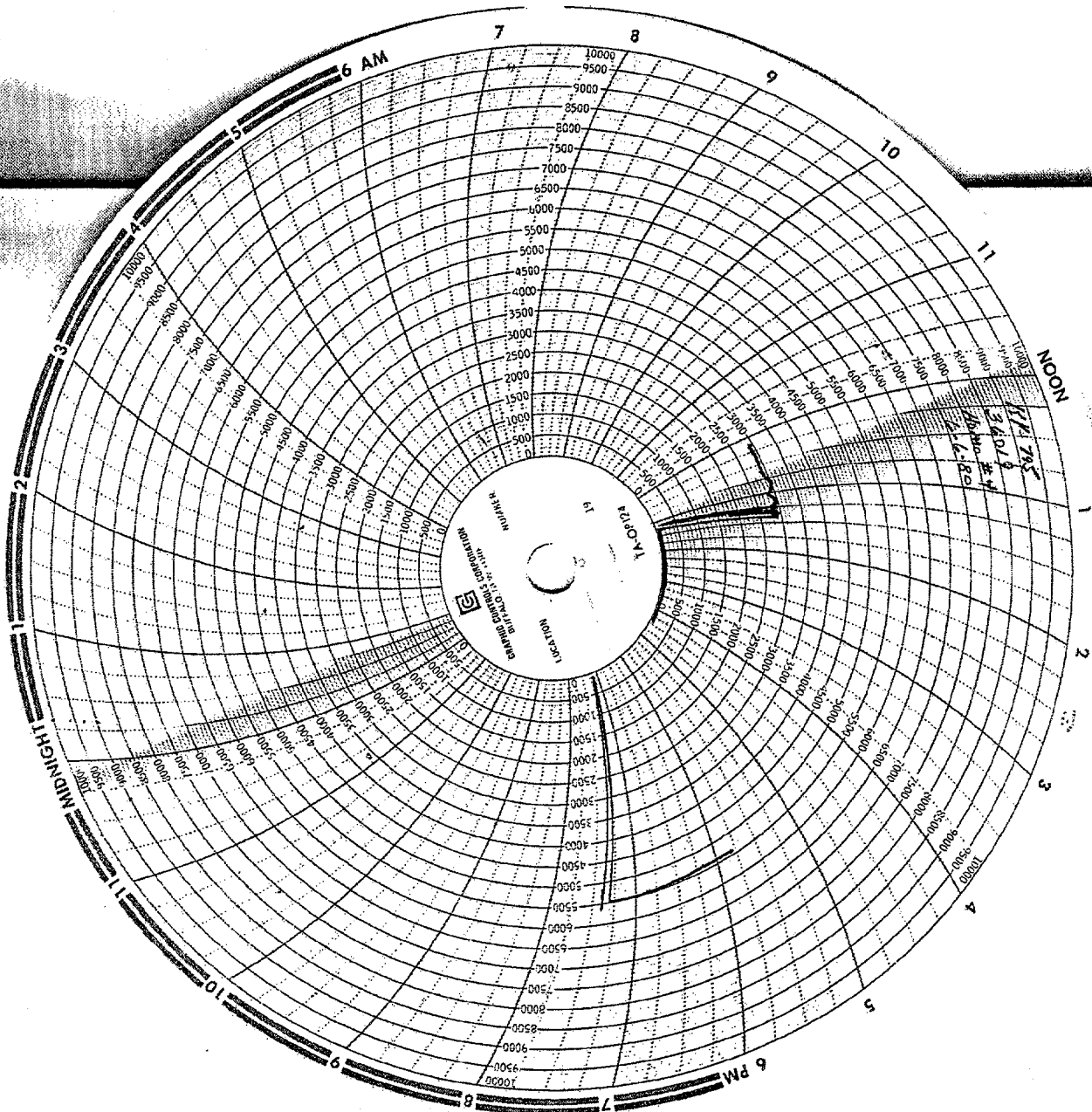
257-126
27



N32430.01

DUP050461193





N32430.02

DUP050461195