

S.V. 243 (244) (AUTOMATED)

DATE PRINTED: 6/25/82

CG 03 CODE KY-787-D PKG

PROCESSES APPROVED BY
() KY-787-D (T) FWP 06/25/82

JUL 27 1982

G2J89

3404*

COMTYP JOB NAME: 03KY787DMT

(DATE)

(LOT)

(EST WGT)

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
				14571	2000	XX.XX				
				13491	500	XX.XX				
						XX.XX				
						XX.XX				
						XX.XX				

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203	*BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF.			
205	RUN 30" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	250	32-D	250
1	RECORD: START <u>10:00</u> LOT <u>14571</u> FIN <u>11:30</u> <u>13491</u>	50X50 2000 500	YC-2-B	2500
	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
4	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	RUN 10" (514 G) WATER INTO V-204 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START <u>5:00</u> TOTAL MINUTES <u>10.6</u> 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	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
3	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 1ALG 70% PRESET #1 32 GAL B. 13LG 53% PRESET #6 141 GAL			
145	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: V3FC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM V3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM V3FR10 (N-27-D/WATER) RATIO 1.31 V3FC10 (N-32-D CONTROLLER) IN MANUAL .84 GPM V3FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM V3FC20 (N-32-D WATER) IN REMOTE V3FR10 (N-32-D/WATER) RATIO 1.76			
			115-D	168
			20-A	141
			27-D	213
			32-D	1425

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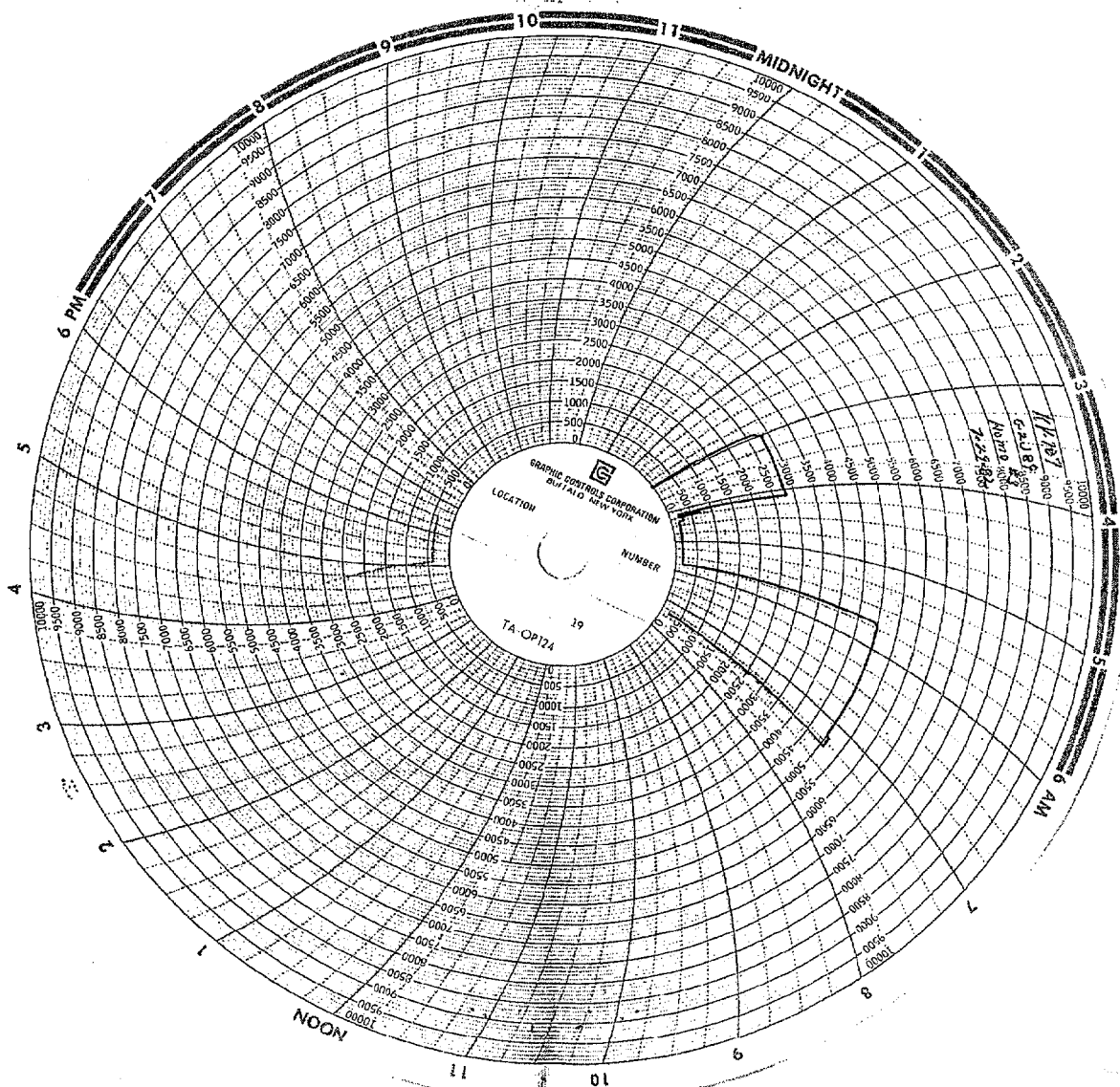
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LOT= COMTYP JOB NAME = 03KY787DMT PAGE 02 DATE PRINTED: 6/25/82

EQUIP PAGE 2 CG 03 KY-787-D USE N- USE
MENTI LBS CODE LBS

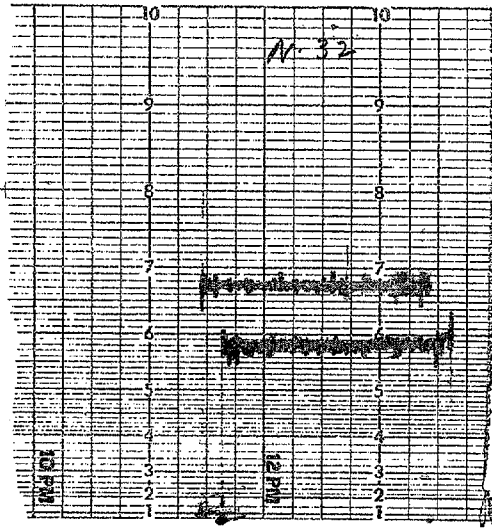
320	118	OPERATOR STEP PB			
SV	117	RECORD LEVEL 2LG 49% IF BELOW 35% FOLLOW SOL'N			
SP	116	MAKE-UP PROCEDURE FOR N-27-D			
CP	115	ADJUST SV TO 48" (2470 G)			
4	114	RECORD PH 10.7. ADJ TO 11.1-11.3 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
	113	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	30	7-D	60
	112	OPERATOR STEP PB			
SV	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9			
SP	120	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	119	OPERATOR STEP PB			
5	118	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
	117	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	116	OPERATOR STEP PB			
	115	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) 9.4 9.0-10.0 9.00 AM			
		14/47 (60 MIN) 9.4 9.0-10.0 9.30			
		15/48 (2 HRS) 9.4 9.0-10.0 10.30			
		16/49 (2 HRS, 25 MIN) 9.4 9.0-10.0 10.55			
		17/50 (FINAL 3 HRS) 7.0 7.5- 8.5 11.30 AM			
		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	127	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
129	126	ADD IN 7-8 MIN. CHECK FOR DRAFT IN VENT STACK	365	530-A	365
		BEFORE DUMPING.			
339	125	ADJ TO 49" (382 G) AT 80-100°F.			
6	124	STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)			
	123	STIR 15 MIN OR LONGER FOR SP STEP 26			
	122	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	121	SET PRESET 48" TO 38.2 GAL FROM S 33			
385	120	RUN 47" (360 G) WATER INTO V-385			
7	119	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	160	7-D	80
	118	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	117	SIFT IN	110	128-A	110
SV	116	SP STEP 23/53. RECORD: PH 4.0 (3.7-4.2)			
SP	115	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
		MIN			
8	114	RECORD: PH 9.5 (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)			
	112	OPERATOR STEP PB			
	111	SP STEP 29/58. RECORD: PH 9.5 & TIME 1:00 PM			
	110	OPERATOR STEP PB			
	109	SP STEP 60. BATCH COMPLETE.			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
11.0	7.0	120.259
7:00 AM	7:00 PM	237



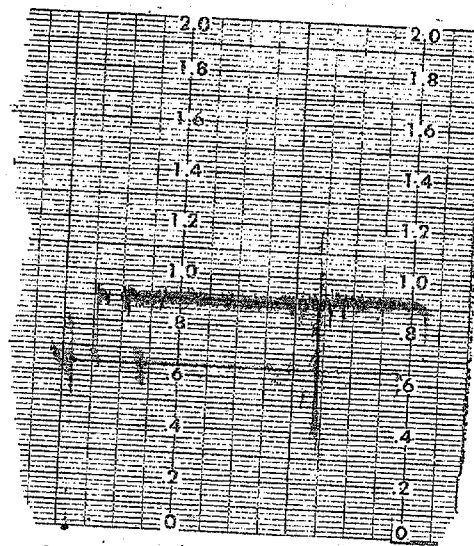
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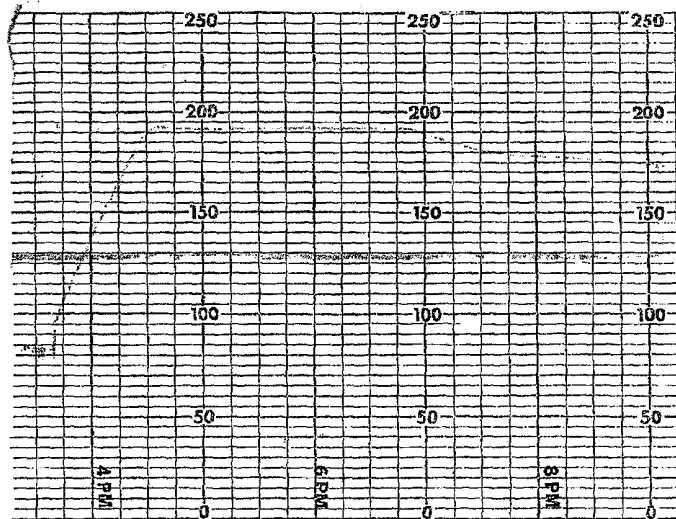
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