

CG 03 CODE KY-788-D PKG

LOT May '81 E1123

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME ----- M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 5/14/80

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JOB NAME 03KY-788-DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	14030	93	1100	14	YC003B		93	
14	YC003B	14038	93	1200	14	YC003B		93	
14	YC003B		93		14	YC003B		93	

Do Not Use YC-3-B LOTS 14001 THRU 14004

Homog #3 - 2nd Pass

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N-CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
26.3	2 WEIGH IN DRUM & POUR IN	345	32-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START 5:00 AM			
	FIN 6:00 PM			
	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 50" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 & 203	9 RUN 10" (514 G) WATER INTO V-203 & START AGITATOR			
2	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 4:40 PM TOTAL MINUTES 120			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
11	11 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP & CP	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)			
	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 42% PRESET #2 208 GAL		15-A	416
	B. 13LG 86% PRESET #6 135 GAL		20-A	135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM		27-D	180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
	3ER10 (N-27-D/WATER) RATIO 0.8			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM		32-D	1215
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	3EC20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.1			

EQUIP

PAGE 2

CG 02 KY-708-D EST WGT 31.00

USE

N-

LBS

LBS

CODE

LBS

V-243

320 114 OPERATOR STEP PB
 117 RECORD LEVEL 2LG 8.2% IF (35% FOLLOW SOLUTION
 MAKE-UP PROCEDURE FOR N-27-D
 SP 118 ADJUST SV TO 47" (2400 G)
 CP 119 RECORD PH 10.10 ADJ TO 11.0-11.2 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% 46 7-D 23
 120 OPERATOR STEP PB

SV 121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9
 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

9.3-10.0

8:45

14/47 (60 MIN)

9.7

9.3-10.0

9:15

15/48 (2 HRS)

9.7

9.3-10.0

10:15

16/49 (2 HRS, 25 MIN)

9.7

9.3-10.0

10:40

17/50 (FINAL 3 HRS)

8.0

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 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 10.1 (9.5-10.5)
 132 STIR 15 MIN OR LONGER FOR SP STEP 26/56
 133 RECORD: VOL 49" & CALC 49" X 0.78 = 38.7 GAL
 134 SET PRESET #8 TO 38.7 GAL FROM S 33

302 135 RUN 40" (440 G) WATER INTO V-302
 7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 360 7-D 180

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 3.5 (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 9.5 (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)

142 OPERATOR STEP PB
 143 SP STEP 29. RECORD: PH 9.5 & TIME 12:45 A
 144 OPERATOR STEP PB
 145 SP STEP 60. BATCH COMPLETE.

4:00 pm to 2:10

START
TIME SP STEP7:00 A
3:00 P
11:00 PFINISH
TIME SP STEP3:00 P
11:00 P
12:00 P

OPTR

126-120
235-244
302-223