CG 03 CODE KY-787-D PKG
LOT OCT·30 80 37660
EST'D WGT 932 LBS
STANDARD HRS. 8.9 TIME 11P M

PROCESSES
( ) KY-787-D (Q) FWP 9/23/80
( ) ( ) (XOB-17: 25%
( ) ( ) LESS N-32-D
( ) ( ) & 240 MIN
( ) ( ) STRIKE)
TYPED BY: FP 9/23/80

APPROVED BY

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13198	93	900	14	YC002B	13198	93	900
14	YC002B	13197	93	1600	14	YC002B	13197	93	1600
14	YC002B		93		14	YC002B		93	

PUNCHED & CHECKED

NOV - 7 80

TOTAL EST'D WGT 3332 NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203 & 205	1	RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	240	32-D	240
	3	DUMP IN AND STIR 5 MIN LOT	48X50	YC-2-B	2400
		RECORD: START 3 PM 13198	900		
1		FIN 530PM 13197	1600		
	4	ADJUST TO 75" (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	6	HOMOG AT 2400-2600 PSI INTO V-~~205~~ 263			
263		WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	7	OF HOT WATER AT 2400-2600 PSI INTO V-~~205~~ 263			
		RECORD: V-~~205~~ 263 VOL ____" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
263 ~~205~~	9	RUN 10" (514 G) WATER INTO V-~~243~~ & START AGITATOR 263			
SV	10	PUMP V-~~205~~ THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 7:30AM TOTAL MINUTES 180			
2		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
		3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	11	WHEN V-~~205~~ 263 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 2 (V-243) OR POSITION 7 (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 ____% PRESET #1 80 GAL		15-A	160
		B. 13LG 26% 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		983-D	
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		~~32-D~~	1376
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.82			

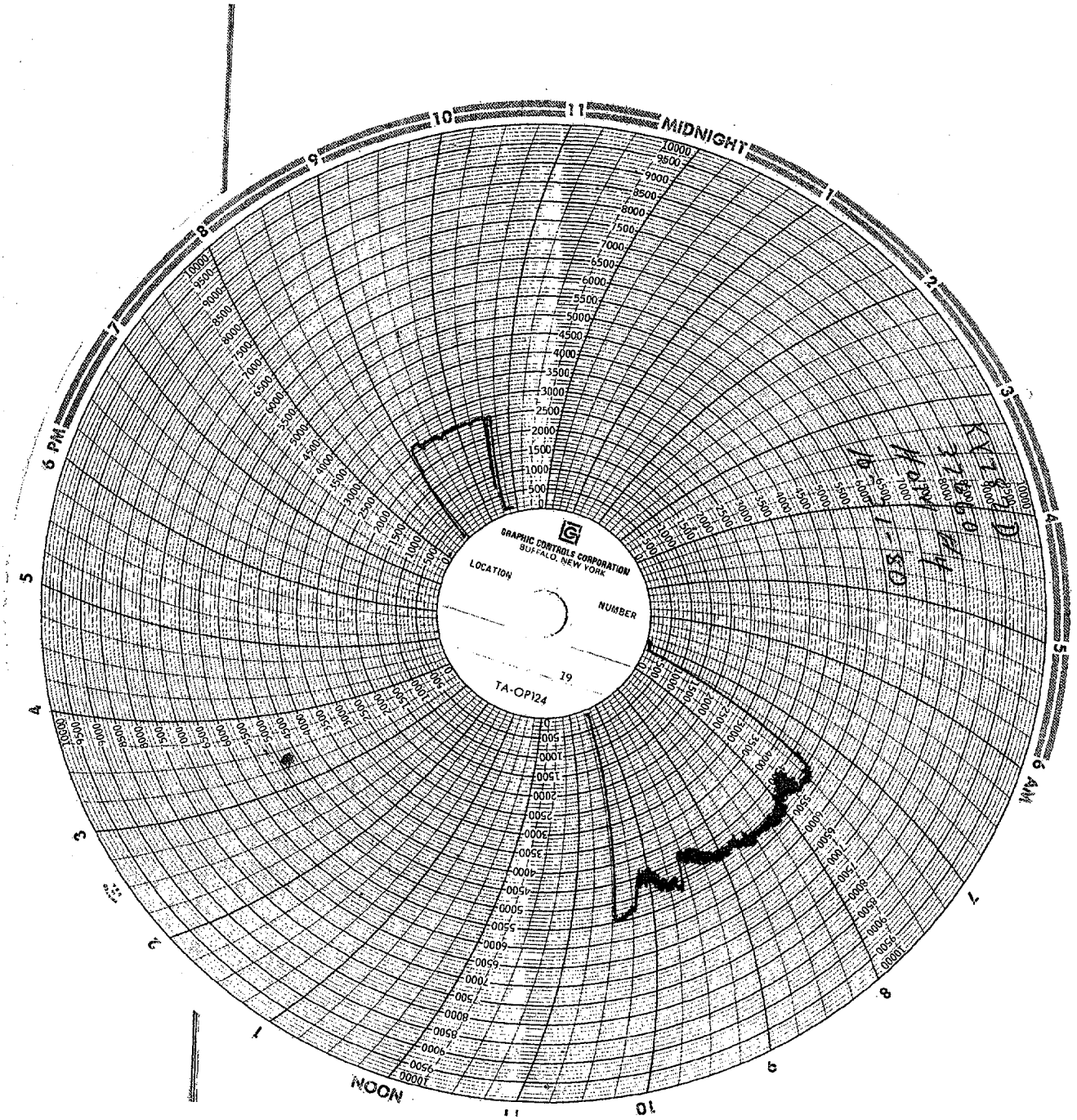
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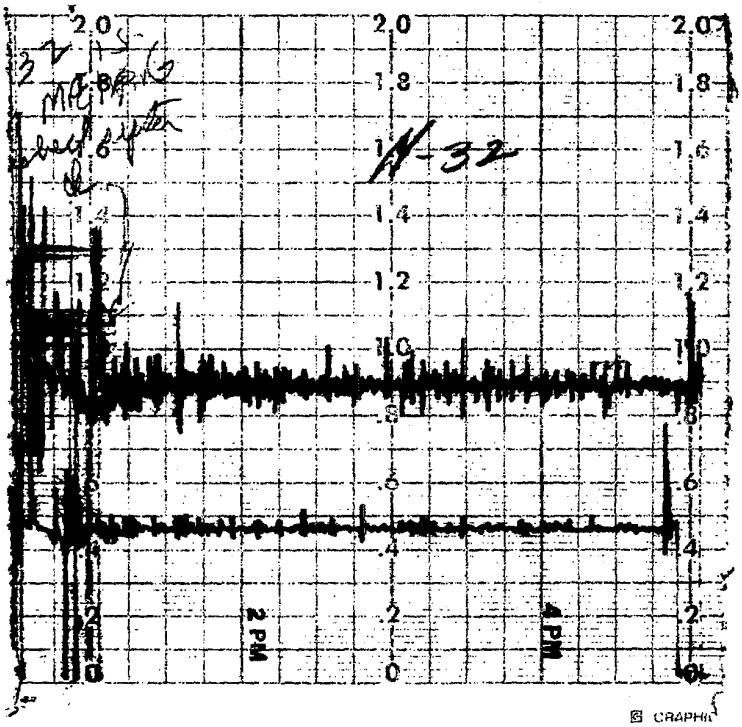
EQUIP		PAGE 2 CG 03 KY-787-D EST WGT 3332# V-243	USE LBS	N-CODE	USE LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 87 % IF BELOW 35% FOLLOW SOL'N			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 48" (2470 G)			
CP	19	RECORD PH 9.5. ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	20	72-D	20
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5			
SV	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	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: 15:57 pm	—		
		SP STEP			
32		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.4 9.0-10.0 1:47 pm			
		14/47 (60 MIN) 9.4 9.0-10.0 2:17 pm			
		15/48 (2 HRS) 9.4 9.0-10.0 3:17 pm			
		16/49 (3 HRS) 9.4 9.0-10.0 4:17 pm			
		16/49 (4 HRS) 9.2 9.0-10.0 5:17 pm			
		17/50 (FINISH) 8.8 7.5-8.5 6:02 pm			
		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	____
	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
	29	ADD IN 7-8 MIN	350	530-A	350
339	30	ADJ TO 49" (382 G) AT 80-100*F			
6	31	STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26			
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	34	SET PRESET #8 TO 38.2 GAL FROM S 33			
302	35	RUN 30" (360 G) WATER INTO V-302	80		
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	80	72-D	80
	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	38	SIFT IN	100	128-A	100
SV	39	SP STEP 23/53. RECORD: PH 3.4 (3.7-4.2)			
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
8	41	RECORD: PH 9.1 (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)			
	42	OPERATOR STEP PB			
	43	SP STEP 29/58. RECORD: PH 9.1 & TIME 2:57			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE. Pumped → V-240			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
____	_____	____	_____	____
3:00 p	_____	7:30 p	_____	252-304

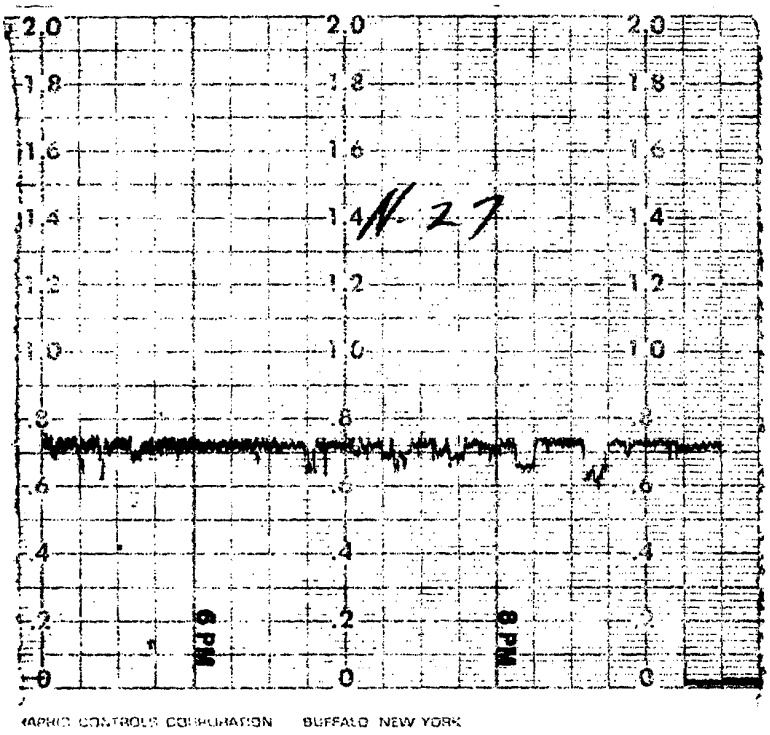
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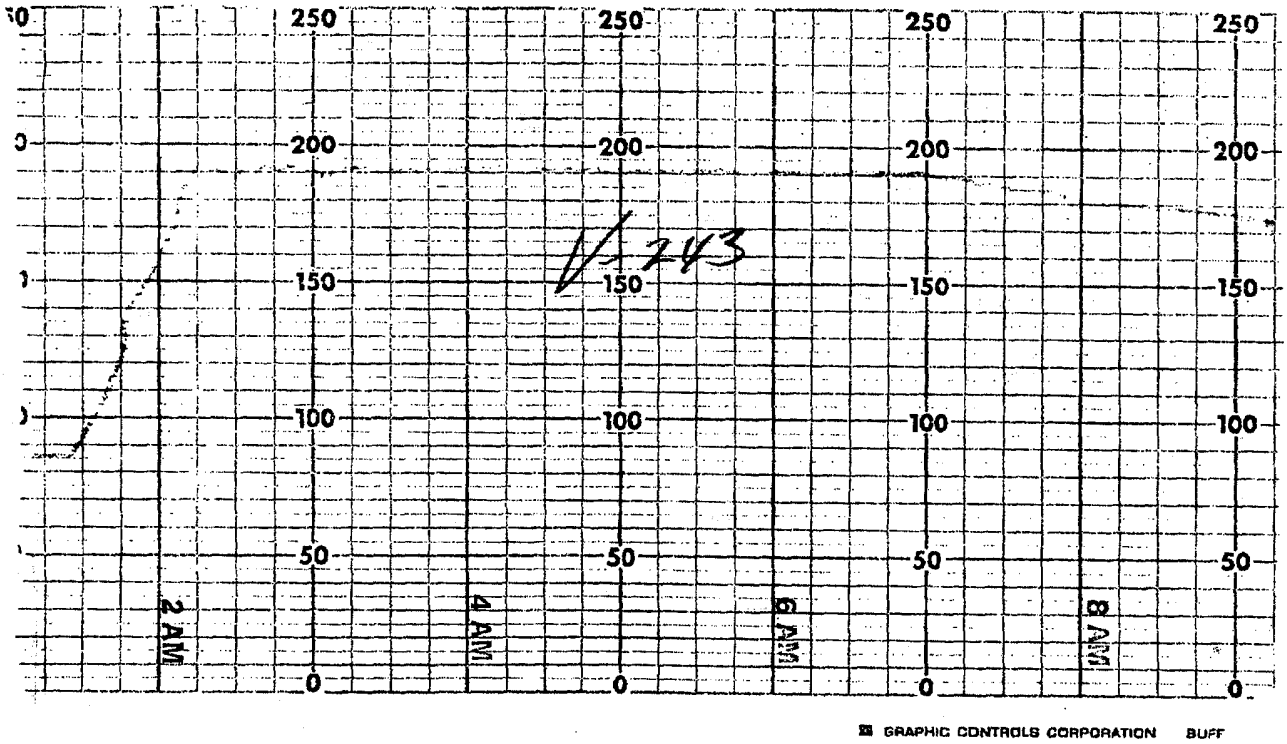


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6 PM
8 PM
N-27
FARRIC CONTROLS CORPORATION BUFFALO NEW YORK



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