CG 03 CODE KY-787-D PKG

LOT OCT--7 80 37364

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 3P M

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

APPROVED BY

OK AP

TYPED BY: FP 9/23/80

COMPONENT CONSUMPTION

| CG | CODE | LOT | PQ | LBS | CG | CODE | LOT | PQ | LBS |
|---|---|---|---|---|---|---|---|---|---|
| 14 | YC002B | 13086 | 93 | 2000 | 14 | YC002B | _____ | 93 | _____ |
| 14 | YC002B | 13096 | 93 | 400 | 14 | YC002B | _____ | 93 | _____ |
| 14 | YC002B | _____ | 93 | _____ | 14 | YC002B | _____ | 93 | _____ |

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 |
| 1 | | RECORD: START 1.15AM 13086 | 2000 | | |
| | | FIN 2.10AM 13096 | 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 40 " & ADJ TO 60" (2100 G) | | | |
| | 8 | INSPECT HOMOG STRAINER & CLEAN IF NECESSARY | | | |
| 205 | 9 | RUN 10" (514 G) WATER INTO V-244 & START AGITATOR | | | |
| SV 2 | 10 | PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 0130A TOTAL MINUTES 2 1/2 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 & CP 3 | 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) | | | |
| | 14 | RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: | | | |
| | | A. 11LG 41 % PRESET #1 80 GAL | | 15-A | 160 |
| | | B. 13LG 68 % PRESET #6 135 GAL | | 20-A | 135 |
| | 15 | SET STRIKE FLOW CONTROLLERS AS FOLLOWS: | | | |
| | | SFC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM | | 27-D | 206 |
| | | SFC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM | | | |
| | | SFR10 (N-27-D/WATER) RATIO 1.35 | | | |
| F.N. | | SFC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM | | 32-D | 1376 |
| | | SFC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM | | | |
| | | SFC20 (N-32-D WATER) IN REMOTE | | | |
| | | SFR10 (N-32-D/WATER) RATIO 1.82 | | | |

N34944

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| EQUIP | | PAGE 2 CG 03 KT-787-D EST WGT 33327 2CC9 | USE LBS | N- CODE | USE LBS |
|---|---|---|---|---|---|
| | 16 | OPERATOR STEP PB | | | |
| 320 | 17 | RECORD LEVEL 2LG ___% 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 9.9. 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 11.3 ASSUME 50% | 40 | 7-D | 20 |
| | 20 | OPERATOR STEP PB | | | |
| | 21 | SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.7 | | | |
| 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: | | | |
| | | SP STEP / V-243/V-244 — PH — RANGE — TIME | | | |
| | | 13/46 (30 MIN) 9.6 9.0-10.0 2 15 | | | |
| | | 14/47 (60 MIN) 9.5 9.0-10.0 2 45 | | | |
| | | 15/48 (2 HRS) 9.5 9.0-10.0 3 45 | | | |
| | | 16/49 (3 HRS) 9.5 9.0-10.0 4 45 | | | |
| | | 16/49 (4 HRS) 9.2 9.0-10.0 5 45 | | | |
| | | 17/50 (FINISH) 7.0 7.5-8.5 6 30 | | | |
| | | 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 10.1 (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 | | | |
| 7 | 36 | ADD & STIR 2 MIN FOR S 40 ASSUME 50% | 160 | 7-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 3.5 (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 9.4 (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 9.4 & TIME 7:15 PM | | | |
| | 44 | OPERATOR STEP PB | | | |
| | 45 | SP STEP 60. BATCH COMPLETE. | | | |

| START TIME | SP STEP | FINISH TIME | SP STEP | OPTR |
|---|---|---|---|---|
| 3:45 A.M | ____ | 5:15 A.M | ____ | 581-223 |
| 10:30A | ____ | 9 P.M | ____ | 120-126 |
| 3:00 PM | ____ | ___ | ____ | 432-37 |

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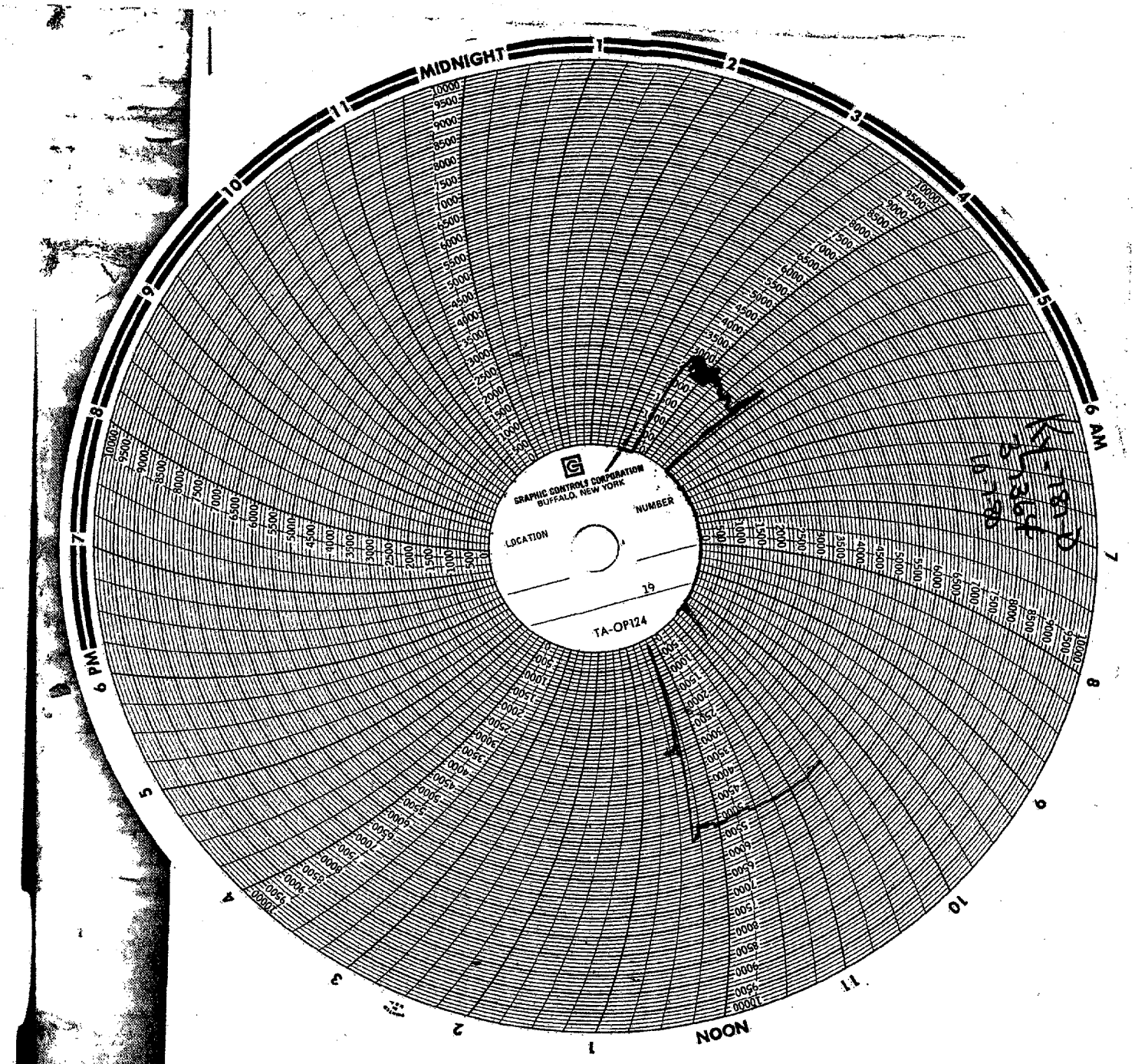


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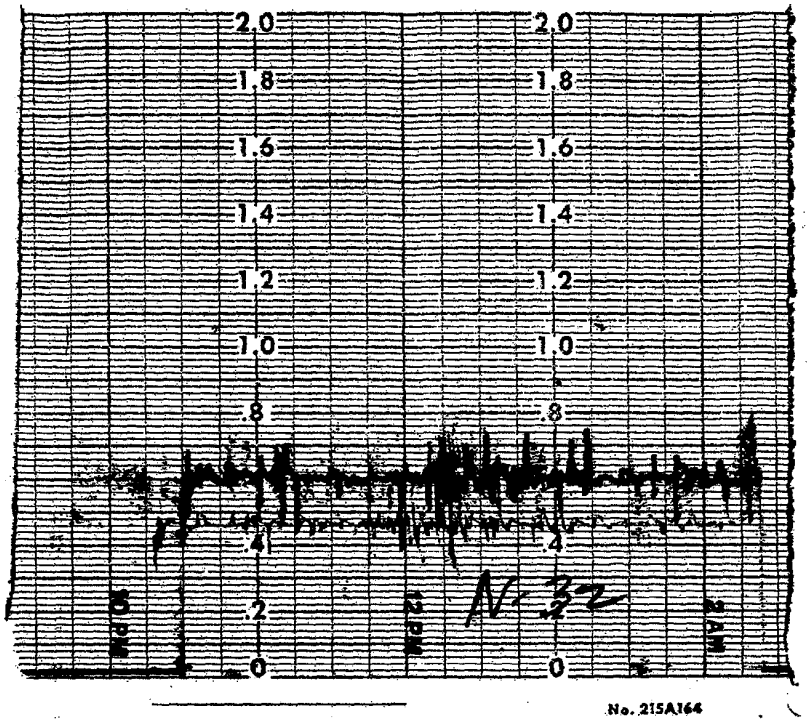


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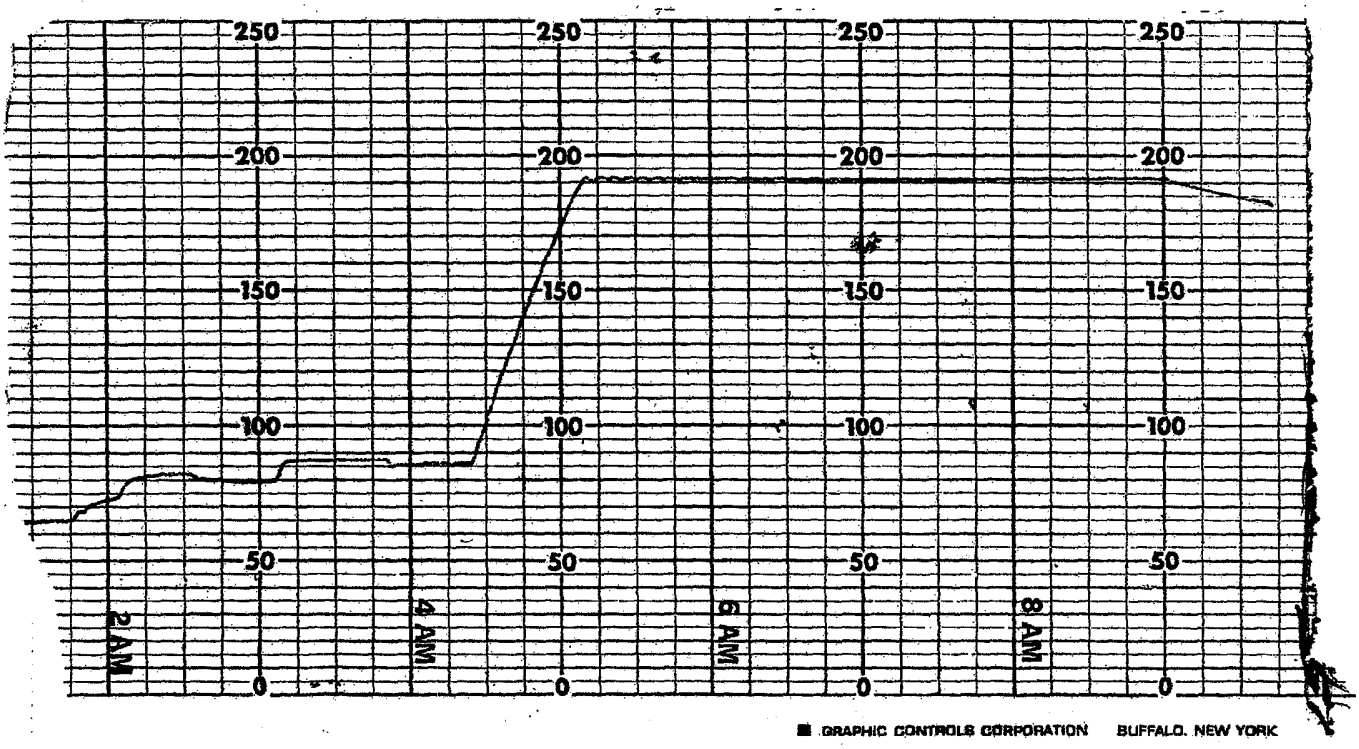


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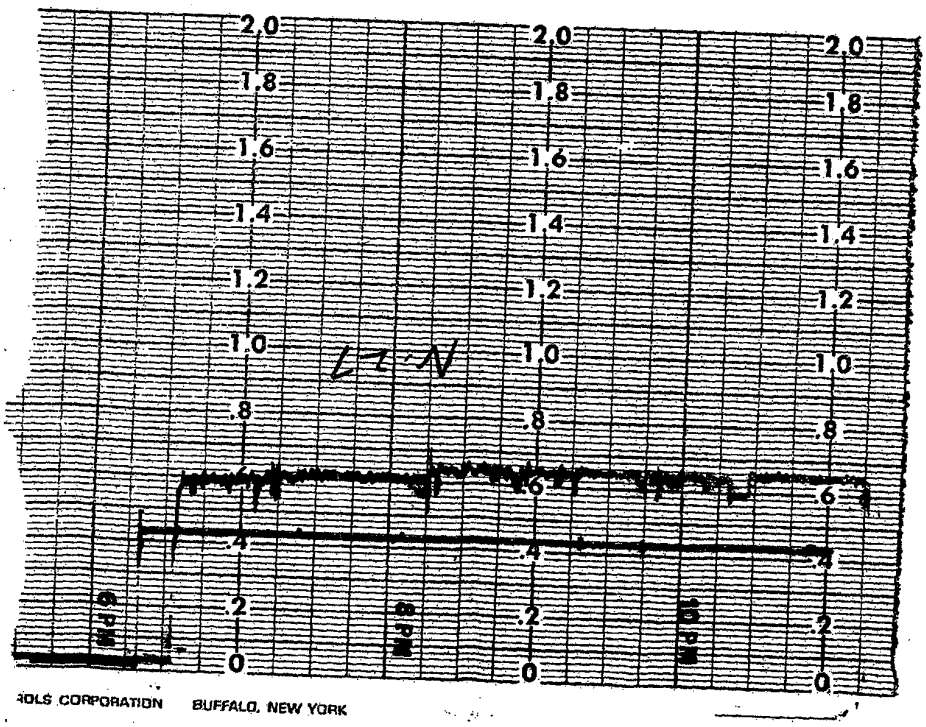


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