

CG 03 CODE KY-787-D PKG
LOT NOV-18 80 37932

EST'D WGT 332 LBS

STANDARD HRS. 8.9 TIME 11P M

PROCESSES APPROVED BY
() KY-787-D (Q) FWP 11/3/80
() (XOB-17: 25%
() LESS N-32-D
() & 240 MIN
() STRIKE)

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PR	LBS	CG	CODE	LOT	PR	LBS
14	YC002B	13175	93	2400	14	YC002B		93	
14	YC002B		93		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	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	240	983-D	240
	3 DUMP IN AND STIR 5 MIN LOT 10:05 AM 13175	48X50	YC-2-B	2400
	RECORD: START 11:39 AM	2400		
	FIN			
	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	9 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 1230 TOTAL MINUTES 155			
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	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
&	2 (V-243) OR POSITION 7 (V-244)			
CP	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 24% 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			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM	983-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			

USE FLASK CHAS. NO. NOV 20 1980

TM

243

16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 58% IF BELOW 35% FOLLOW SOL'N		
SV	18	MAKE-UP PROCEDURE FOR N-27-D		
SP	19	ADJUST SV TO 48" (2470 G)		
CP	20	RECORD PH 10.2 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 11.4 ASSUME 50%	12	721 10
	20	OPERATOR STEP PB		

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0		
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO		
	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 5:15 Am		
		14/47 (60 MIN) 9.5 9.0-10.0 5:45 Am		
		15/48 (2 HRS) 9.4 9.0-10.0 6:15 Am		
		16/49 (3 HRS) 9.3 9.0-10.0 7:45 Am		
		16/49 (4 HRS) 9.2 9.0-10.0 8:45 Am		
		17/50 (FINISH) 7.0 7.5-8.5 9:30 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

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		
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	80	721-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 4.0 (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 9.5 (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)		
42	OPERATOR STEP PB			
43	SP STEP 29/58. RECORD: PH 9.3 & TIME 12:25 Am			
44	OPERATOR STEP PB			
45	SP STEP 60. BATCH COMPLETE. Pump To V-240			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
3:00 PM	11:00 AM	322-320
11:00 PM	7:45 AM	257
7:45 AM	10:40 AM	54-223







