

CG 03
LOT

CODE RT-795-D PRG

PROCESSSES
KY-795-D

APPROVED BY
(H) FWP 10/21/80

OCT-28 80 37601

STANDARD HRS. 8.2 TIME 7A M

TYPED BY: FWP 10/21/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13198	93	3500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

HOMO G #3. 1ST PASS

CLEAN UP AS YOU GO ALONG

TOTAL EST'D WGT 4380

NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
	"KROLOR" YELLOW MEDIUM			
203	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	475	32-D	475
	RECORD: START 11.30 PM LOT 13198	70X50	YC-2-B	3500
	FIN 12.50 AM	3500		
	ADJUST TO 75" (1275 G)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL 48" & ADJ TO 60" (2100 G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 2.30 PM TOTAL MINUTES 120			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	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 5 (V-243) OR (POSITION 10 (V-244))			
CP	PRESS SV CAM RESET PB - SET 22 TO IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
3	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 26% PRESET #1 104 GAL		15-A	208
	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM		27-D	296
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.04			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM		32-D	1885
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.59			

N35046

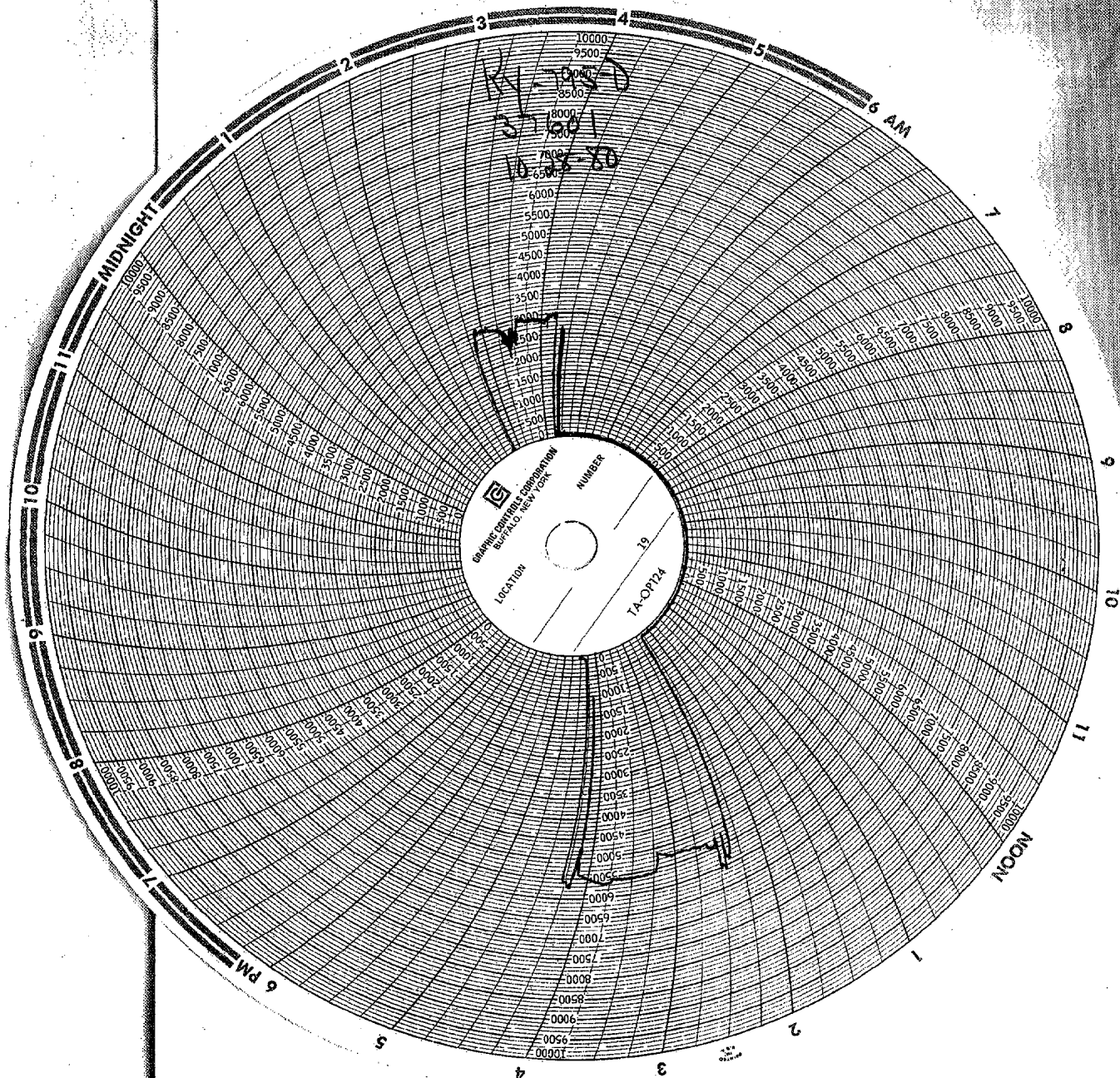
16	OPERATOR STEP PB			
17	RECORD LEVEL 2LG <u>40</u> % IF (35% FOLLOW SOLUTION			
SV	MAKE-UP PROCEDURE FOR N-27-D			
SP	ADJUST SV TO 58" (2980 G)			
CP	RECORD PH <u>10.5</u> . ADJ TO 11.1-11.3 WITH N-7-D AT			
	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	SIPHON INTO SV. RECORD: PH <u>11.1</u> . ASSUME 50%	10	721-D	10
20	OPERATOR STEP PB			

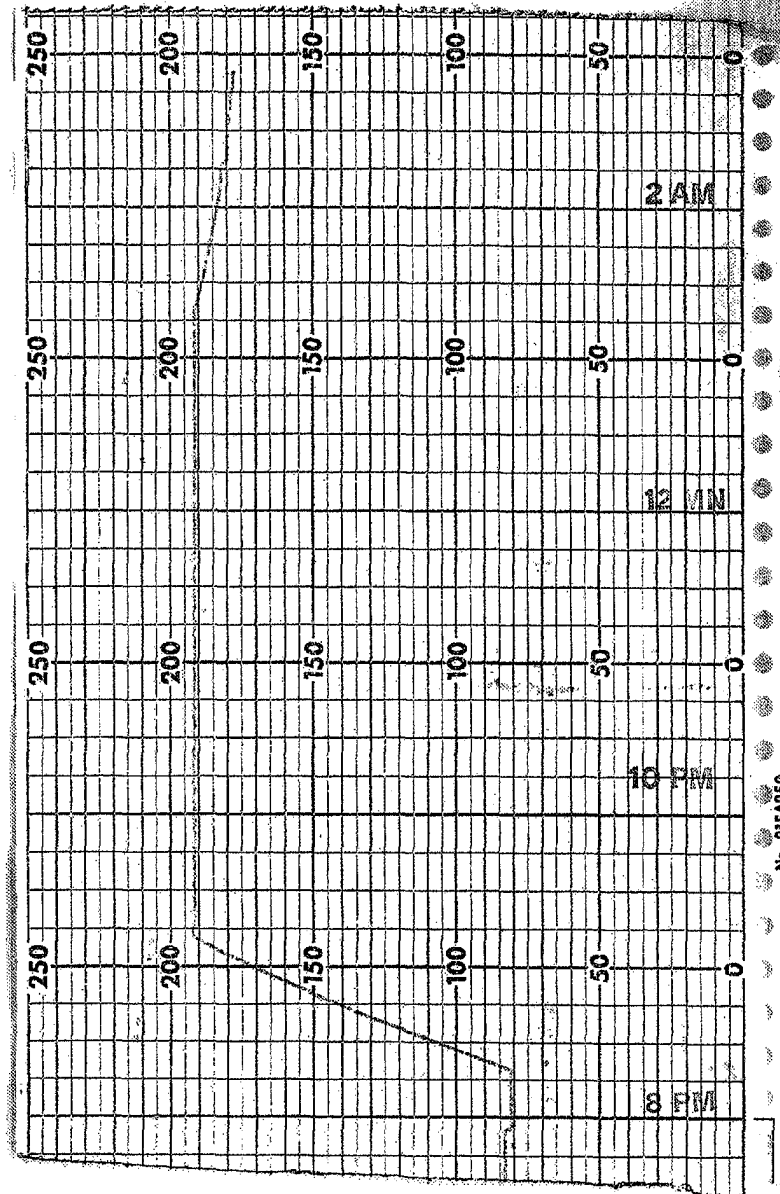
21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.8</u>			
SV	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	OPERATOR STEP PB			
24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
	LIMITS, SWITCH 3FC20 TO REMOTE			
26	OPERATOR STEP PB			
27	DURING STRIKE RECORD:			
	SP STEP			
	V-243/V-244			
	PH RANGE TIME			
	13/46 (30 MIN) <u>9.6</u> 9.0-10.0 <u>7:20</u>			
	14/47 (60 MIN) <u>9.6</u> 9.0-10.0 <u>7:50</u>			
	15/48 (2 HRS) <u>9.4</u> 9.0-10.0 <u>8:50</u>			
	16/49 (3 HRS) <u>9.4</u> 9.0-10.0 <u>9:50</u>			
	16/49 (4 HRS) <u>9.3</u> 9.0-10.0 <u>10:50</u>			
	17/50 (FINISH) <u>7.7</u> 7.5-8.5 <u>11:35 PM</u>			
	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	

DRUM	28	WEIGH INTO 55 GAL DRUM	ASSUME 50%	28
6	29	FILL WITH WATER & STIR 2 MIN		28

130	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	SP STEP 23/53 - RECORD: PH <u>3.6</u> (3.3-3.7)			
SP	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
&	RECORD: PH ____		15-A	
CP	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7	*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
	STIR 5 MIN AFTER EACH ADDITION.			
23	SIFT IN	150	128-A	150
34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR			
	5 MIN			
35	RECORD: PH <u>4.2</u> (4.0-4.2) & IF NECESSARY ADJ TO			
	PH 4.0-4.2 & RECORD: PH ____ ASSUME 77%		27-D	
	(DILUTE 10 TO 1 WITH WATER). ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV			
36	OPERATOR STEP PB			
37	SP STEP 24/54 - POUR IN & STIR 15 MIN	22	978-A	22
38	OPERATOR STEP PB			
39	SP STEP 60 - BATCH COMPLETE			
40	OPERATOR STEP PB			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
2:00 AM	3:00 PM	381.201
2:30 P	3:00	176
3:00 PM	11:00 PM	350.204
11.0	12:30 PM	201





No. 215A250

