

(AUTOMATED)
S.V. 243, 244

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-788-D PKG

LOT NOV-25 80 38029

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME 7A M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 11/3/80
() () 4 HOUR STRIKE
() () AS FOR XDB-17
() ()
() ()

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	13066	93	2600	14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	

HOMOLOG #3 - 1st PASS

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.	350		350
205	2 WEIGH IN DRUM & POUR IN	345	983-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START 9:27 AM	13066		
	FIN 12:30 AM			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOLOG AT 2400-2600 PSI INTO V-205			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOLOG WITH MIN. OF HOT WATER AT 2400-2600 PSI INTO V-205			
	7 RECORD: V-205 VOL " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOLOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOLOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 8:30P TOTAL MINUTES 190			
2	NOTE: IF HOMOLOG 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 HOMOLOG AT 4800-5200 PSI INTO SV			

SP 142 SP STEP 01 - SET FORMULA SELECTOR TO POSITION

& 3 (V-243) OR POSITION 8 (V-244)

CP 143 PRESS SV CAM RESET PB - SET 22 TC IN AUTO

REMOTE (TEMP IS SET AT 190-194°F)

3 144 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:

A. 11LG 36% PRESET #2 208 GAL

B. 13LG 32% PRESET #6 135 GAL

145 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:

3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM

3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM

3FR10 (N-27-D/WATER) RATIO 0.8

8FC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM

8FC20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM

8FC20 (N-32-D WATER) IN REMOTE

8FR10 (N-32-D/WATER) RATIO 1.1

15-A 416

20-A 135

27-D 180

983-D 4215

1940

V-243

320 ~~116~~ OPERATOR STEP PB
 SV ~~117~~ RECORD LEVEL 2LG 24% IF (35% FOLLOW SOLUTION
 SP ~~118~~ MAKE-UP PROCEDURE FOR N-27-D
 CP ~~119~~ ADJUST SV TO 47" (2400 G)
 4 ~~120~~ RECORD PH 10.0 ADJ TO 11.0-11.2 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 ~~121~~ SIPHON INTO SV. RECORD: PH 11.1. ASSUME 50% 20 721-D 20
 4 ~~122~~ OPERATOR STEP PB

SV ~~123~~ SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.6
 SP ~~124~~ SWITCH 3FC20, BFC10, & 8FC20 TO AUTO
 SP ~~125~~ OPERATOR STEP PB
 5 ~~126~~ SP STEP 10/43. WHEN 3FC20, BFC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 ~~127~~ SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
 5 ~~128~~ OPERATOR STEP PB
 5 ~~129~~ DURING STRIKE RECORD:
 5 ~~130~~ SP STEP
 5 ~~131~~ V-243/V-244
 5 ~~132~~ 13/46 (30 MIN) PH RANGE TIME
 5 ~~133~~ 14/47 (60 MIN) 9.5 9.3-10.0 2:10
 5 ~~134~~ 15/48 (2 HRS) 9.4 9.3-10.0 2:00
 5 ~~135~~ 16/49 (3 HRS) 9.4 9.3-10.0 3:30
 5 ~~136~~ 16/49 (4 HRS) 9.4 9.3-10.0 4:40
 5 ~~137~~ 16/49 (4 HRS) 9.4 9.3-10.0 5:40
 5 ~~138~~ 17/50 (FINISH) 7.8 7.5-8.5 1:25 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

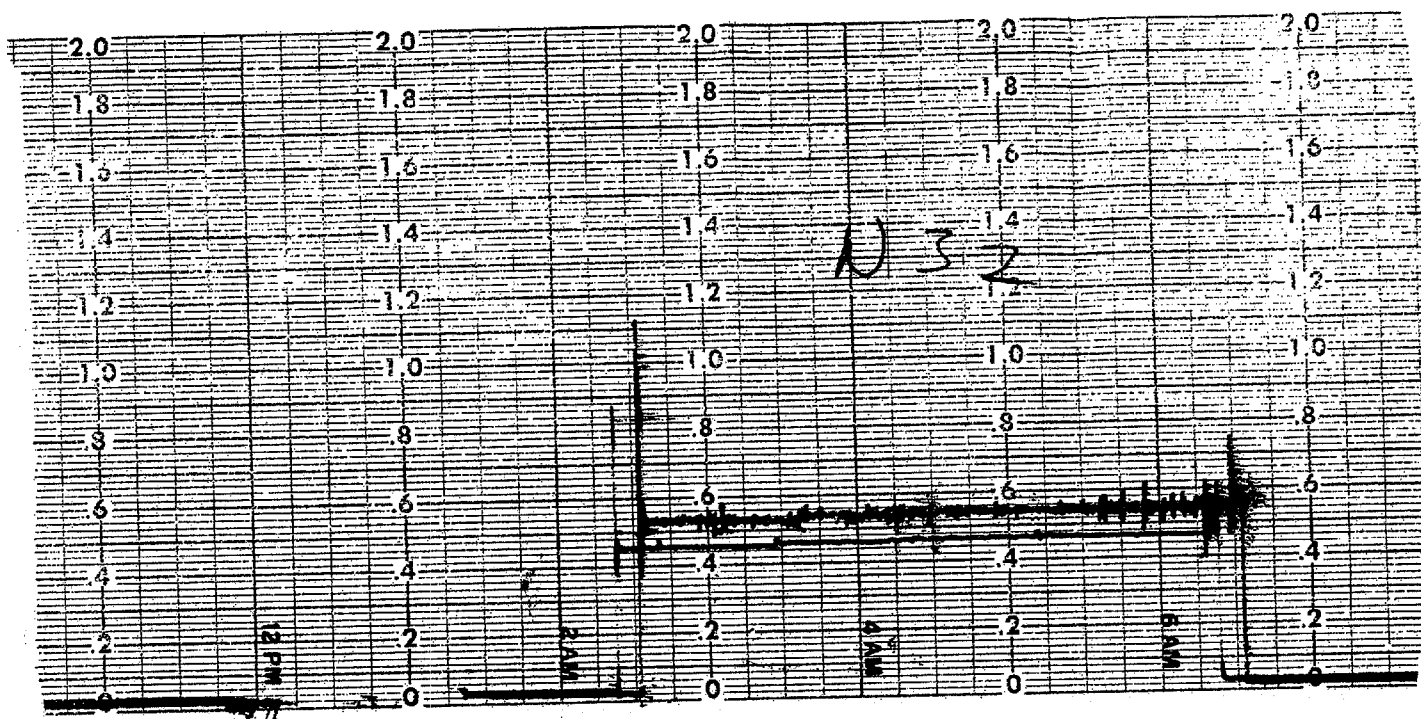
339 ~~139~~ WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 6 ~~140~~ ADD IN 7-8 MIN 350 530-A 350
 6 ~~141~~ ADJ TO 49" (382 G) AT 80-100°F
 6 ~~142~~ STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
 6 ~~143~~ STIR 15 MIN OR LONGER FOR SP STEP 26/56
 6 ~~144~~ RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL
 6 ~~145~~ SET PRESET #8 TO 38.2 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% 180 721-D 180

SV ~~137~~ SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 SV ~~138~~ SIFT IN 100 128-A 100
 SP ~~139~~ SP STEP 23/53. RECORD: PH 3.1 (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 9.1 (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)
 8 ~~142~~ OPERATOR STEP PB
 8 ~~143~~ SP STEP 29. RECORD: PH ____ & TIME ____
 8 ~~144~~ OPERATOR STEP PB
 8 ~~145~~ SP STEP 60. BATCH COMPLETE.

46 PUMP TO 240

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>3:00 P</u>	<u>1:00 P</u>	<u>259</u>
<u>11:00 AM</u>	<u>7:00 AM</u>	<u>320</u>
<u>7:00 AM</u>	<u>8:00 AM</u>	<u>282</u>



No. 215A164

