

CG-03 CODE KY-795-D PKG

LOT OCT-14 80 37449

EST'D WGT 880 LBS

STANDARD HRS. 8.2 TIME 110 M

PROCESSES APPROVED BY
 () KY-795-D (H) FWP 7/24/80
 () () (XOB-17: 3/4
 () () N-32-D & 240
 () () MIN STRIKE)
 () ()
 TYPED BY: FWP 7/24/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	82813-2	93	3500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

HOMO G 3-1st Pass

TOTAL EST'D WGT ~~4420~~ 4380 4230

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	475	32-D	475
	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3750
	RECORD: START <u>11:00 AM</u> <u>82813-2</u>	3500		3500
	FIN <u>5:30 AM</u>			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO <u>V-205</u> <u>V-263</u>			
	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 " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 SV	9 RUN 10" (514 G) WATER INTO V- 244 & START AGITATOR			
	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <u>6:00 P</u> TOTAL MINUTES <u>120</u>			
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	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (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 <u>55</u> % PRESET #1 104 GAL		15-A	208
	15 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			

N34981

V-244

16	OPERATOR STEP PB			
17	RECORD LEVEL 2LG 44% IF <35% FOLLOW SOLUTION			
SV	MAKE-UP PROCEDURE FOR N-27-D			
SP	ADJUST SV TO 68" (3495 G)			
CP	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 11.2 ASSUME 50%	40	7-D	20
120	OPERATOR STEP PB			

21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8.			
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) 9.7 9.0-10.0 1105 P			
	14/47 (60 MIN) 9.6 9.0-10.0 1135 P			
	15/48 (2 HRS) 9.5 9.0-10.0 1235 A			
	16/49 (3 HRS) 9.4 9.0-10.0 135 A			
	16/49 (4 HRS) 9.3 9.0-10.0 235 A			
	17/50 (FINISH) 7.9 7.5-8.5 320 A			
	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE			
	IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.			
	A RECORD: PH ASSUME 77%		27-D	

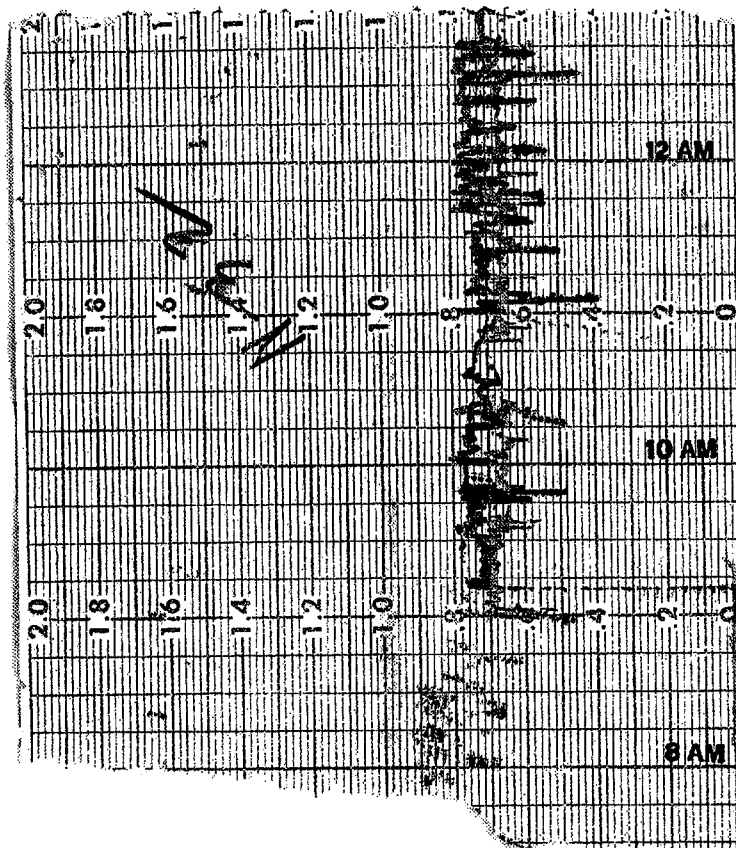
DRUM	WEIGH INTO 55 GAL DRUM	ASSUME 50%	56	7-D	28
6	FILL WITH WATER & STIR 2 MIN				

120	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.				
SV	SP STEP 23/53 - RECORD: PH 3.5 (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.				
133	SIPHON IN		150	128-A	150
134	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR				
	5 MIN				
135	RECORD: PH 4.05 (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				
136	OPERATOR STEP PB				
137	SP STEP 24/54 - POUR IN & STIR 15 MIN		22	978-A	22
138	OPERATOR STEP PB				
139	SP STEP 60 - BATCH COMPLETE				
140	OPERATOR STEP PB				

START
TIME SP STEP
800P
11:00P

FINISH
TIME SP STEP
11:00P
4:00 AM

OPTR
126-207
235-244



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