

(AUTOMATED)

S.V. 243

C.V.

NOV 24 1980

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 03 CODE KY-788-D PKG

LOT DEC -2 80 38094

EST'D WGT 240 LBS

STANDARD HRS. 8.8 TIME M

PROCESSES

APPROVED BY

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

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC003B	13071	93	2000
14	YC003B	13066	93	600
14	YC003B		93	

CG	CODE	LOT	PQ	LBS
14	YC003B	13071	93	2000
14	YC003B	13066	93	600
14	YC003B		93	

HOMOG 3.1 PSI PASS

TOTAL EST'D WGT 3560

CLEAN UP

AS YOU GO ALONG

NON-BLEEDING

EQUIP	NAME : "KROLD" YELLOW-LIGHT	USE LBS	N- CODE	ADCT 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 7 A.M. 13071	2000		
	FIN 9 A.M. 13066	600		
	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 45" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-213 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 9:45 PM TOTAL MINUTES 155			
	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 3 (V-243) OR POSITION B (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 60% PRESET #2 208 GAL	15-A	416
		B. 13LG 22% PRESET #6 135 GAL	20-A	135
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:		
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM	27-D	180
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM		
		3FR10 (N-27-D/WATER) RATIO 0.8		
		3FC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM	983-D	4215
		3FC20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM		1240
		3FC20 (N-32-D WATER) IN REMOTE		
		3FR10 (N-32-D/WATER) RATIO 1.1		

EQUIP

PAGE 2

CG 03

KY-788-D

EST WGT 3560#

USE

H

DIA

LBS

CODE

LBS

320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG <u>24.2</u> IF <35% FOLLOW SOLUTION			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 47" (2400 G)			
	19	RECORD PH <u>10.2</u> . ADJ TO 11.0-11.2 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH <u>11.2</u> ASSUME 50%	<u>32</u>	7-D	<u>16</u>
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.2</u>			
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: <u>5.20 A</u>			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) <u>9.5</u> 9.3-10.0 <u>5.50 A</u>			
		14/47 (60 MIN) <u>9.4</u> 9.3-10.0 <u>6.20 A</u>			
		15/48 (2 HRS) <u>9.3</u> 9.3-10.0 <u>7.20 A</u>			
		16/49 (3 HRS) <u>9.3</u> 9.3-10.0 <u>8.20 A</u>			
		16/49 (4 HRS) <u>9.3</u> 9.3-10.0 <u>9.20 A</u>			
		17/50 (FINISH) <u>7.2</u> 7.5-8.5 <u>10.05 A</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 <u>---</u> 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 <u>10.0</u> (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
	33	RECORD: VOL <u>49</u> " & CALC <u>49</u> " X 0.78 = <u>38.2</u> GAL			
	34	SET PRESET #8 TO <u>38.2</u> GAL FROM S 33			
302	35	RUN 40" (440 G) WATER INTO V-302			
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	160
	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 <u>9.2</u> (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 <u>9.3</u> (9.0-9.5). ADJ IF NECESSARY &			
		RECORD: PH <u>---</u> 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. RECORD: PH <u>9.2</u> & TIME <u>11:30 A M</u>			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START

TIME SP STEP

FINISH

TIME SP STEP

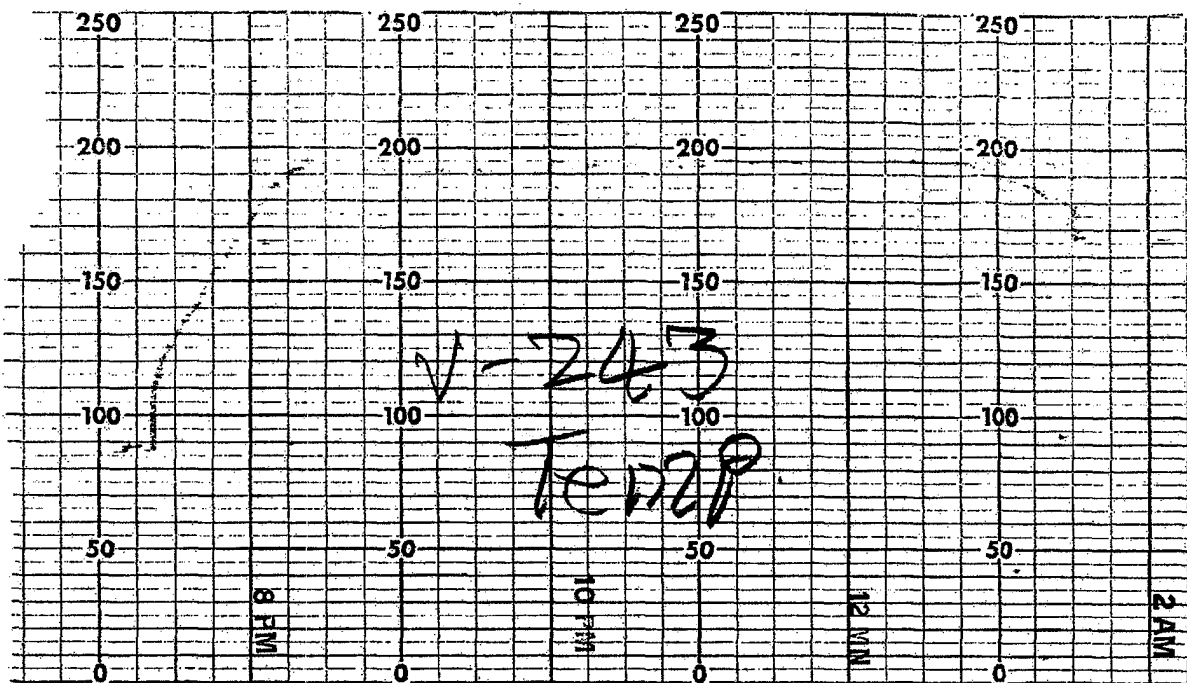
OPTR

5:15 PM
11:00 AM
1:00 PM

11:00 PM
7:00 AM
11:35 A M

38.232
301
320.235

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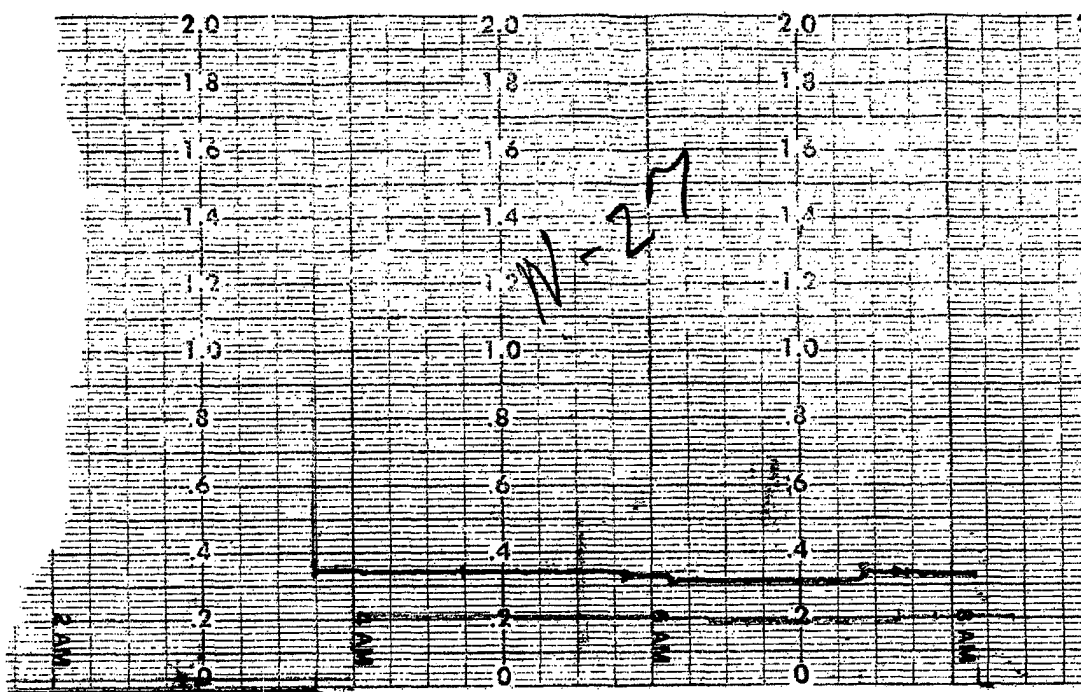


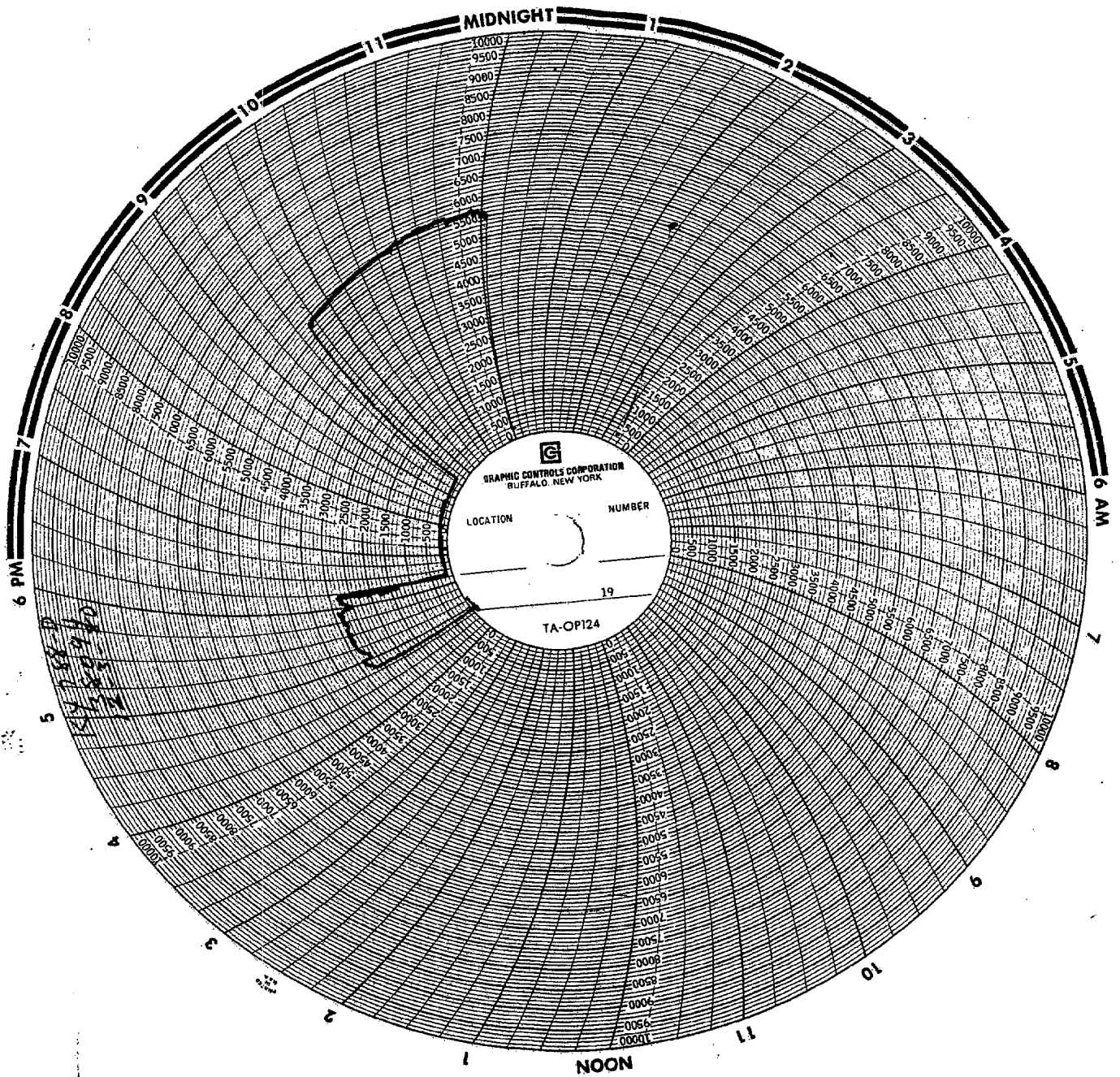
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