

CG 03 CODE KY-788-D PKG

PROCESSES

APPROVED BY

LOT DEC-1 80 38073

() KY-788-D (J) FWP 11/3/80

EST'D WGT 960

LBS

() 4 HOUR STRIKE

() AS FOR XOB-17

STANDARD HRS. 8.8

TIME

7A M

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC003B	24721	93	2000
14	YC003B	13066	93	600
14	YC003B		93	

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

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP NAME : "KROLOR" YELLOW-LIGHT

USE
LBSN-
CODEACCT
LBS203 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

LOT

52X50

YC-3-B

2600

RECORD: START

24721

40

FIN

13066

12

4 ADJUST TO 75" (1275 G)

5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU
HOMOG AT 2400-2600 PSI INTO V-2056 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 44" & ADJ TO 60" (2100 G)

8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY

205 9 RUN 10" (514 G) WATER INTO V-205 & START
AGITATORSV 10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.
RECORD: TIME START 9:50 PM TOTAL MINUTES 125

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

& 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 4.3% PRESET #2 208 GAL

15-A

416

B. 13LG 5.4% PRESET #4 135 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

BFC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM

983-D

415

BFC20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM

BFC20 (N-32-D WATER) IN REMOTE

BFR10 (N-32-D/WATER) RATIO 1.1

1240

V-243

320 147 OPERATOR STEP PB
SV 147 RECORD LEVEL 2LG 8.1% IF <35% FOLLOW SOLUTION
SP 148 MAKE-UP PROCEDURE FOR N-27-D
CP 148 ADJUST SV TO 47" (2400 G)
149 RECORD PH 10.2. ADJ TO 11.0-11.2 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 150 SIPHON INTO SV. RECORD: PH 11.0. ASSUME 50% 20 7-D 10
150 OPERATOR STEP PB

121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9
SV 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 123 OPERATOR STEP PB
124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
126 OPERATOR STEP PB
127 DURING STRIKE RECORD:
SP STEP

V-243/V-244

	PH	RANGE	TIME
13/46 (30 MIN)	9.7	9.3-10.0	3:10
14/47 (60 MIN)	9.7	9.3-10.0	3:40
15/48 (2 HRS)	9.6	9.3-10.0	4:40
16/49 (3 HRS)	9.5	9.3-10.0	5:40
16/49 (4 HRS)	9.4	9.3-10.0	6:40
17/50 (FINISH)	7.3	7.5-8.5	7:25

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

128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
129 ADD IN 7-8 MIN 350 530-A 350
339 130 ADJ TO 49" (382 G) AT 80-100°F
6 131 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
132 STIR 15 MIN OR LONGER FOR SP STEP 26/56
133 RECORD: VOL 19" & CALC 19" X 0.78 = 382 GAL
134 SET PRESET #8 TO 382 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% 360 7-D 180

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
138 SIFT IN 100 128-A 100
SV 139 SP STEP 23/53. RECORD: PH 3.3 (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 9.3 (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)

142 OPERATOR STEP PB
143 SP STEP 29. RECORD: PH 9.3 & TIME 8:45 AM
144 OPERATOR STEP PB
145 SP STEP 60. BATCH COMPLETE.

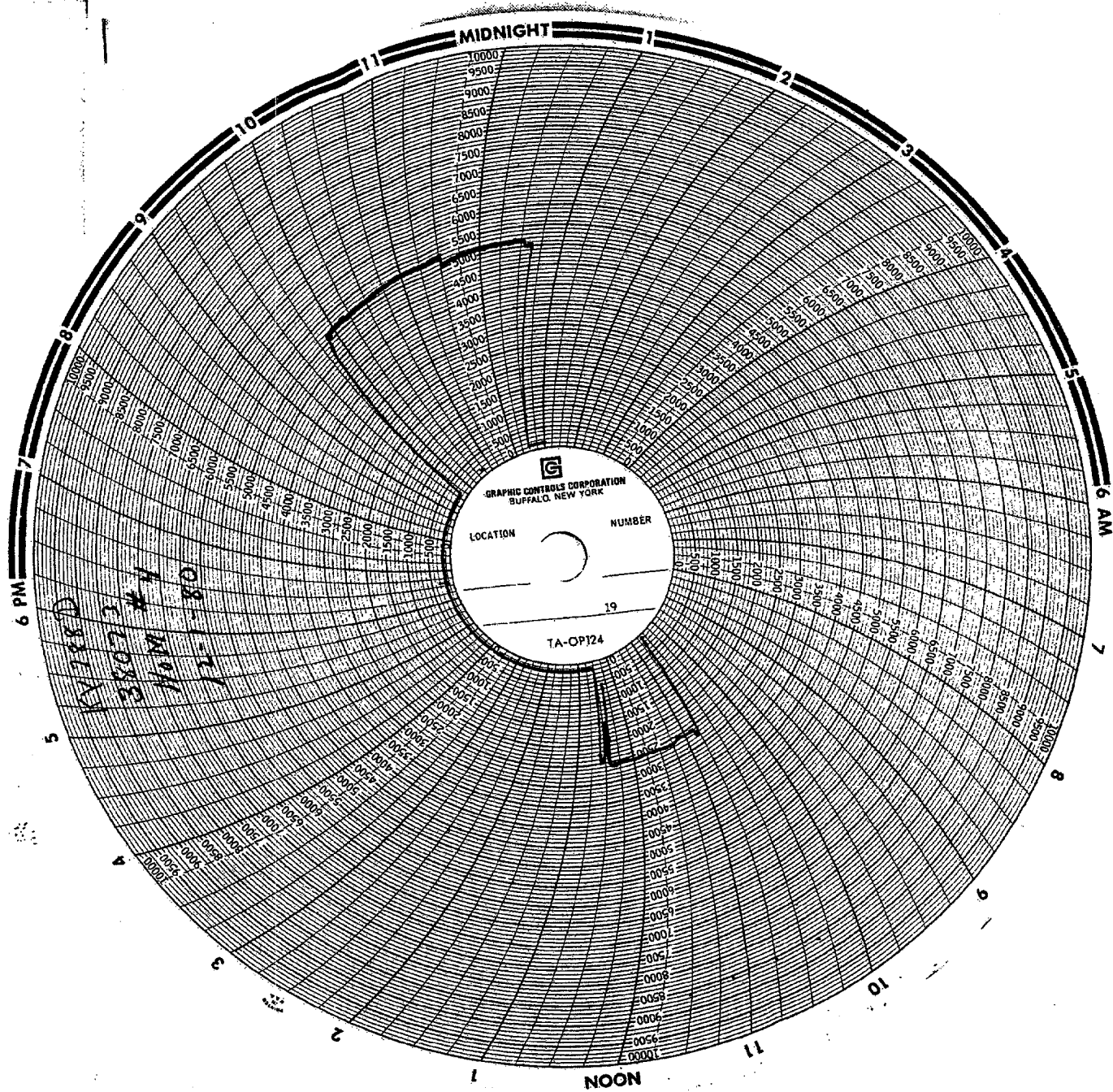
Note AG, for OFF
at shift CHANGE (V-243)
while stirring
low Vol come in Vat
extend - #237

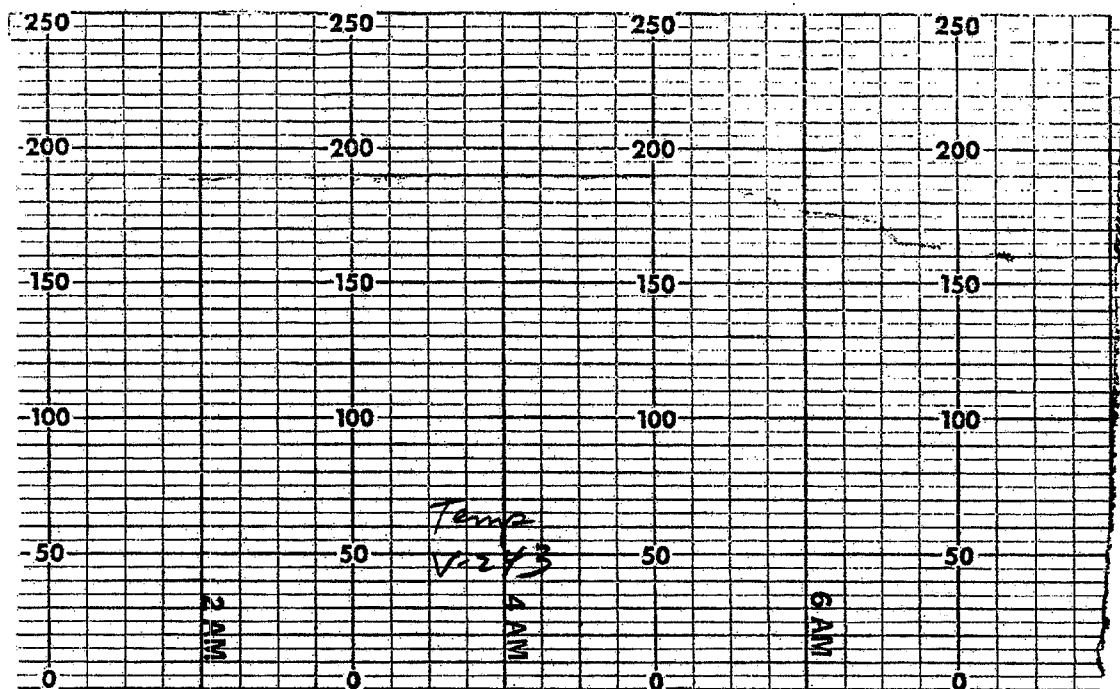
START
TIME SP STEP
7:00 AM
7:00 AM

FINISH
TIME SP STEP
3:00 AM
8:45 AM

OPTR
37-244
237-235

NO CHARTS
for N-27
N-32





GRAPHIC CONTROLS C