

(AUTOMATED)

3 VZ 243 244

C.V.

JUN 23 1980

MAKING INSTRUCTIONS BATCH UNIT
D.V.CG 03 CODE KY-781-D PKG
LOT

JUN 25 36303

EST'D WGT 1128 LBS

STANDARD HRS. TIME 3 PM

PROCESSES APPROVED BY

() KY-781-D (N) FWP 6/20/80

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TYPED BY: FWP 6/20/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	23870	93	2000	14	YC003B		93	
14	YC003B	23876	93	1300	14	YC003B		93	
14	YC003B		93		14	YC003B		93	

PUNCHED & CHECKED

Homog #3 - 1st Pass

TOTAL EST'D WGT 4428

JUN 30 1980

JUN 26 1980

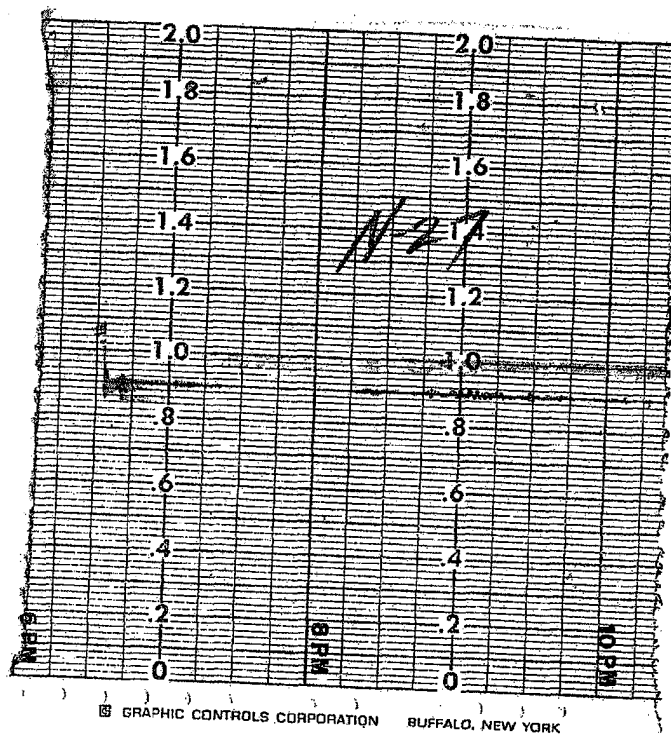
NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
	"KROLOR" YELLOW LIGHT			
203	✓ RUN 60" (990 G) WATER IN V-203 & ADD ASSUME 50%	36	7-D	18
&	✓ SET AGITATOR ON HIGH SPEED.			
205	✓ WEIGH IN DRUM & POUR IN	442	32-D	442
	✓ DUMP IN AND STIR 5 MIN	66X50	YC-3-B	3300
	RECORD: START 9 PM 23880 - 40 - 2000			
	FIN 10 PM 23876 - 26 - 1300			
1	✓ ADJUST TO 75" (1275 G)			
5	✓ WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
6	✓ HOMOG AT 2400-2600 PSI INTO V-205			
7	✓ WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
8	✓ OF HOT WATER AT 2400-2600 PSI INTO V-205			
	✓ RECORD: V-205 VOL 38" & ADJ TO 45" (1662 G)			
	✓ INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	✓ 9 RUN 10" (514 G) WATER INTO V-203 & START			
	AGITATOR			
SV	✓ 10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 5:30 PM TOTAL MINUTES 120			
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			
&	1 (V-243) OR POSITION 6 (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 63% PRESET #3 187 GAL		15-A	374
15	✓ SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.9 GPM		27-D	373
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM			
	3PR10 (N-27-D/WATER) RATIO 0.7			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM		32-D	252
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	8PR10 (N-32-D/WATER) IN REMOTE			
	0.9			

N32231

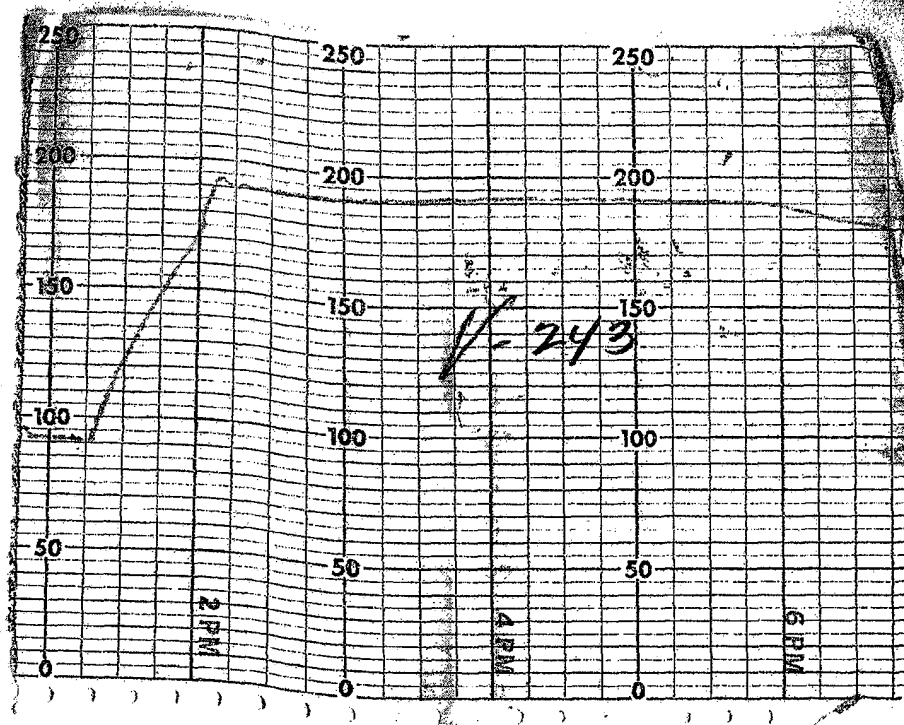
V-243

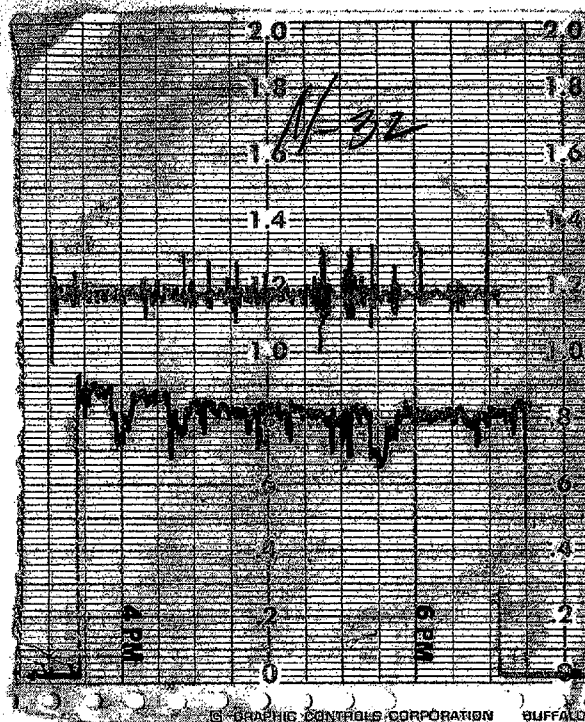
		11	OPERATOR STEP PB				
		12	RECORD LEVEL 2LG 90% IF <35% FOLLOW SOLUTION				
SV		13	MAKE-UP PROCEDURE FOR N-27-D				
SP		14	ADJUST SV TO 54" (2300 G)				
CP		15	RECORD PH 10.4. ADJ TO 11.4-11.6 WITH N-7-D AT				
			5% (10 PARTS WATER TO 1 PART N-7-D)				
4		16	SIPHON INTO SV. RECORD: PH 11.6. ASSUME 50%	32	7-D	16	
		17	OPERATOR STEP PB				
		21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.2				
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:				
			SP STEP				
			V-243/V-244				
			PH RANGE TIME				
			13/41 (30 MIN) 9.9 9.3-10.0 9:45A				
			14/47 (60 MIN) 9.9 9.3-10.0 9:45A				
			15/48 (2 HRS) 9.9 9.3-10.0 10:45A				
			16/49 (3 HRS) 9.9 9.3-10.0 11:45P				
			17/50 (FINAL) 7.7 7.5-8.5 12:30P				
			NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NO				
			IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5				
			& RECORD: PH ASS 77%			27-D	
302	28		RUN 31" (379 G) WATER INTO V-302				
6	29		ADD & STIR 5 MIN	D	ASSUME 50%	124	7-D 62
		30	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.				
		31	SIFT IN	✓ 150	128-A	150	
SV		32	SP STEP 23/53				
		33	RECORD: PH 9.5 (3.3-3.7) & IF NECESSARY ADJ			15-A	
			(DOWN ONLY) TO 3.3-3.7 & RECORD: PH				
			NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140				
			*F IN DRUM, USE 30 GAL WATER TO 50%				
			N-15-A. STIR SV 5 MIN AFTER EACH ADDITION				
SP		34	RUN IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5				
			MIN				
7		35	RECORD: PH 4.2 (4.2-4.4). 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)				
		36	OPERATOR STEP PB				
		37	SP STEP 24/54 - ADD & STIR 5 MIN	✓ 20	978-A	20	
		38	OPERATOR STEP PB				
		39	SP STEP 60. BATCH COMPLETE. Pumped → V-240				
		START	FINISH	OPTR			
		TIME SP STEP	TIME SP STEP				
		10:00P	11:00PM	235			
		11:00P	7:00A	223			
		7:00A	1:15P	254-54			
		TIME SP STEP	TIME SP STEP				

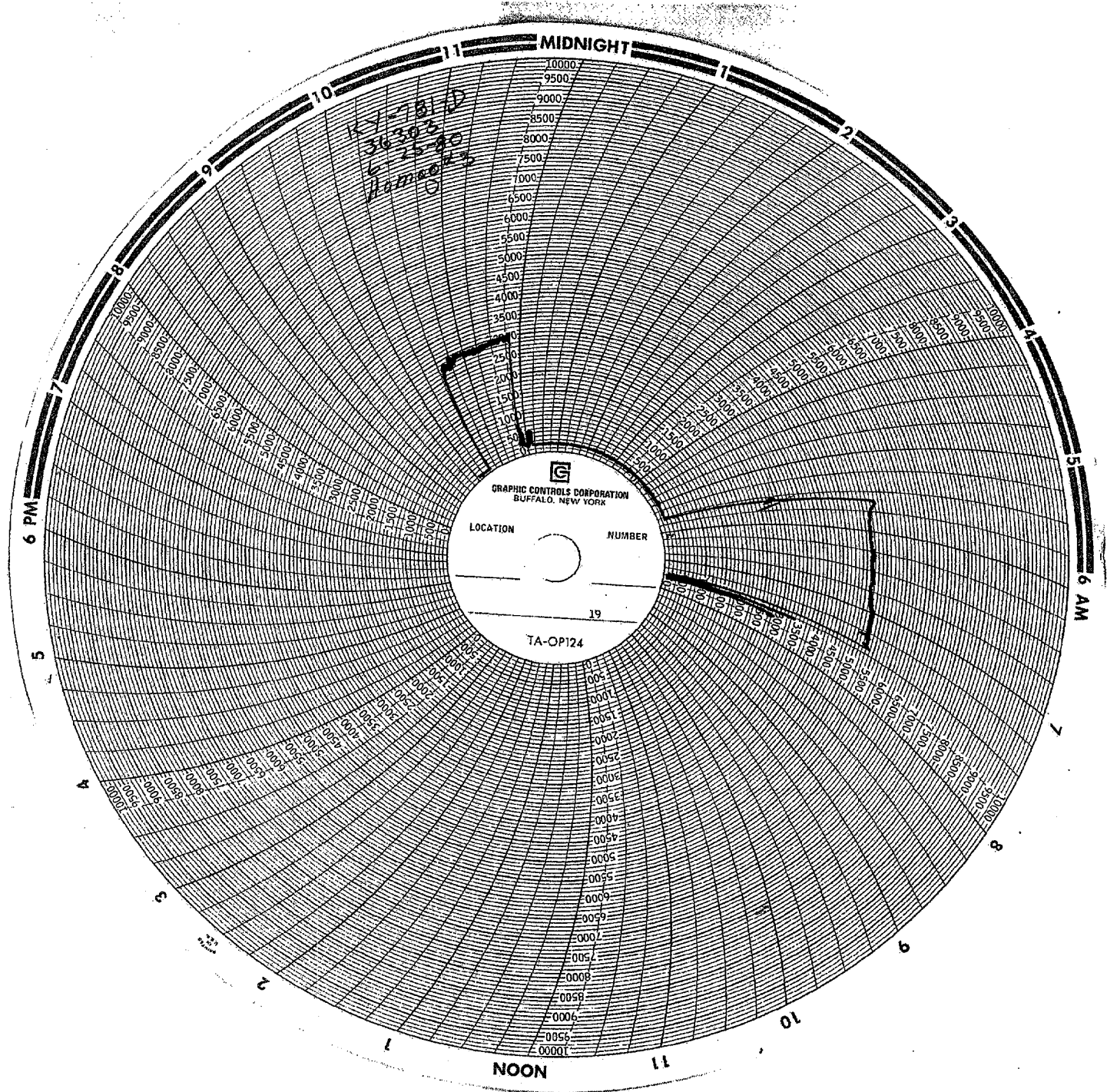


N32231.01

DUP050457188







N32231.02

DUP050457191

V-12113