

(AUTOMATED) MAY 1 - 1980
S.V. 243 C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-795-D PKG
LOT APR 28 35540

PROCESSES APPROVED BY
() KY-795-D (H) FWP 4/23/80

EST'D WGT ~~440~~ 880 LBS

STANDARD HRS. 8.2 TIME 7 P M

TYPED BY: FWP 4/23/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	24775	93	500	14	YC002B		93	
14	YC002B	24845	93	3000	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

HOMO #3 - 1ST Pass
APR 29 80

TOTAL EST'D WGT ~~4012~~ 4340

NON-BLEEDING

EQUIP	NAME	USE	N-	ACCT
		LBS	CODE	LBS
203 & 205	NAME : "KROLOR" YELLOW MEDIUM			
1	4 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
2	12 WEIGH IN DRUM & POUR IN	475	32-D	475
3	13 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
4	RECORD: START 12.00	500		
5	FIN 1.30	3000		
6	ADJUST TO 75" (1275 G)	3500		
7	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
8	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
9	RECORD: V-205 VOL 44" & ADJ TO 60" (2100 G)			
10	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	7 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
2	RECORD: TIME START 4.30 AM			
3	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)			
3	13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 53% PRESET #1 104 GAL		15-A	208
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: BFC10 (N-27-D CONTROLLER) IN MANUAL 0.77 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM 3FR10 (N-27-D/WATER) RATIO 0.8 BFC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM BFR10 (N-32-D/WATER) RATIO 1.0		27-D	296
			32-D	2675
				1885

N32440

V-243

QUIP PAGE 2 CG 03 KY-795-D EST WGT 4412#

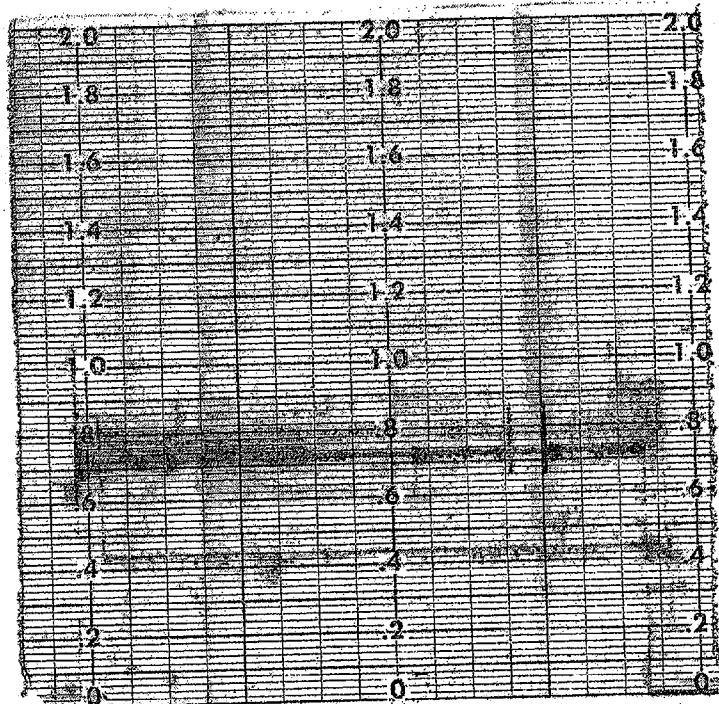
USE N- USE
LBS CODE LBS

116	OPERATOR STEP PB				
117	RECORD LEVEL 21.0% IF <35% FOLLOW SOLUTION				
TV	MAKE-UP PROCEDURE FOR N-27-D				
SP	ADJUST SV TO 10" (3495 G)				
CP	RECORD PH 10.5. 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%	30	7-D	15	
120	OPERATOR STEP PB				
121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8				
122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
SP	OPERATOR STEP PB				
124	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				
126	OPERATOR STEP PB				
127	DURING STRIKE RECORD:	9.25A			
	SP STEP				
	V-243/V-244				
	13/46 (30 MIN)	9.45	9.0-10.0	9.55A	
	14/47 (40 MIN)	9.65	9.0-10.0	10.25A	
	15/48 (2 HRS)	9.65	9.0-10.0	11.25A	
	16/49 (3 HRS)	9.65	9.0-10.0	12.25A	
	17/50 (FINAL PH 6.8)	6.8	7.5-8.5	1.10 PM	
	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	WEIGH INTO 55 GAL DRUM	56	7-D	28	
6	FILL WITH WATER & STIR 2 MIN				
130	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.				
SV	SP STEP 23/53 - RECORD: PH 3.3 (3.3-3.7)				
CP	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7				
	RECORD: PH 15-A				
7	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140				
	*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.				
	STIR 5 MIN AFTER EACH ADDITION.				
133	STIR IN	150	128-A	150	
134	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR				
	5 MIN				
135	RECORD: PH 4.0 (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				
44	OPERATOR STEP PB				

START
TIME SP STEP
11:00P
1:00A

FINISH
TIME SP STEP
7:00AM
2:00PM

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