LOT OCT · 6 30 37348

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 11L M

( ) KY-787-D (Q) FWP 9/23/80
( ) ( ) (XOB-17: 25%
( ) ( ) LESS N-32-D
( ) ( ) & 240 MIN
( ) ( ) STRIKE)
TYPED BY: FP 9/23/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	13089	93	------
14	YC002B	13098	93	------
14	YC002B	--------	93	------

CG	CODE	LOT	PQ	LBS
14	YC002B	-------	93	------
14	YC002B	-------	93	------
14	YC002B	-------	93	------

1980

TOTAL EST'D WGT 3332 NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203 & 205 1	1	RUN 60*(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	240	32-D	240
	3	DUMP IN AND STIR 5 MIN LOT	48X50	YC-2-B	2400
		RECORD: START 1AM 13089	2000		
		FIN 2AM 13098	400		
	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 48" & ADJ TO 60* (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 SV 2	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 1:20PM TOTAL MINUTES 120			
		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 3	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
	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:			224
		A. 11LG 59% PRESET #1 112 ~~90~~ GAL		15-A	~~160~~
		B. 13LG 74% PRESET #6 135 GAL		20-A	135
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
		3FR10 (N-27-D/WATER) RATIO 1.35			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		32-D	1376
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.82			

N34947

EQUIP		PAGE 2 CG 03 KY-787-D EST WGT 3332# V-244	USE LBS	N-CODE	USE LBS
	116	OPERATOR STEP PB			
320	117	RECORD LEVEL 2LG 89% IF BELOW 35% FOLLOW SOL'N			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	118	ADJUST SV TO 48" (2470 G)			
CP	119	RECORD PH 9.75 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 11.1 ASSUME 50%	36	7-D	18
	120	OPERATOR STEP PB			
	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7			
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	6:10PM		
	127	DURING STRIKE RECORD:			

SP STEP — V-243/V-244

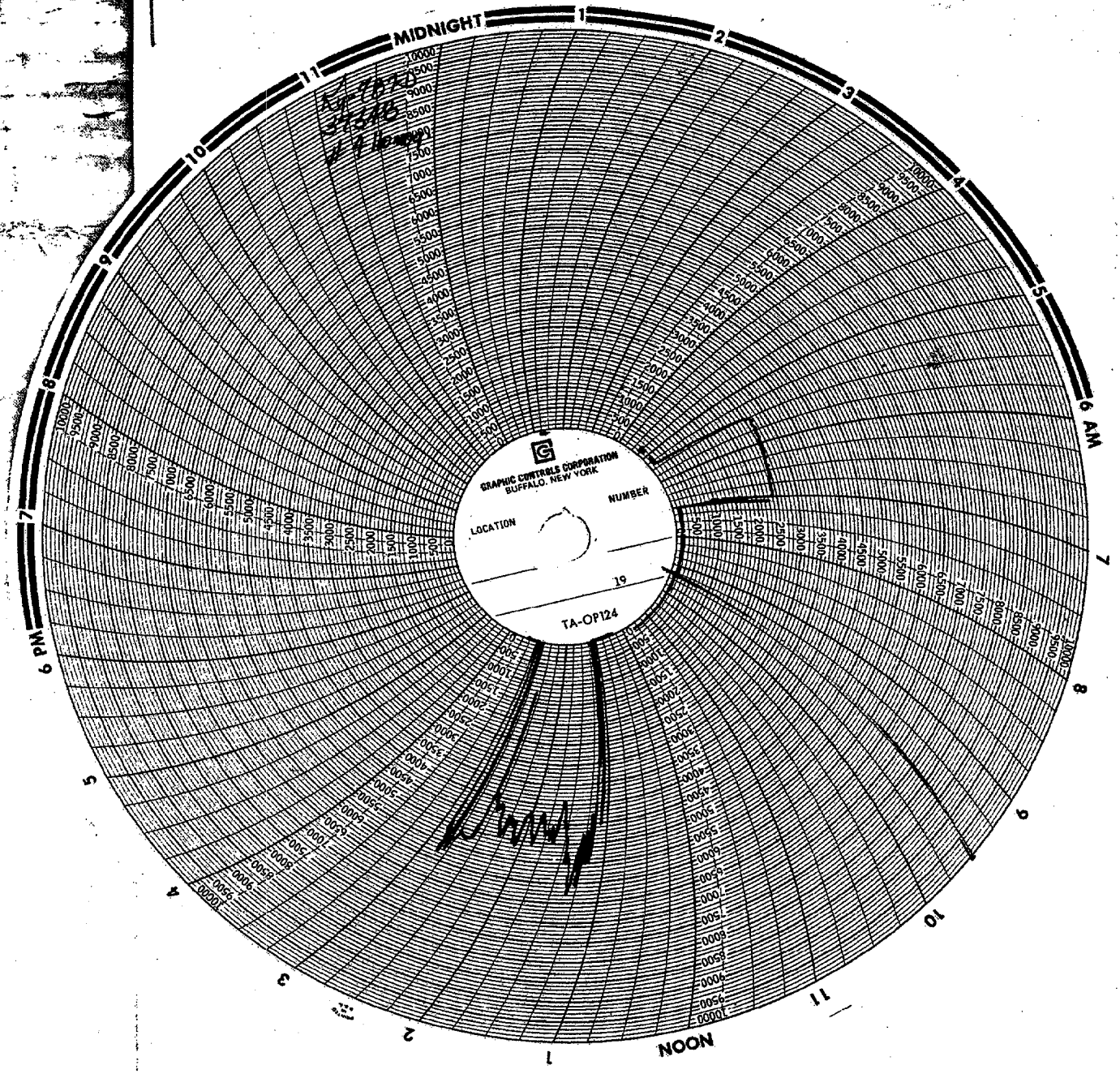
	PH	RANGE	TIME
13/46 (30 MIN)	9.5	9.0-10.0	6:40
14/47 (60 MIN)	9.45	9.0-10.0	7:10
15/48 (2 HRS)	9.4	9.0-10.0	8:10
16/49 (3 HRS)	9.4	9.0-10.0	9:10
16/49 (4 HRS)	9.4	9.0-10.0	10:10
17/50 (FINISH)	7.8	7.5-8.5	10:55

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 10.1 (9.5-10.5)			
	132	STIR 15 MIN OR LONGER FOR SP STEP 26			
	133	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	134	SET PRESET #8 TO 38.2 GAL FROM S 33			
302	135	RUN 30" (360 G) WATER INTO V-302			
7	136	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	160	7-D	80
	137	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	138	SIFT IN	100 ✓	128-A	100
SP	139	SP STEP 23/53. RECORD: PH 4.1 (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 9.1 (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 29/58. RECORD: PH 9.2 & TIME 11:55 PM			
	144	OPERATOR STEP PB			
	145	SP STEP 60. BATCH COMPLETE.			

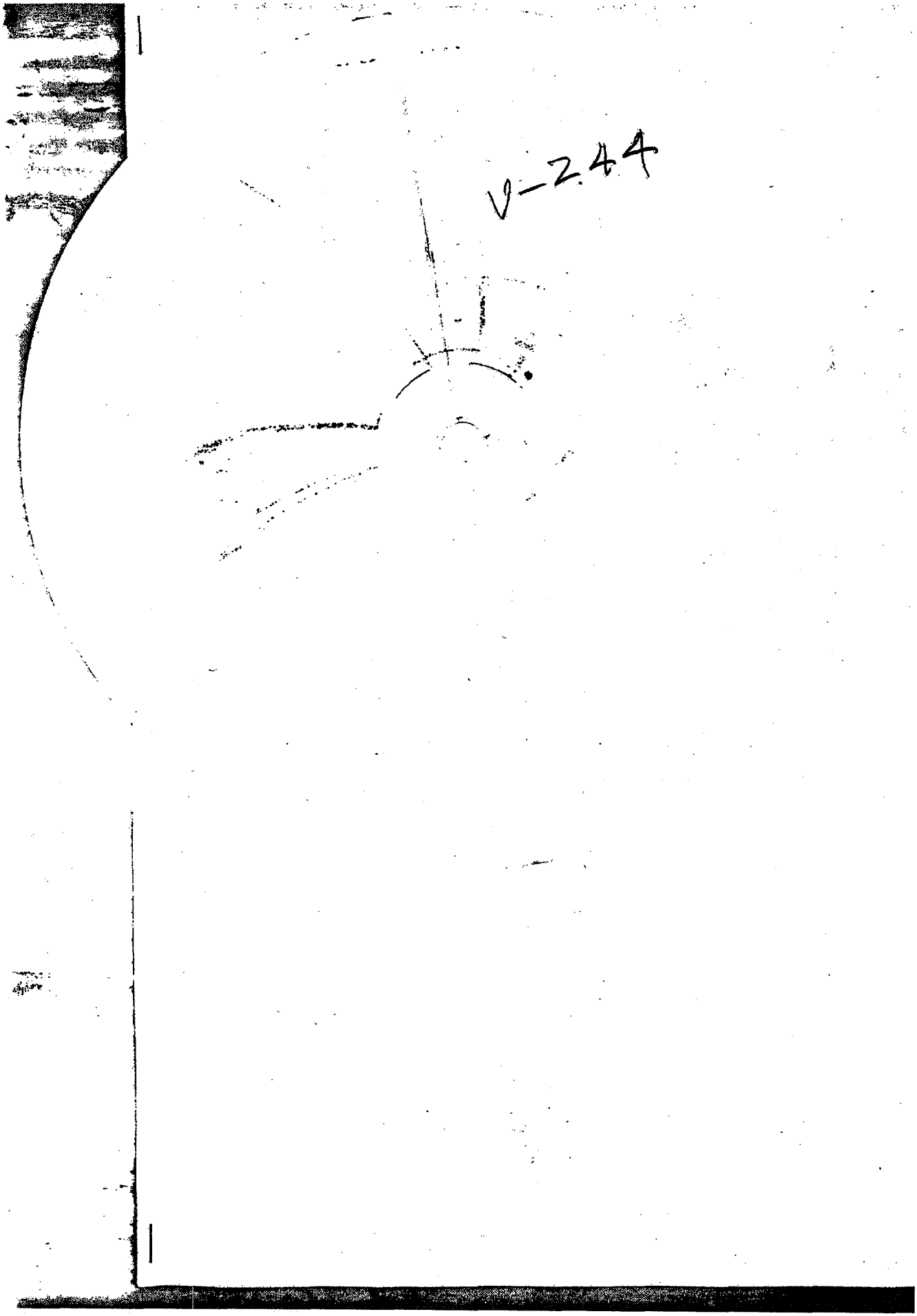
START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
7:00AM	____	3:PM	____	54-120
3:00PM	____	11:00PM	____	235 + 244
11:00PM	____	11:55PM	____	38 223

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DUP050105950

V-244



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