

LOT

001-20 80 37552

OK
H

() KY-795-D (H) FWP 10/14/80
() (XOB-17: 3/4
() N-32-D & 240
() MIN STRIKE)
()

STANDARD HRS. 8.2 TIME 3P M

TYPED BY: FWP 10/14/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13170	93	3500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

Homog #4 - 2nd Pass

TOTAL EST'D WGT 4380

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ADCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON			
	& HIGH SPEED.			
203	2 WEIGH IN DRUM & POUR IN	475	32-D	475
V-263	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
	RECORD: START 6 ³⁰ PM			
	FIN 8 PM			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	HOMOG AT 2400-2600 PSI INTO V-203			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
V-263	7 OF HOT WATER AT 2400-2600 PSI INTO V-205			
	8 RECORD: V-205 VOL " & ADJ TO 60" (2100 G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	9 RUN 10" (514 G) WATER INTO V-244 & START			
V-263	AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 5:25/1 TOTAL MINUTES 160			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	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			
&	5 (V-243) OR POSITION 10 (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 44% PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM		27-D	296
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.04			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.48 GPM		32-D	1885
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	3FR20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.59			

N35032

116	OPERATOR STEP PB			
SV 117	RECORD LEVEL 2LG ____% IF <35% FOLLOW SOLUTION			
SP 118	MAKE-UP PROCEDURE FOR N-27-D			
CP 119	ADJUST SV TO 60" (3495 G) 58" (2980 G)			
4 120	RECORD PH ____ ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
	SIPHON INTO SV. RECORD: PH ____ ASSUME 50%		7-D	
120	OPERATOR STEP PB			

SV 121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH ____			
SP 122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
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)	----	9.0-10.0	-----
	14/47 (60 MIN)	----	9.0-10.0	-----
	15/48 (2 HRS)	----	9.0-10.0	-----
	16/49 (3 HRS)	----	9.0-10.0	-----
	17/50 (FINISH)	----	7.5-8.5	-----
	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

DRUM 128	WEIGH INTO 55 GAL DRUM	ASSUME 50%	28 ✓	7-D	28
6 129	FILL WITH WATER & STIR 2 MIN				

SV 130	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SP 131	SP STEP 23/53 - RECORD: PH ____ (3.3-3.7)			
132	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
& 133	RECORD: PH ____		15-A	
CP 134	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7 135	*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A. STIR 5 MIN AFTER EACH ADDITION.			
136	SIFT IN	150 ✓	128-A	150
137	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
138	RECORD: PH ____ (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 S			
139	OPERATOR STEP PB			
140	SP STEP 24/54 - POUR IN & STIR 15 MIN	22 ✓	978-A	22
141	OPERATOR STEP PB			
142	SP STEP 60 - BATCH COMPLETE			
143	OPERATOR STEP PB			

START
TIME SP STEP

FINISH
TIME SP STEP

OPTR

11:00 AM

7:00 AM

34-120

V-244

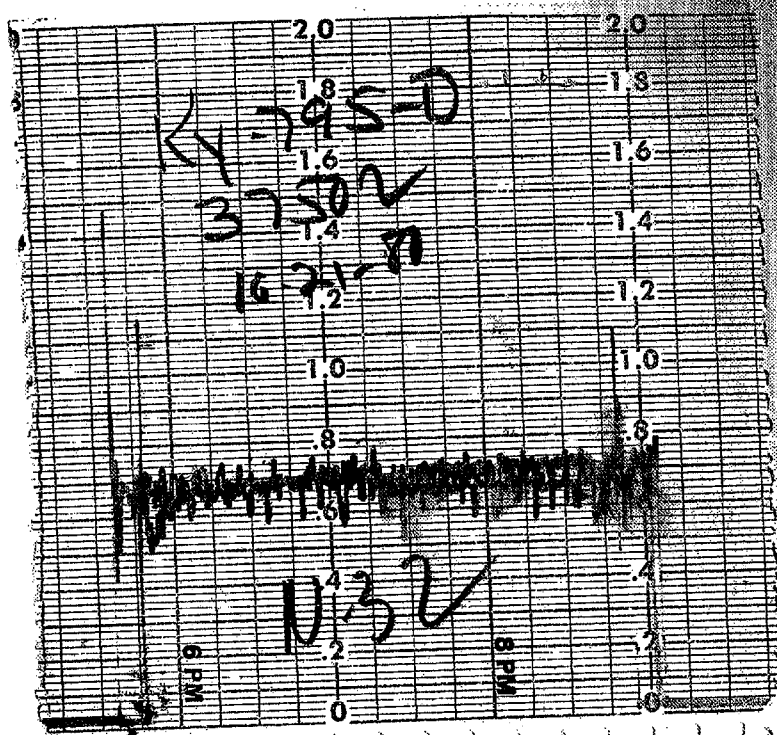
SV	116	OPERATOR STEP PB			
SV	117	RECORD LEVEL 2LG 7.8% IF <35% FOLLOW SOLUTION			
SV	118	MAKE-UP PROCEDURE FOR N-27-D			
SP	118	ADJUST SV TO 58" (2980 G)			
CP	119	RECORD PH 10.2 ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.1	ASSUME 50%	20	720 20
120		OPERATOR STEP PB	FLAKE		

SV	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) 9.65 9.0-10.0 11:05			
		14/47 (60 MIN) 9.6 9.0-10.0 11:35			
		15/48 (2 HRS) 9.5 9.0-10.0 12:35			
		16/49 (3 HRS) 9.5 9.0-10.0 1:35			
		16/49 (4 HRS) 9.5 9.0-10.0 2:35			
		17/50 (FINISH) 7.7 7.5-8.5 3:20			
		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

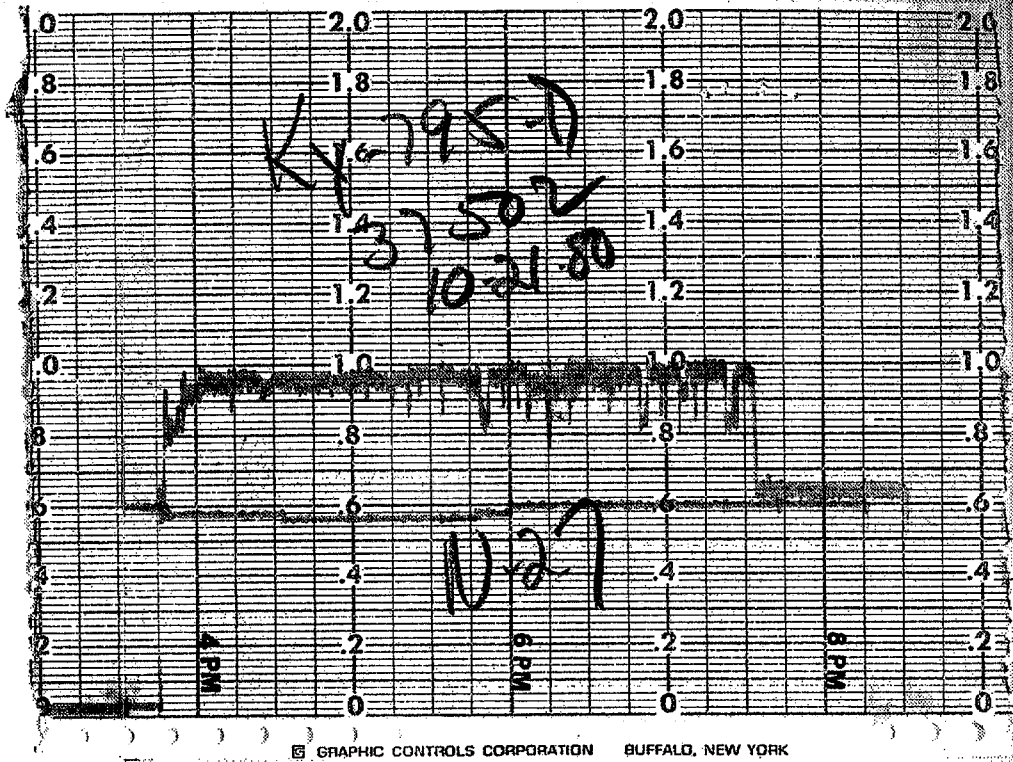
DRUM	128	WEIGH INTO 55 GAL DRUM	ASSUME 50%	54	720 28
6	129	FILL WITH WATER & STIR 2 MIN	FLAKE	28	

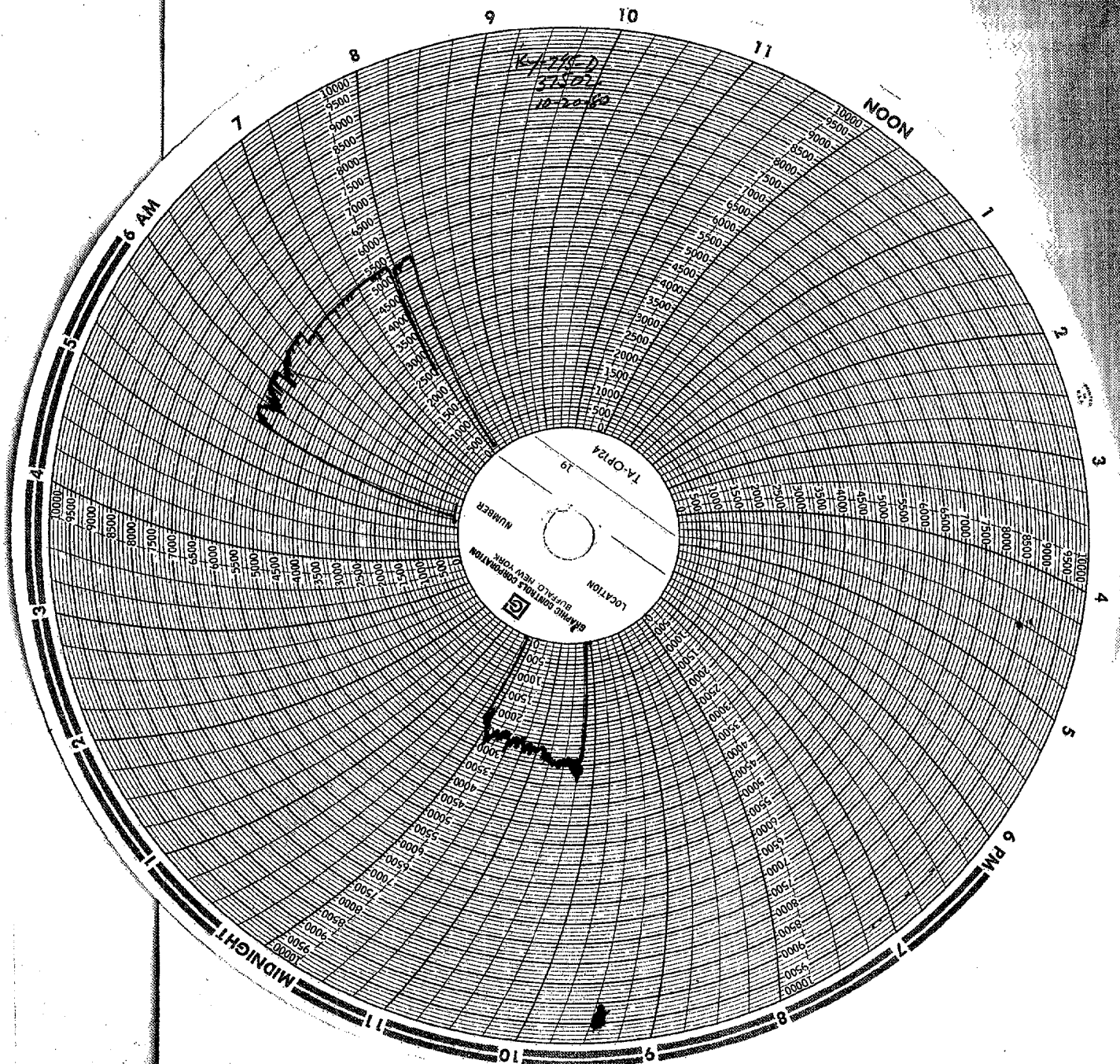
SV	130	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	131	SP STEP 23/53 - RECORD: PH 4.1 (3.3-3.7)			
SP	132	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
&		RECORD: PH 3.6		80	15-A 80
CP		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7		*F IN DRUM. USE 30 GAL WATER TO 50% N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			
133		SIFT IN		150	128-A 150
134		SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
135		RECORD: PH 4.1 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH			
		(DILUTE 10 TO 1 WITH WATER)	ASSUME 77%		27-D
		SIPHON N-7-D INTO SV	ASSUME 50%		7-D
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			
140		OPERATOR STEP PB			

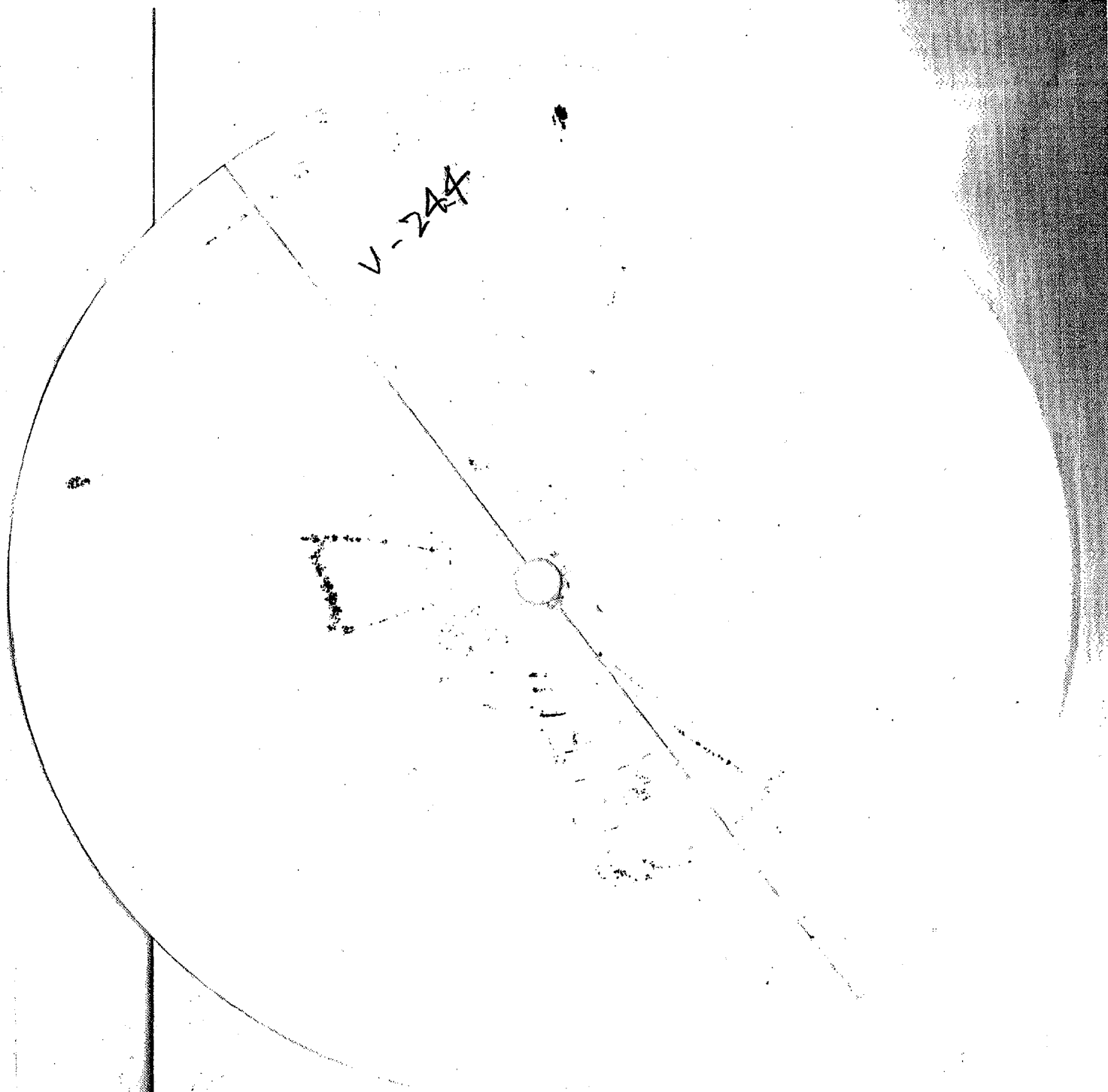
START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
11:00P	7:00A	54-120
7:30A	3:00P	235-244
3:00PM	4:15 PM	381



CONTROLS CORPORATION BUFFALO, NEW YORK







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