

CG 03 CODE KY-787-D PRG

PROCESSES

APPROVED BY

LOT NOV-17 80 37865

() KY-787-D (Q) FWP 11/3/80

() (XOB-17: 25%

EST'D WGT 932 LBS

() LESS N-32-D

() & 240 MIN

STANDARD HRS. 8.9 TIME 11P M

() STRIKE)

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13125	93	2000	14	YC002B		93	
14	YC002B	13185	93	900	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

CLEAN UP
AS YOU GO ALONG

Use only
Fluke Calibration
NON-BLEEDING

TOTAL EST'D WGT 3332

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
	NAME : "KROLOR" YELLOW-MEDIUM			
203	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON			
&	HIGH SPEED.			
205	WEIGH IN DRUM & POUR IN	240	983-D	240
	DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 7:00 PM	2000		
	FIN 7:07 PM	900		
	ADJUST TO 75" (1275 G)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	HOMOG AT 2400-2600 PSI INTO V-205			
	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	OF HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL 45" & ADJ TO 60" (2100 G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-244 & START			
	AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 7:10 PM TOTAL MINUTES 150			
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	SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
&	2 (V-243) OR POSITION 7 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 58% PRESET #1 80 GAL	15-A		160
	B. 13LG 61% PRESET #6 135 GAL	20-A		135
	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	983-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			

EQUIP	PAGE 2	CG 03	KY-787-D	EST WGT 3332#	USE LBS	N- CODE	USE LBS
				V-244			
320	16	OPERATOR STEP PB					
SV	17	RECORD LEVEL 2LG 77% IF BELOW 35% FOLLOW SOL'N					
SP	18	MAKE-UP PROCEDURE FOR N-27-D					
CP	19	ADJUST SV TO 48" (2470 G)					
	19	RECORD PH 10.1 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%	16	724	16	
	20	OPERATOR STEP PB					
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8					
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					
		13/46 (30 MIN)	PH RANGE TIME				
		14/47 (60 MIN)	9.5 9.0-10.0 5:10 PM				
		15/48 (2 HRS)	9.1 9.0-10.0 5:40 AM				
		16/49 (3 HRS)	9.3 9.0-10.0 6:10 PM				
		16/49 (4 HRS)	9.3 9.0-10.0 7:10 PM				
		17/50 (FINISH)	9.1 9.0-10.0 8:40 PM				
			6.9 7.5-8.5 9:25 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	
	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339					
	29	ADD IN 7-8 MIN					
339	30	ADJ TO 49" (382 G) AT 80-100*F		350	530-A	350	
6	31	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)					
	32	STIR 15 MIN OR LONGER FOR SP STEP 26					
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL					
	34	SET PRESET #8 TO 38.2 GAL FROM S 33					
302	135	RUN 30" (360 G) WATER INTO V-302		80	721-D	80	
7	136	ADD & STIR 2 MIN FOR S 40	ASSUME 50%	160	721-D	80	
	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 3.8 (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 9.0 (9.0-9.5). ADJ IF NECESSARY & RECORD: PH	ASSUME 77%				
		(DILUTE 10 PARTS WATER TO 1 PART)	ASSUME 50%				
		(SIPHON N-7-D INTO SV)					
	142	OPERATOR STEP PB					
	143	SP STEP 29/58. RECORD: PH 9.2 & TIME 10:10 AM					
	144	OPERATOR STEP PB					
	145	SP STEP 60. BATCH COMPLETE.					
		START TIME SP STEP	FINISH TIME SP STEP	OPTR			
		3:00 PM	11:00 AM	3.2 244			
		11:00 AM	7:50 PM	342			
		7:00 AM	10:10 AM	38.2 259			



