

CG 03 CODE KY-781-D PKG
LOT F2J24 MAY 27 1982PROCESSES APPROVED BY
() KY-781-D (N) FWP 03/19/82
()

STANDARD HRS. TIME M

JOB NAME: 03KY781DMN

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	D8D15	93	2000	14	YC003B		93	
14	YC003B	19277	93	1300	14	YC003B		93	
14	YC003B		93		14	YC003B		93	

TOTAL EST'D WGT 4233* LBS.

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	N-CODE	ACCT LBS
203	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
205	RUN 60" (990 G) WATER IN V-203 & ADD ASSUME 50% SET AGITATOR ON HIGH SPEED.	36	7-D	18
205	WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	442	32-D	442
1	RECORD: START <u>1:00</u> FIN <u>2:30</u>	66X50	YC-3-B	3300
4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
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 <u>45</u> & ADJ TO 45" (1662 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>12:58</u> TOTAL MINUTES <u>150</u>			
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	SP STEP 01 - SET FORMULA SELECTOR TO POSITION (V-243) OR POSITION 6 (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 <u>44</u> PRESET #3 70 GAL			
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: BFC10 (N-27-D CONTROLLER) IN MANUAL 0.90 GPM BFC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM BFR10 (N-27-D/WATER) RATIO 0.7 BFC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM BFC20 (N-32-D WATER) IN REMOTE			
			115-A	374
			27-D	373
			32-D	2527

JUN 1 1982

4261

16 OPERATOR STEP PB
 17 RECORD LEVEL 2LG **92%** IF (35% FOLLOW SOLUTION
 SV MAKE-UP PROCEDURE FOR N-27-D
 SP 18 ADJUST SV TO 54" (2800 G)
 CP 19 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 SIPHON INTO SV. RECORD: PH **11.6** ASSUME 50% **40** 7-D **20**
 20 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

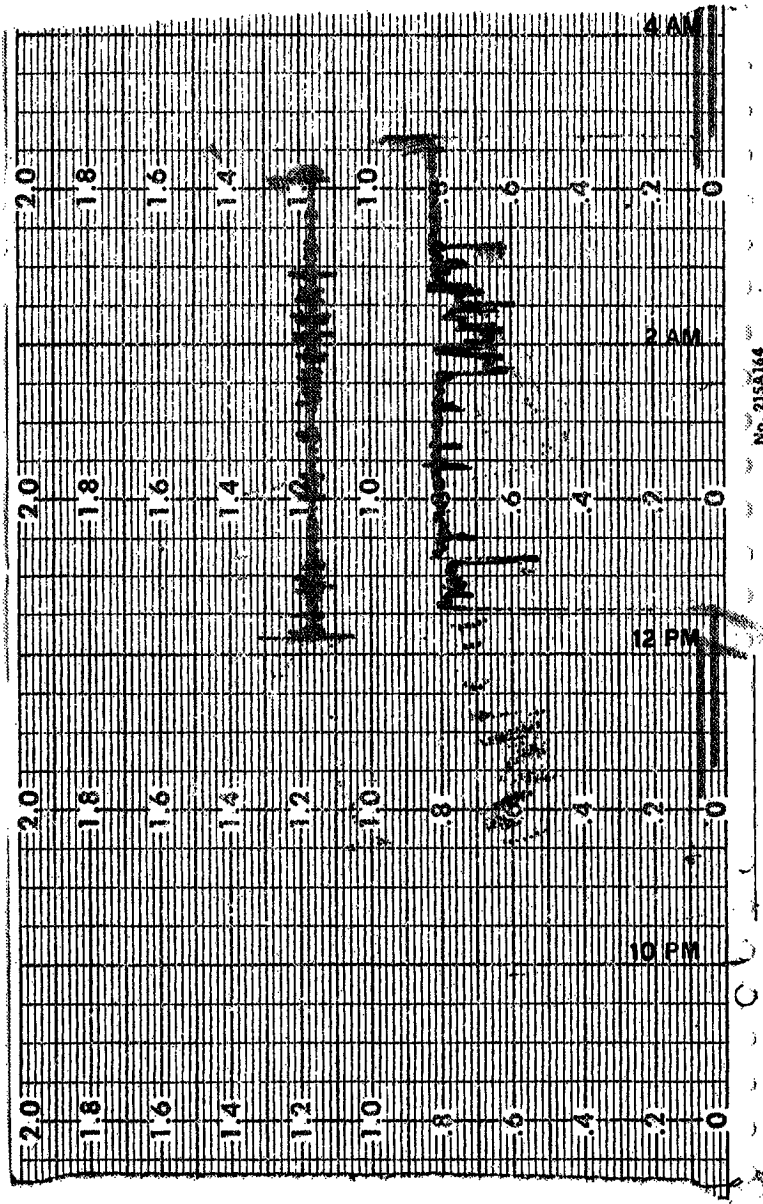
	PH	RANGE	TIME
13/41 (30 MIN)	9.8	9.3-10.0	5:30
14/47 (60 MIN)	9.8	9.3-10.0	6:00
15/48 (2 HRS)	9.7	9.3-10.0	7:00
16/49 (3 HRS)	9.7	9.3-10.0	8:00
17/50 (FINAL)	6.4	7.5-8.5	8:45 PM

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

385 28 RUN 49" (379 G) WATER INTO V-385
 6 29 ADD & STIR 5 MIN **D** ASSUME 50% **124** 7-D **62**

30 SP STEP 17/50 AFTER CHECKING PH, OPERATOR FB.
 SV 31 SIFT IN **165** 128-A **165**
 32 SP STEP 23/53
 33 RECORD: PH **3.2** (3.3-3.7) & IF NECESSARY ADJ
 (DOWN ONLY) TO 3.3-3.7 & RECORD: PH _____ 15-A
 NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
 BADGER METER. STIR 5 MIN AFTER EACH
 ADDITION. ASSUME 50% 115-A
 SP 34 RUN IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5
 MIN
 7 35 RECORD: PH **3.7** (4.2-4.4). ADJ IF NECESSARY &
 RECORD: PH **4.4** ASSUME 77% **27-D** **3**
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% **6/4** 7-D **32**
 (SIPHON N-7-D INTO SV)
 36 OPERATOR STEP PB
 37 SP STEP 24/54 - ADD & STIR 5 MIN **40** 978-A **40**
 38 OPERATOR STEP PB
 39 SP STEP 60. BATCH COMPLETE.

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
1:30 A	7:00 A	259-301
17:15 PM	8:00 PM	381144
3:00	9:50 PM	320-342



No. 215A164