(AUTOMATED) MAKING INSTRUCTIONS BATCH UNIT

S.V. 243, 244 C.V. D.V.

CG 03 CODE KY-787-D PKG

LOT JUN1880 3610

EST'D WGT 1090 LBS

STANDARD HRS. 8.9 TIME 3P M

OK AP

PROCESSES APPROVED BY

( ) KY-787-D (Q) FWP 5/20/80

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TYPED BY: FP 5/20/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	24789	93	2000
14	YC002B	24772	93	400
14	YC002B			

PUNCHED & CHECKED

JUN 2 1980

CG	CODE	LOT	PQ	LBS
14	YC002B	24789	93	2000
14	YC002B	24772	93	400
14	YC002B		93	

(2)

Homog #4 — 2nd Pass

TOTAL EST'D WGT 3490 NON-BLEEDING

EQUIP		NAME : 'KROLOR' YELLOW-MEDIUM	USE LBS	N-CODE	ACC LBS
203 & 205	1	RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	320	32-D	320
	3	DUMP IN AND STIR 5 MIN LOT	48X50	YC-2-B	240
1		RECORD: START 1030 AM 24789	2000		
		FIN 130 PM 24772	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 40" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 3:30 PM TOTAL MINUTES 265			
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 & CP	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)			
3	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
		A. 11LG 50 % PRESET #1 80 GAL		15-A	160
		B. 13LG 44 % PRESET #6 135 GAL		20-A	135
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM		27-D	275
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
		3FR10 (N-27-D/WATER) RATIO 0.64			
		3FC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM		32-D	184
		3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
		3FC20 (N-32-D WATER) IN REMOTE			
		3FR10 (N-32-D/WATER) RATIO 0.83			

EQUIP		PAGE [illegible]	USE LBS	N-CODE	USE LBS
		V-243			
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 90% IF BELOW 35% FOLLOW SOL'N			
SV		MAKE-UP PROCEDURE FOR V-27-D			
SP	18	ADJUST SV TO 40' (2470 G)			
CP	19	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%	26	7-D	13
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
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		9:30 AM	
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.8 9.0-10.0 10:00			
		14/47 (60 MIN) 9.8 9.0-10.0 10:30			
		15/48 (2 HRS) 9.8 9.0-10.0 11:30			
		16/49 (2 HRS, 25 MIN) 9.8 9.0-10.0 11:55			
		17/50 (FINAL 3 HRS) 7.8 7.5-8.5 12:30			
		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	350	530-A	350
339	30	ADJ TO 49" (382 G) AT 80-100*F			
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	35	RUN 30" (360 G) WATER INTO V-302			
7	36	ADD & STIR 2 MIN FOR S 40 ASSUNE 50%	160	7-D	80
	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	38	SIFT IN	100	128-A	100
SV	39	SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)			
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
		MIN			
8	41	RECORD: PH 9.0 (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)			
	42	OPERATOR STEP PB			
	43	SP STEP 29/58. RECORD: PH 9.0 & TIME 1:15 AM			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			
	46	PUMP TO V-240			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
3:30 AM		7 OVR		126-54
9:00 A		1:50 PM		235-320

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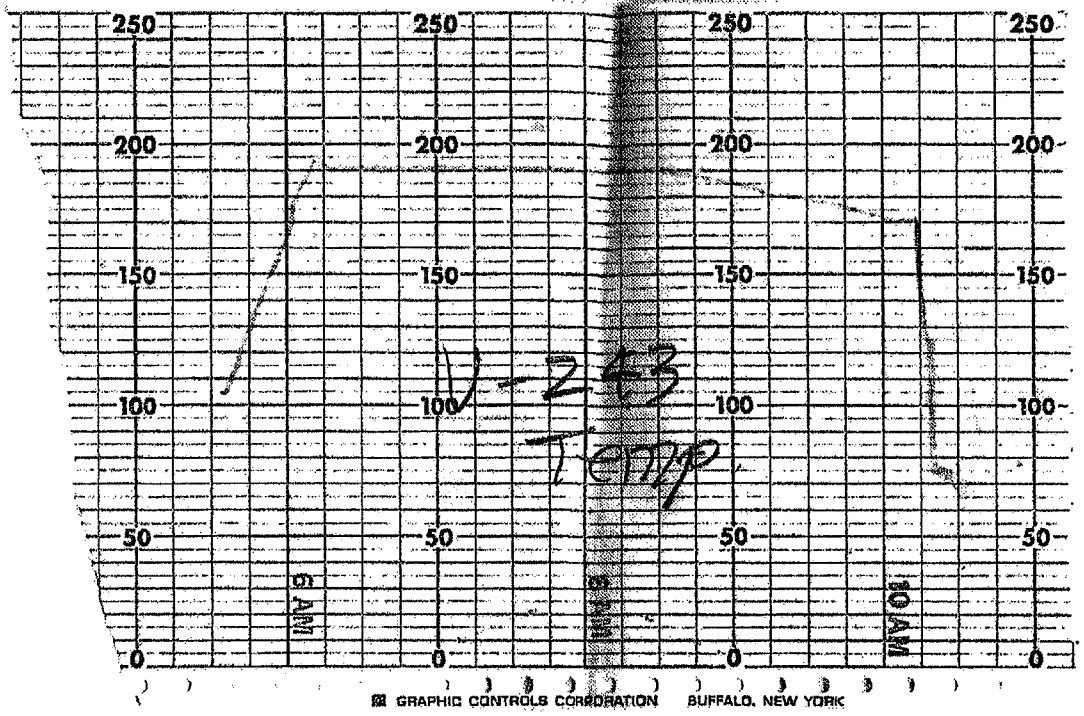

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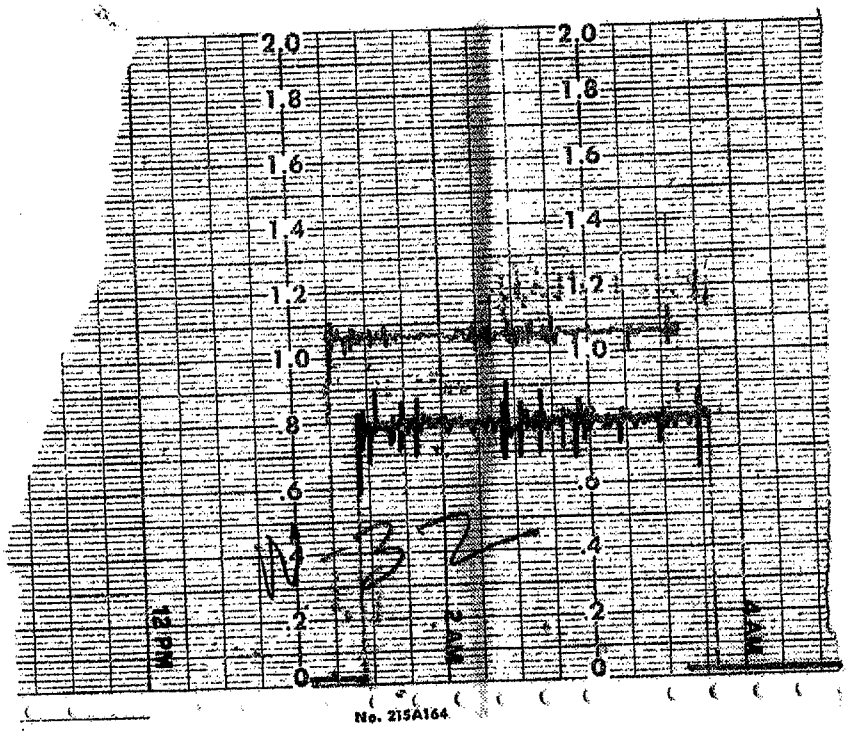

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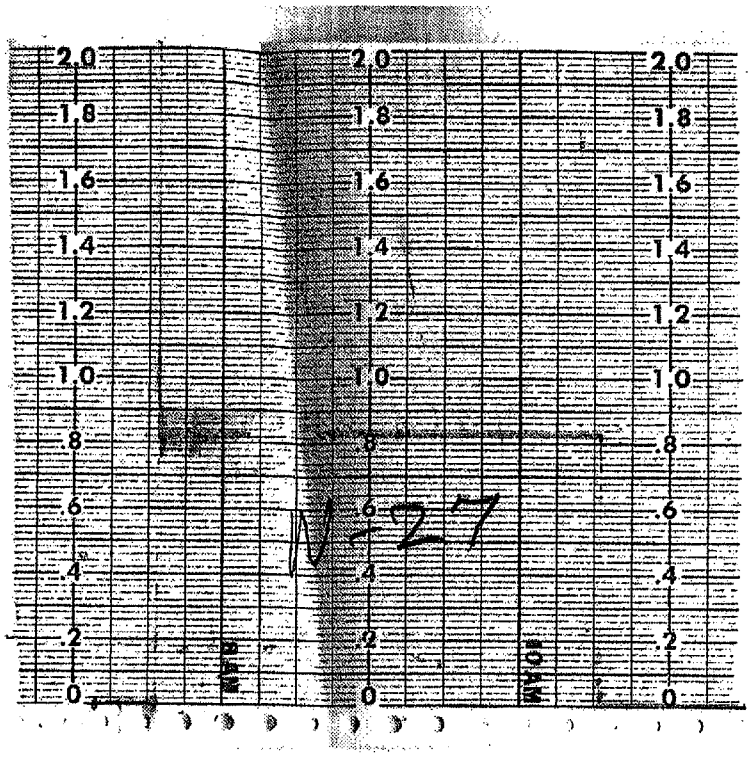
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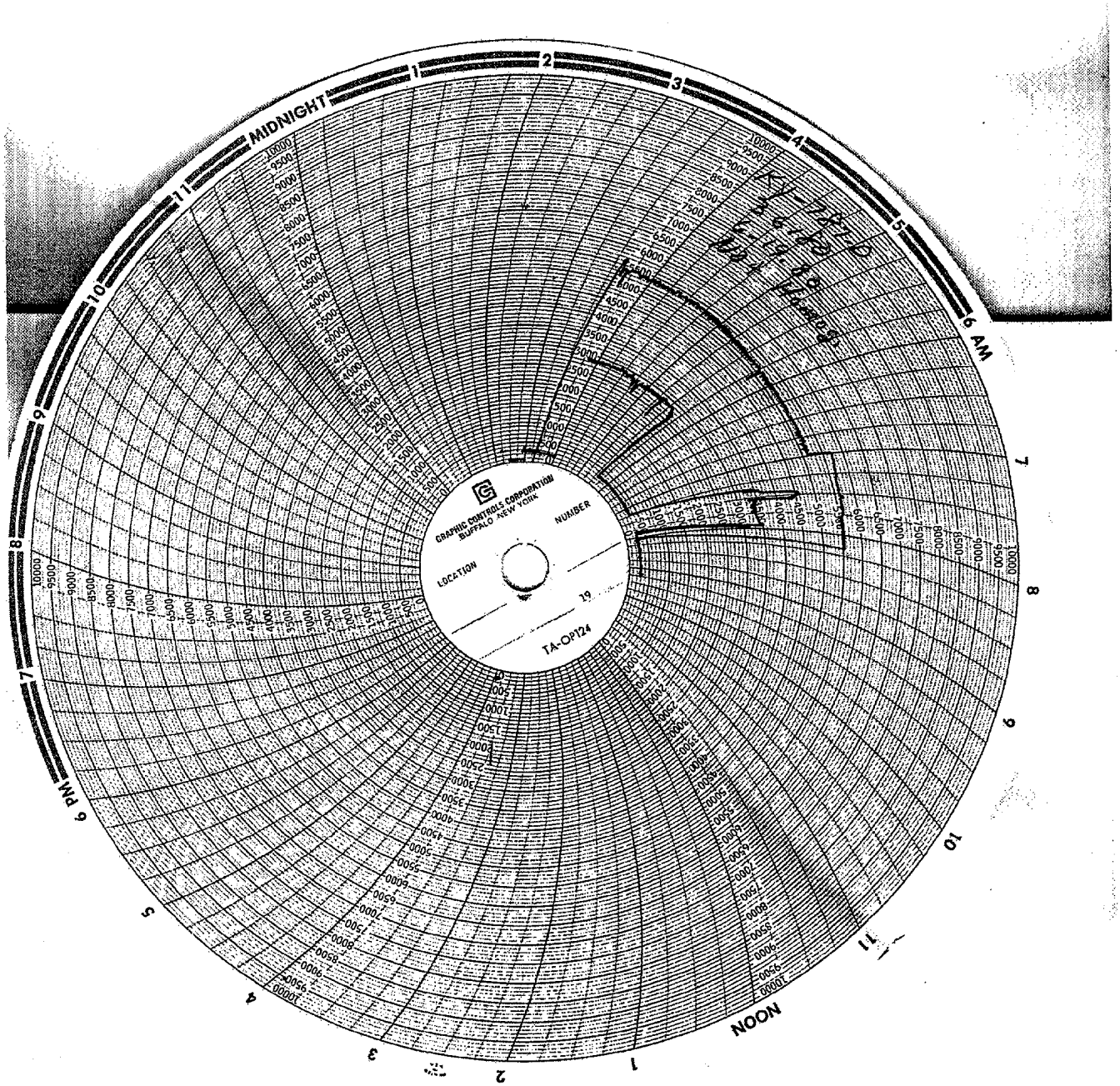

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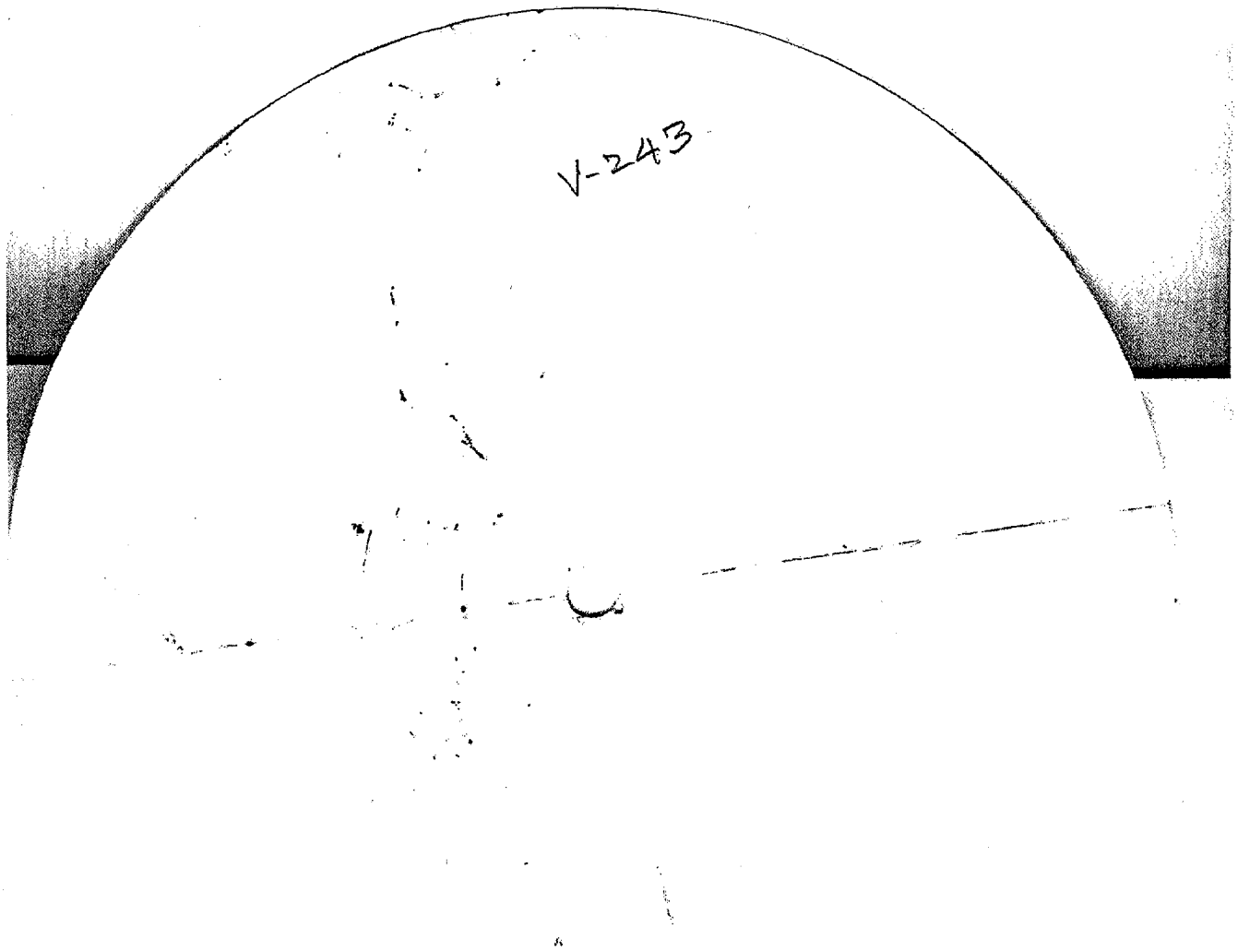

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