

CG 03 CODE KY-788-D PKG

LOT MAY -0.81-E1267

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME ----- M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 5/14/80

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JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	<u>14029</u>	93	<u>2600</u>	14	YC003B	-----	93	-----
14	YC003B	-----	93	-----	14	YC003B	-----	93	-----
14	YC003B	-----	93	-----	14	YC003B	-----	93	-----
03	<u>129781D</u>	<u>82946-1</u>	<u>98</u>	<u>50</u>					

DO NOT USE YC-3-B LOTS 14001 THRU 14004

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME : *KROLOR* YELLOW-LIGHT	USE LBS	N-CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
203	2 WEIGH IN DRUM & POUR IN	345	32-D	345
203	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
203	RECORD: START <u>11:00</u> FIN <u>12:00</u> <u>14029</u>			
203	4 ADJUST TO 75" (1275 G)			
203	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
203	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
203	7 RECORD: V-205 VOL <u>54</u> " & ADJ TO 60" (2100 G)			
203	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	9 RUN 10" (514 G) WATER INTO V-204 & START AGITATOR			
203	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>1:00</u> TOTAL MINUTES <u>140</u>			
203	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
203	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 3 (V-243) OR POSITION 8 (V-244)			
3	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:			
3	A. 14LG 70% PRESET #2 208 GAL		15-A	416
3	B. 13LG 60% PRESET #6 135 GAL		20-A	135
3	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
3	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM		27-D	180
3	3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
3	3FR10 (N-27-D/WATER) RATIO 0.8			
3	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM		32-D	1215
3	8FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
3	8FR10 (N-32-D/WATER) RATIO 1.1			

V. 244

320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 2% IF <35% FOLLOW SOLUTION			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 47" (2400 G)			
	20	RECORD PH 22. ADJ TO 11.0-11.2 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%	32	7-D	16
	20	OPERATOR STEP PB			

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8			
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	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			
		13/46 (30 MIN) 9.6 9.3-10.0 3:45			
		14/47 (60 MIN) 9.6 9.3-10.0 4:15			
		15/48 (2 HRS) 9.5 9.3-10.0 5:15			
		16/49 (2 HRS, 25 MIN) 9.5 9.3-10.0 5:40			
		17/50 (FINAL 3 HRS) 7.9 7.5-8.5 6:15			
		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	

3:15 PM

	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 9.0 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
	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 40" (440 G) WATER INTO V-302			
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180

	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 3.4 (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 9.35 (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. RECORD: PH 9.35 TIME 7:30 PM			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START
TIME SP STEP
2:00P
2:00A
3:00P

FINISH
TIME SP STEP
7:30P
3:00P
7:30P

OPTR
282312
126-259
233-244