

S.V. 4000 (AUTOMATED)

DATE PRINTED: 6/25/82

CG 03 CODE KY-787-D PKG

PROCESSES APPROVED BY
() KY-787-D (T) FWP 06/25/82

JUL 22, 1982

G2J41

3404*

COMTYP JOB NAME: 03KY787DHT

(DATE) (LOT) (EST WGT)

LOCATN	CG	CODE	PR	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
		<u>YC-2-B</u>		<u>4571</u>	<u>2000</u>	XX.XX				
		<u>11</u>		<u>13489</u>	<u>500</u>	XX.XX				
						XX.XX				
						XX.XX				
						XX.XX				

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203 & 205	*BEFORE USING SV, MAKE SURE THAT N-20-D LINE IF ANY IS BLANKED OFF. 1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED. 2 WEIGH IN DRUM & POUR IN 3 DUMP IN AND STIR 5 MIN 4 RECORD: START <u>3:45 PM</u> LOT <u>4571</u> 5 FIN <u>4:11 PM</u> <u>13489</u> 6 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. 7 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 8 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205 9 RECORD: V-205 VOL <u>58</u> " & ADJ TO 60" (2100 G) 10 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY	250	32-D	250
205	1 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR 2 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. 3 RECORD: TIME START <u>2:01 PM</u> TOTAL MINUTES <u>130</u> 4 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205 5 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV	50X50	YC-2-B	2500

SP	CP	STEP	DESCRIPTION	DATE	USE LBS	N-CODE	ACCT LBS
12		1	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)	JUL 26 1982			
13		2	PRESS SV CAM RESET PB - SET 22 TO IN AUTO				
14		3	REMOTE (TEMP IS SET AT 190-194°F)				
15		4	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:				
			A. 11LG <u>26%</u> PRESET #1 32 GAL		115-D		168
			B. 13LG <u>46%</u> PRESET #6 141 GAL		20-A		141
		5	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:				
			3PC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM		27-D		213
			3PC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM				
			3PR10 (N-27-D/WATER) RATIO 1.31				
			3PC10 (N-32-D CONTROLLER) IN MANUAL .84 GPM		32-D		1425
			3PC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM				
			3PC20 (N-32-D WATER) IN REMOTE				
			3PR10 (N-32-D/WATER) RATIO 1.76				

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EQUIP PAGE 2 CG 03 KY-787-D V-240 USE N- USE
MENT: LBS CODE LBS

116 OPERATOR STEP PB
320 117 RECORD LEVEL 2LG 9.0% IF BELOW 35% FOLLOW SOL'N
SV 118 MAKE-UP PROCEDURE FOR N-27-D
SP 119 ADJUST SV TO 48" (2470 G)
CP 120 RECORD PH 9.8. ADJ TO 11.1-11.3 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 121 SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50% 40 7-D 20
122 OPERATOR STEP PB

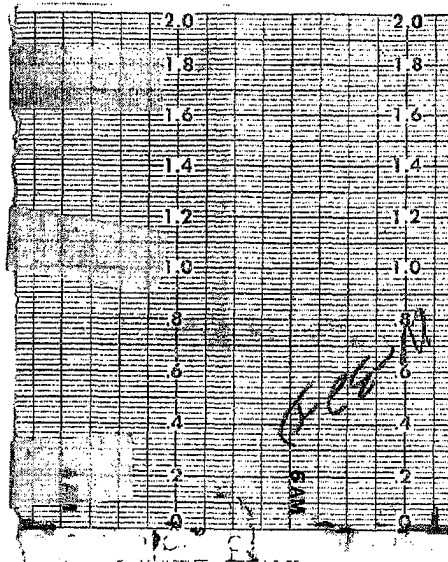
123 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9.
SV 124 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 125 OPERATOR STEP PB
126 SP STEP 16/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 127 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
128 OPERATOR STEP PB
129 DURING STRIKE RECORD:
SP STEP
V-243/V-244
PH RANGE TIME
13/46 (30 MIN) 9.5 9.0-10.0 7.30
14/47 (60 MIN) 9.4 9.0-10.0 8.00
15/48 (2 HRS) 9.5 9.0-10.0 9.00
16/49 (2 HRS, 25 MIN) 9.5 9.0-10.0 9.25
17/50 (FINAL 3 HRS) 8.5 7.5-8.5 10.00
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

128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
129 ADD IN 7-8 MIN. CHECK FOR DRAFT IN VENT STACK 365 530-A 365
BEFORE DUMPING.
339 130 ADJ TO 49" (382 G) AT 80-100°F
6 131 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
132 STIR 15 MIN OR LONGER FOR SP STEP 26
133 RECORD: VOL 44" & CALC 44" X 0.78 38.2 GAL
134 SET PRESET #8 TO 38.2 GAL FROM S 33

385 135 RUN 47" (340 G) WATER INTO V-385
7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

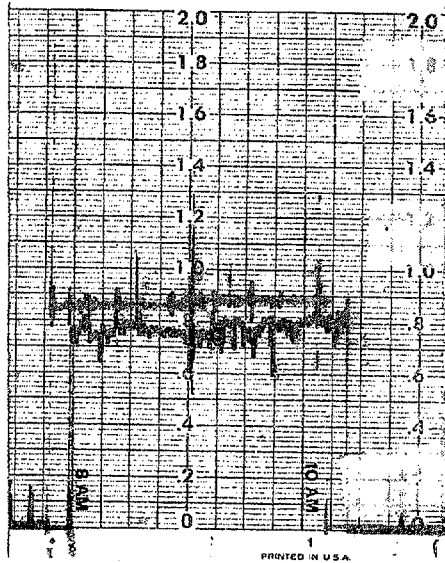
137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
138 SIFT IN 110 12B-A 110
SV 139 SP STEP 23/53. RECORD: PH 3.3 (3.7-4.2)
SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
8 141 RECORD: PH 9.9 (9.0-9.5). ADJ IF NECESSARY &
RECORD: PH 9.0 ASSUME 77% 3 27-D 3
(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 7-D
(SIPHON N-7-D INTO SV)
142 OPERATOR STEP PB
143 SP STEP 29/58. RECORD: PH & TIME
144 OPERATOR STEP PB
145 SP STEP 60. BATCH COMPLETE.

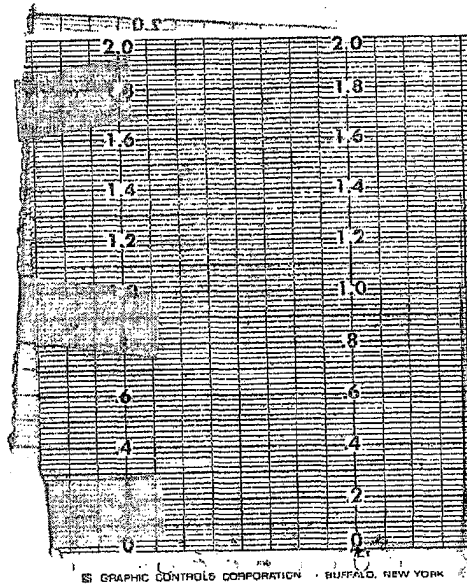
START FINISH OPTR
TIME SP STEP TIME SP STEP
3:00 11:00 54-114

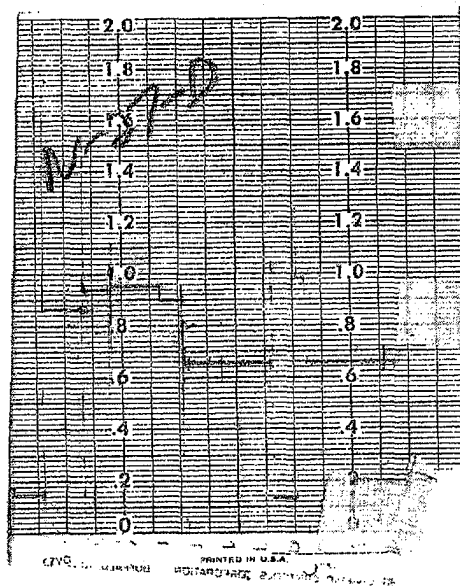


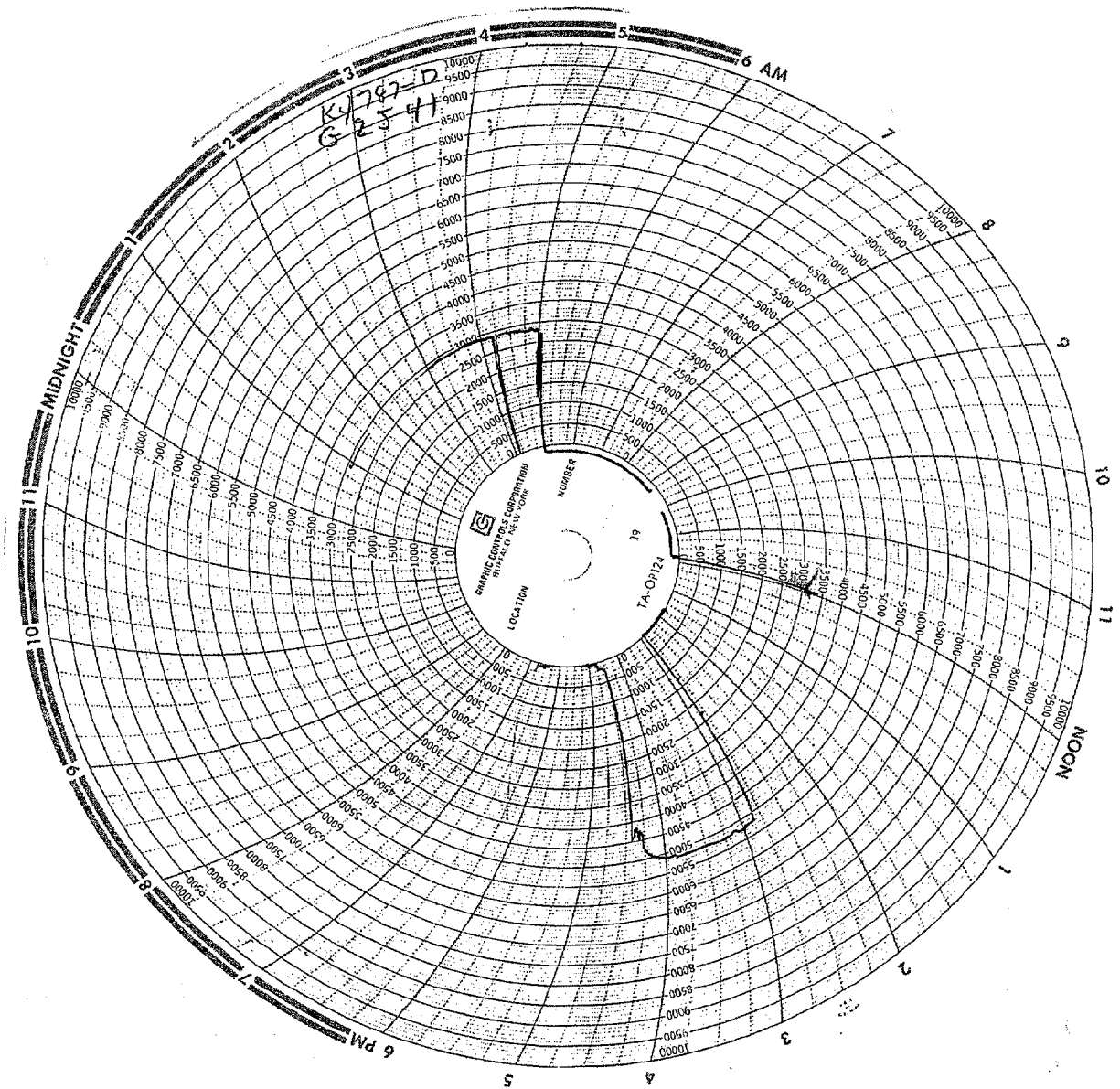
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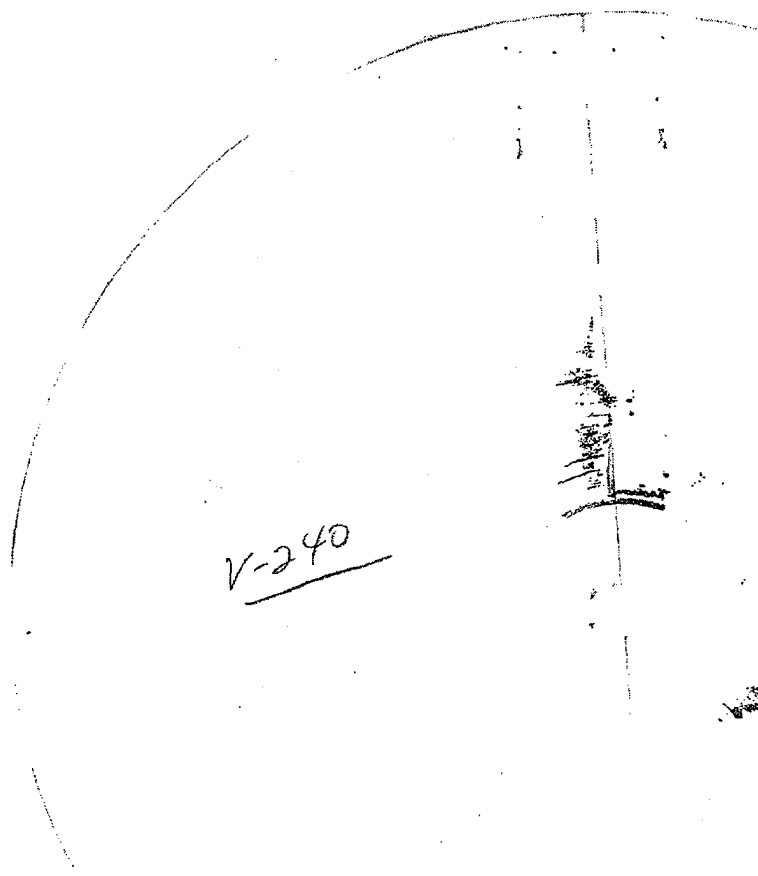






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V-240