

CG 03 CODE KY-788-D PKG

LOT 14 0-81-21028

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 01/16/81

() () 4 HOUR STRIKE

() () AS FOR XOB-17

() ()

JOB NAME: XOB17:788J

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	14012	93	2000	14	YC003B		93	
14	YC003B	13020	93	400	14	YC003B		93	
14	YC003B		93		14	YC003B		93	

(3/4)

Homog #4-1ST RUN

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	345	32-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
1	RECORD: START 1:00			
	FIN 5:00			
	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			
	RECORD: V-205 VOL 41" & ADJ TO 60" (2100 G)			
	7 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	8 RUN 10" (514 G) WATER INTO V-205 & START			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 7:30 TOTAL MINUTES 7:80			
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			
	3 (V-243) OR POSITION B (V-244)			
13	PRESS SV CAM RESET PB - SET 20 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-190°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 20% PRESET #2 208 GAL		15-A	416
	B. 13LG 35% PRESET #6 135 GAL		20-A	135
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM		27-D	180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.8			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.44 GPM		32-D	1215
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 2.4 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.1			

(3/4)

V-243

116 OPERATOR STEP PB
117 RECORD LEVEL 2LG 74% IF <35% FOLLOW SOLUTION
118 MAKE-UP PROCEDURE FOR N-27-D
119 ADJUST SV TO 47" (2400 G)
120 RECORD PH 9.8 ADJ TO 11.0-11.2 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
121 SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50% 40 7-D 20
122 OPERATOR STEP PB

121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0
122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
123 OPERATOR STEP PB 11:20 P
124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
126 OPERATOR STEP PB
127 DURING STRIKE RECORD:
SP STEP

V-243/V-244

13/46 (30 MIN)

14/47 (60 MIN)

15/48 (2 HRS)

16/49 (3 HRS)

16/49 (4 HRS)

17/50 (FINISH)

PH RANGE

TIME

9.8 9.3-10.0

9.7 9.3-10.0

9.7 9.3-10.0

9.7 9.3-10.0

9.5 9.3-10.0

8.3 7.5-8.5

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

350

530-AV 350

130 ADD TO 49" (382 G) AT 80-100°F

131 STIR 5 MIN & RECORD: PH 10.3 (9.5-10.5)

132 STIR 15 MIN OR LONGER FOR SP STEP 26/56

133 RECORD: VOL 49" & CALC 49" X 0.78 = ____ GAL

134 SET PRESET #8 TO 38.2 GAL FROM S 33

135 RUN 40" (440 G) WATER INTO V-302

136 ADD & STIR 2 MIN FOR S 40

ASSUME 50%

360

7-D

180

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.

138 SIFT IN

100

128-AV 100

139 SP STEP 23/53. RECORD: PH 3.4 (3.7-4.2)

140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5

MIN

141 RECORD: PH 9.4 (9.0-9.5). ADJ IF NECESSARY &

RECORD: PH ____ ASSUME 77%

(DILUTE 10 PARTS WATER 1 PART) ASSUME 50%

(SIPHON N-7-D INTO SV)

142 OPERATOR STEP PB

143 SP STEP 29. RECORD: PH 9.3 & TIME 5:00 AM

144 OPERATOR STEP PB

145 SP STEP 60. BATCH COMPLETE.

Pump to V-240

START

TIME SP STEP

7:08.4

FINISH

TIME SP STEP

8:00 P.M.

OPTR

235-244
232-381
400-111