PUNCHED & CHECKED

(AUTOMATED)
S.V. 243, ~~244~~ C.V. JUN 17 80

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-795-D PKG
LOT JUN-11 36079

EST'D WGT 880 LBS 3 PM

STANDARD HRS. 8.2 TIME ~~7 A~~ M

PROCESSES APPROVED BY
( ) KY-795-D (H) FWP 5/1/80
( ) 3/4 N-32-D STRIKE TO
( ) IMPROVE GLOSS
( ) ( )
( ) ( )
TYPED BY: FWP 5/1/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	24786	93	2000	14	YC002B		93	
14	YC002B	24477	93	850	14	YC002B		93	
14	YC002B	24787	93	650	14	YC002B		93	

Homog #4 - 1st Pass
" #4 - 2nd "

TOTAL EST'D WGT 4380 V-243 'M'T' 1:45A NON-BLEEDING

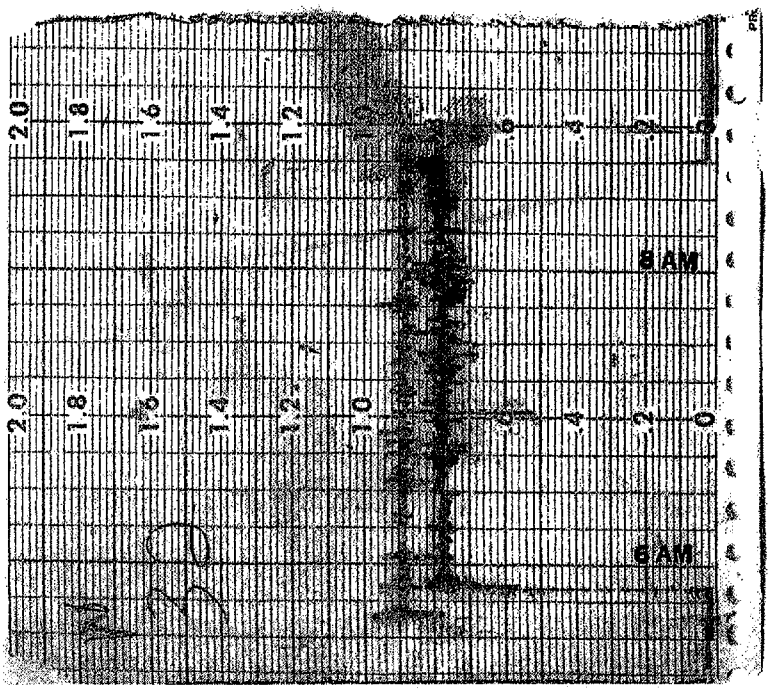
EQUIP		NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N-CODE	ACCT LBS
203 & 205	1	RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	475	32-D	475
	3	DUMP IN AND STIR 5 MIN LOT	70X50	YC-2-B	3500
		RECORD: START 6:15 PM 24786	2000		
1		FIN 7:45 PM 24477	850		
		24787	650		
	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 41 " & 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 1:50A TOTAL MINUTES 135			
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 5 (V-243) OR POSITION 10 (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 45 % PRESET #1 104 GAL		15-A	208
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.71 GPM		27-D	296
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
		3FR10 (N-27-D/WATER) RATIO 0.8			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM		32-D	1885
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.0			

V-243

QUIP		PAGE 2 CG 03 KY-795-D EST WGT 4612#	USE LBS	N-CODE	USE LBS
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 42% IF (35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 68' (3495 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 11.1 ASSUME 50%	36	7-D	18
	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			
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD:		6:40/AM	
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.8 9.0-10.0 7:10			
		14/47 (60 MIN) 9.8 9.0-10.0 7:40			
		15/48 (2 HRS) 9.8 9.0-10.0 8:40			
		16/49 (3 HRS) 9.8 9.0-10.0 9:40			
		17/50 (FINISH) 6.8 7.5-8.5 10:25			
		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	___
RUM	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	56	7-D	28
6	29	FILL WITH WATER & STIR 2 MIN			
	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	31	SP STEP 23/53 - RECORD: PH 3.1 (3.3-3.7)			
SP	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
&		RECORD: PH ___.	___	15-A	___
CP		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7		*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			
	33	SIFT IN	150	128-A	150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR			
		5 MIN			
	35	RECORD: PH 4.0 (4.0-4.2) & IF NECESSARY ADJ TO			
		PH 4.0-4.2 & RECORD: PH ___ ASSUME 77%		27-D	
		(DILUTE 10 TO 1 WITH WATER) ASSUME 50%	34	7-D	17
		SIPHON N-7-D INTO SV			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN &STIR 15 MIN	22	978-A	22
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	44	OPERATOR STEP PB			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
700P		1100P		259-54
11:00P		7:00AM		235-323
7:00AM		11:10AM		223-342

DUP050456331



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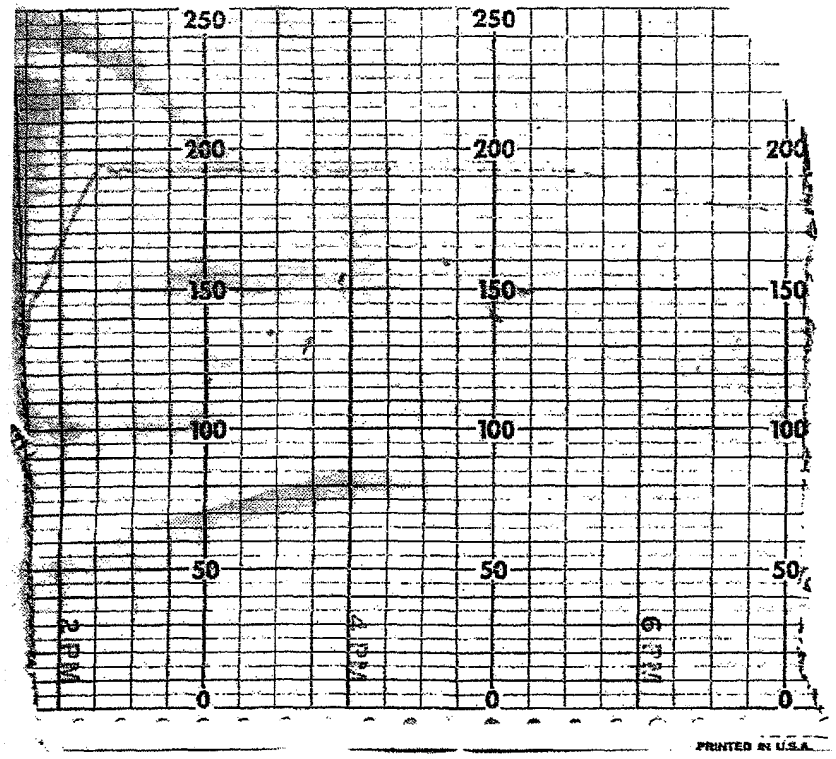

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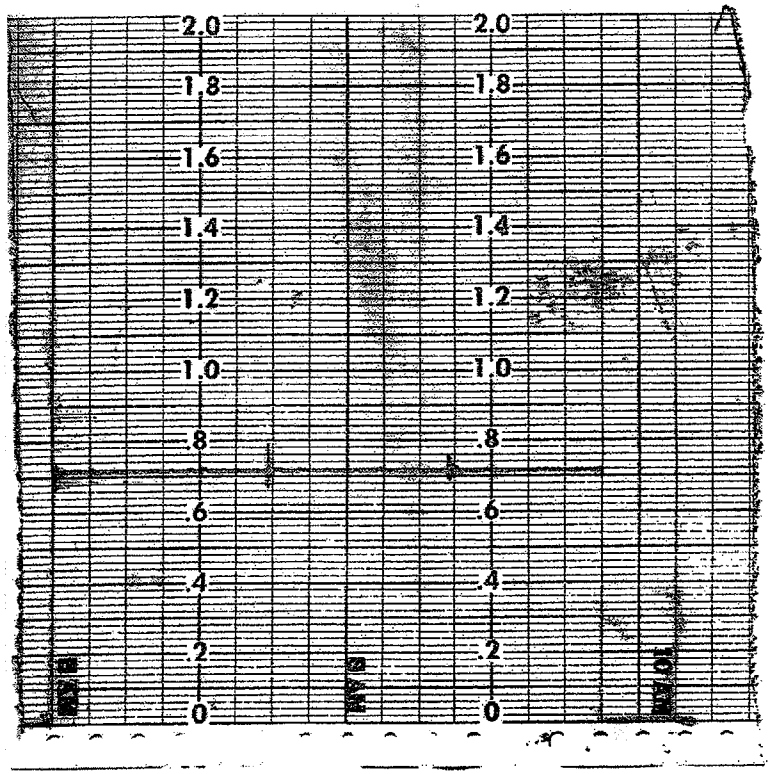

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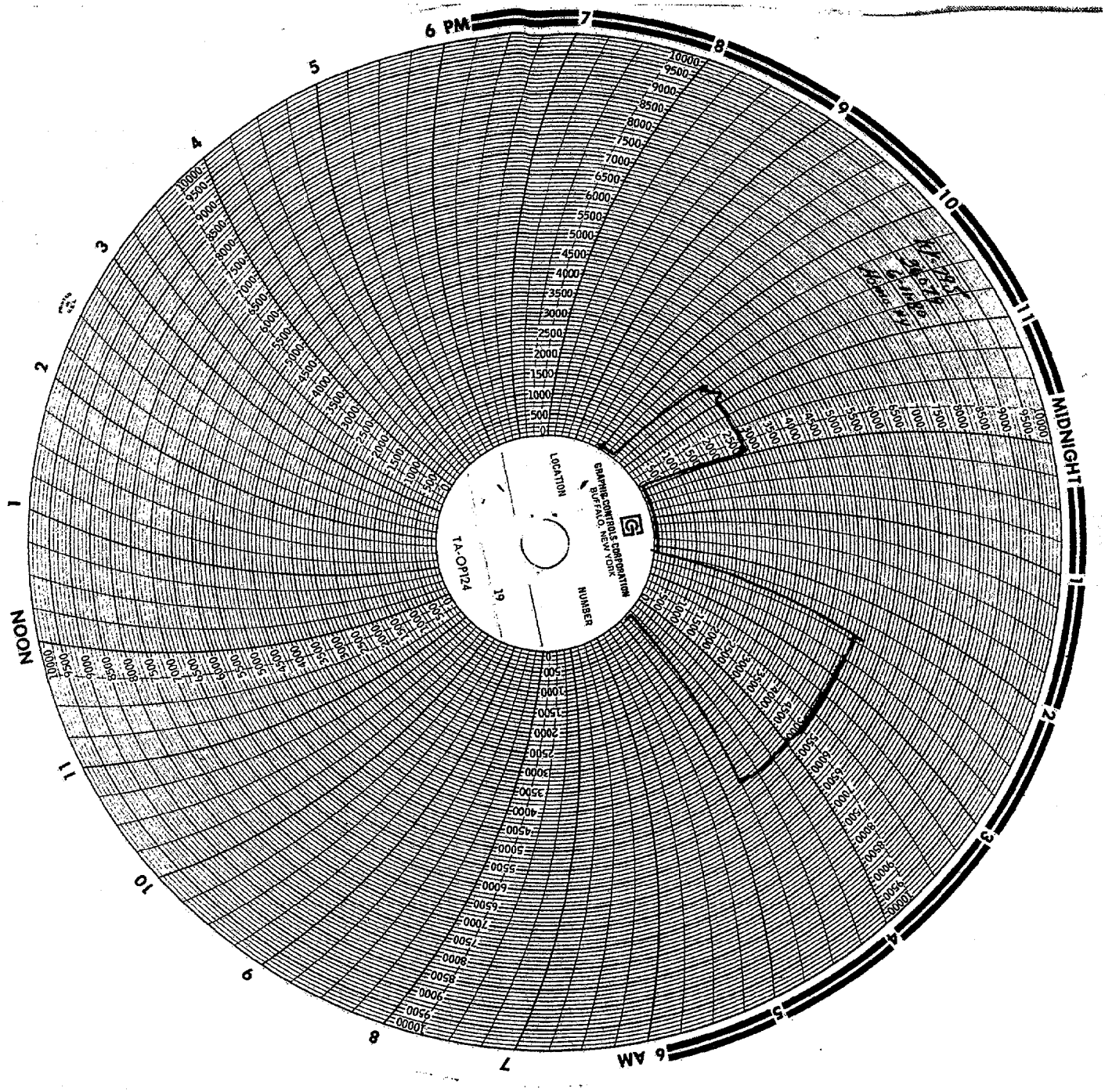

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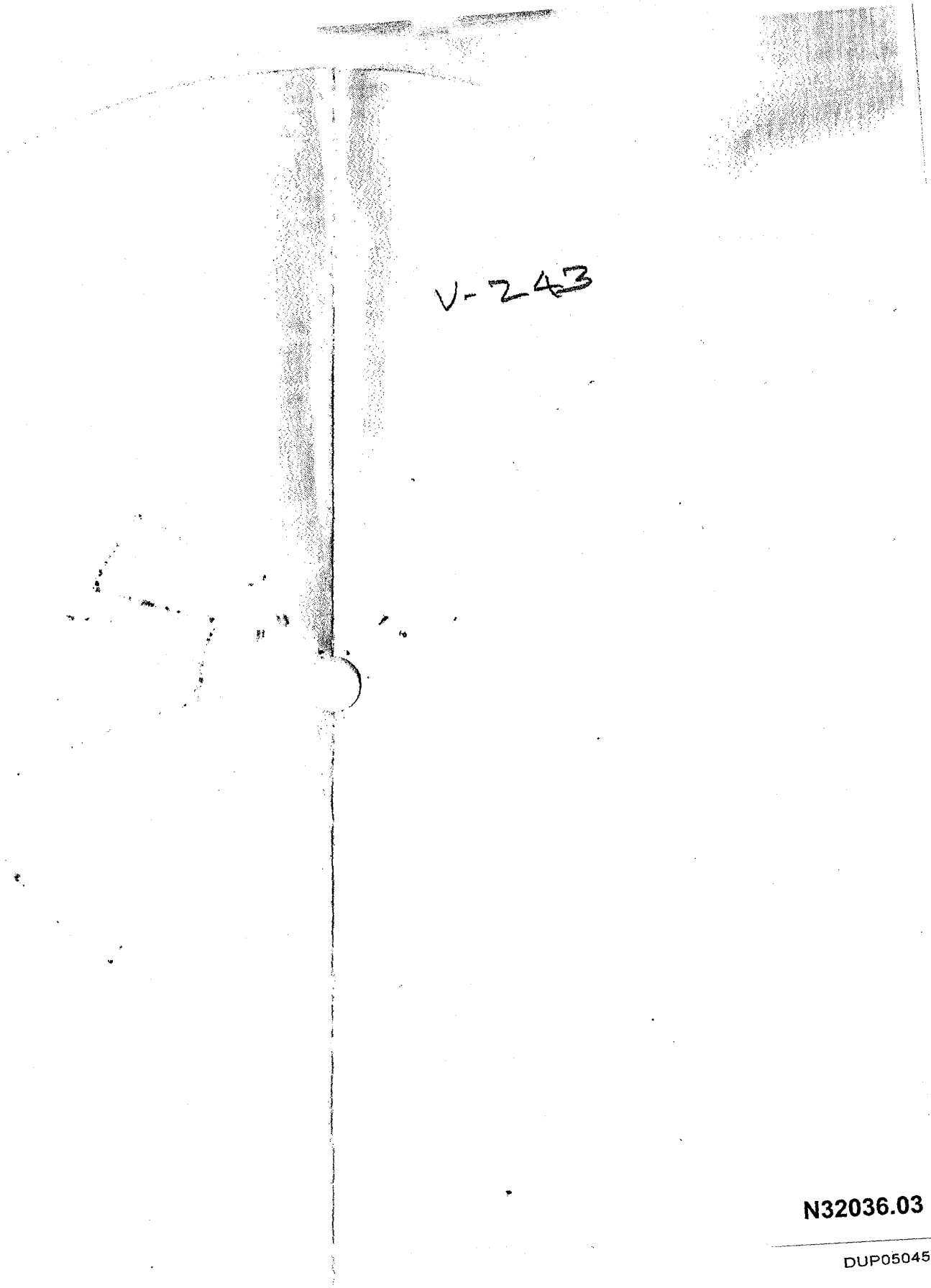

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