

AUTOMATED)

V. 243, 244

C. PUNCHED & CHECKED

MARKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-788-D PKG JUN 30 1980

PROCESSES

APPROVED BY

LOT JUN 24 36301

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

EST'D WGT 960 LBS

STANDARD HRS. 8.8

TIME

TYPED BY: FP 5/14/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC003B	24222	93	2400
14	YC003B		93	
14	YC003B		93	

CG	CODE	LOT	PQ	LBS
14	YC003B		93	
14	YC003B		93	
14	YC003B		93	

Homog #3-151+200 Pass

TOTAL EST'D WGT 3560

JUN 25 1980

NON-BLEEDING

QUIP	NAME	USE LBS	N- CODE	ACCT LBS
03	1. RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
263	2. WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	345	32-D	345
	RECORD: START 8:17	52X50	YC-3-B	2600
	FIN 9:07	2400		
	4. ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	5. WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	7. RECORD: V-263 VOL " & ADJ TO 60" (2100 G)			
	8. INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	9. RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
10	10. PUMP V-203 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:30 PM TOTAL MINUTES 110			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-263			
14	11. WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			

SP 142 SP STEP 01 - SET FORMULA SELECTOR TO POSITION

A 3 (V-243) OR POSITION B (V-244)

SP 143 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 41% PRESET #2 208 GAL

15-A 416

B. 13LG 61% PRESET #6 135 GAL

20-A 135

15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:

3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM

27-D 180

3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM

3FR10 (N-27-D/WATER) RATIO 0.8

3FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM

32-D 1215

3FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM

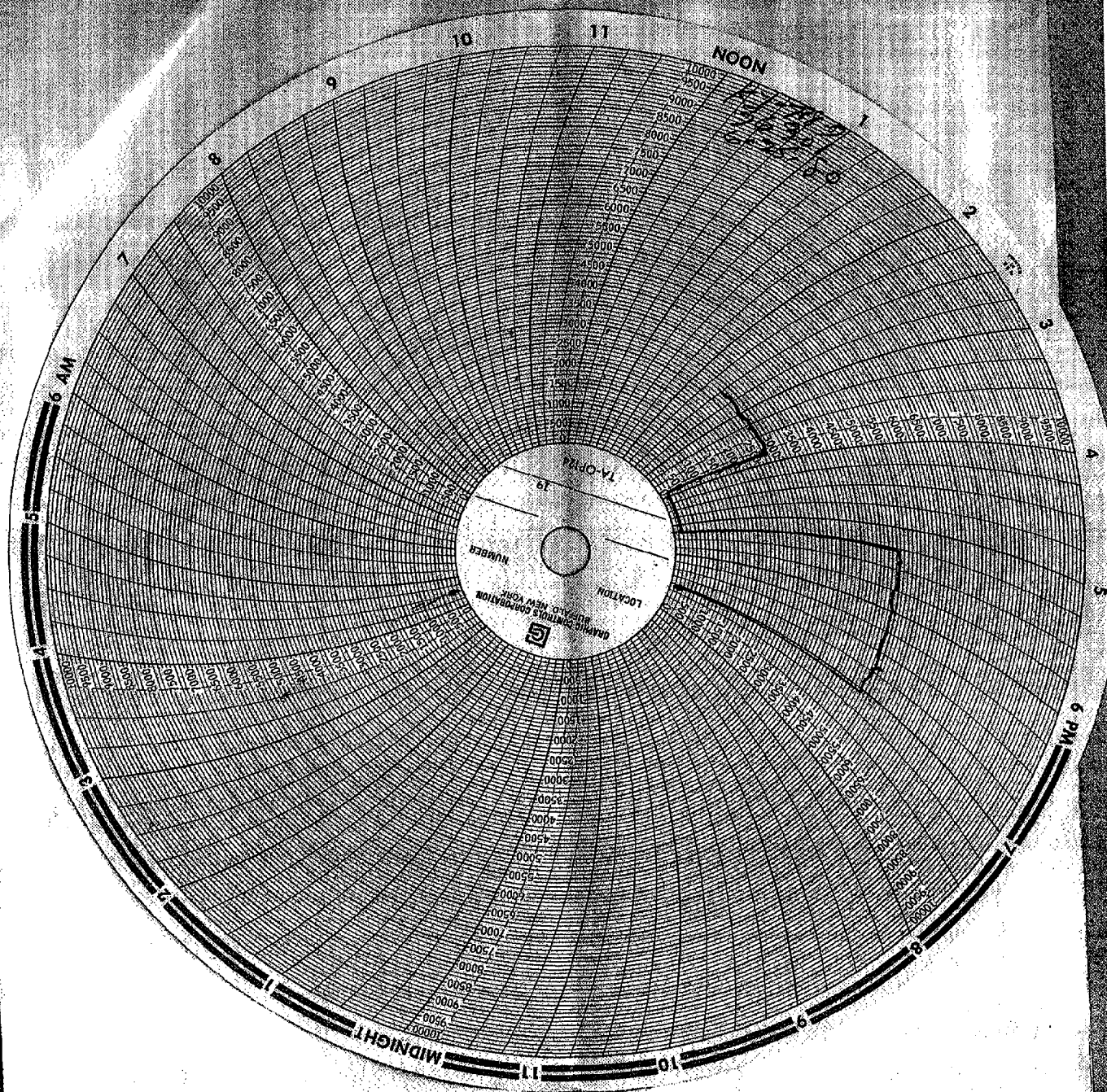
3FC20 (N-32-D WATER) IN REMOTE

3FR10 (N-32-D/WATER) RATIO 1.1

N32220

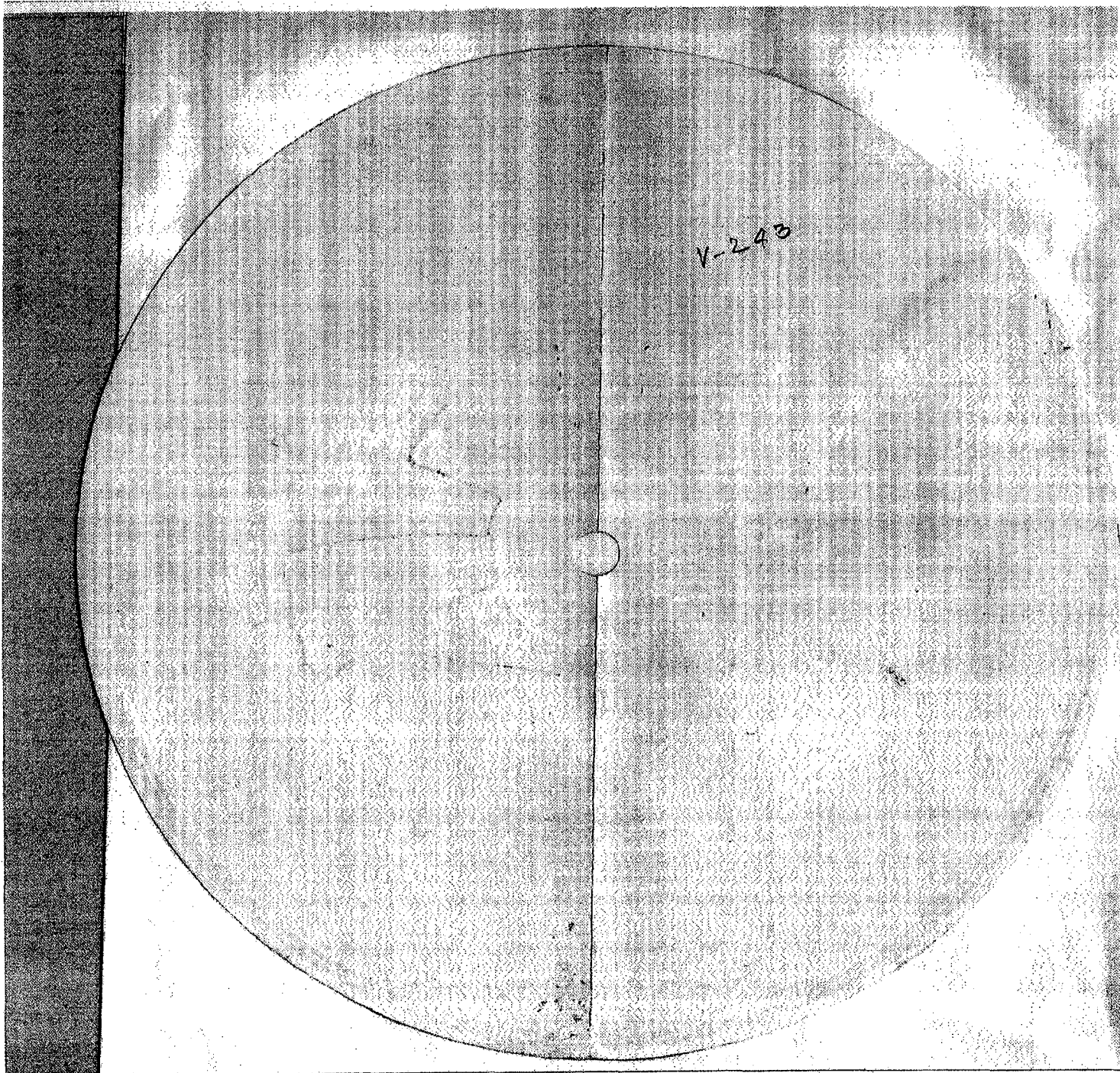
QUIP	PAGE 2	33 03	Y-733-D	EST WGT 3560#	USE LBS	N- CODE	USE LBS
V-243							
320	116	OPERATOR STEP PB					
SV	117	RECORD LEVEL 2LG 42% IF <35% FOLLOW SOLUTION					
SP	118	MAKE-UP PROCEDURE FOR N-27-D					
CP	119	ADJUST SV TO 47" (2400 G)					
	120	RECORD PH 10.2 ADJ TO 11.0-11.2 WITH N-7-D AT					
		5% (10 PARTS WATER TO 1 PART N-7-D)					
4		SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50%			40	7-D	20
	121	OPERATOR STEP PB					
	122	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0					
SV	123	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO					
SP	124	OPERATOR STEP PB					
	125	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS					
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB					
5	126	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN					
		LIMITS, SWITCH 3FC20 TO REMOTE					
	127	OPERATOR STEP PB					
	128	DURING STRIKE RECORD:					
		SP STEP					
		V-243/V-244					
		PH RANGE TIME					
		13/46 (30 MIN) 9.9 9.3-10.0 11:10					
		14/47 (60 MIN) 9.9 9.3-10.0 11:40					
		15/48 (2 HRS) 9.75 9.3-10.0 12:40					
		16/49 (2 HRS, 25 MIN) 9.1 9.3-10.0 1:05					
		17/50 (FINAL 3 HRS) 8.5 7.5-8.5 1:30					
		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	
	129	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339					
	130	ADD IN 7-8 MIN			350	530-A	350
339	131	ADJ TO 49" (202 G) AT 80-100*F					
6	132	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)					
	133	STIR 15 MIN OR LONGER FOR SP STEP 26/56 38.2					
	134	RECORD: VOL 49 & CALC 49 X 0.78 = --- GAL					
	135	SET PRESET #8 TO 38.2 GAL FROM S 33					
302	136	RUN 40" (440 G) WATER INTO V-302					
7	137	ADD & STIR 2 MIN FOR S 40 ASSUME 50%			360	7-D	180
	138	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.					
	139	SIFT IN			100	128-A	100
SV	140	SP STEP 23/53. RECORD: PH 3.3 (3.7-4.2)					
SP	141	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5					
		MIN					
8	142	RECORD: PH 9.2 (9.0-9.5). ADJ IF NECESSARY &					
		RECORD: PH --- ASSUME 77%				27-D	
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%				7-D	
	143	SIPHON N-7-D INTO SV)					
	144	OPERATOR STEP PB					
	145	SP STEP 29. RECORD: PH 9.5 & TIME 3:20 AM					
	146	OPERATOR STEP PB					
	147	SP STEP 60. BATCH COMPLETE.					
4th Pump to 240 VOT							
		START					
		TIME SP STEP					
		3:00 P					
		11:00 P					
		FINISH					
		TIME SP STEP					
		11:00 P					
		3:33 P					
		OPTR					
		235-					
		233-312					

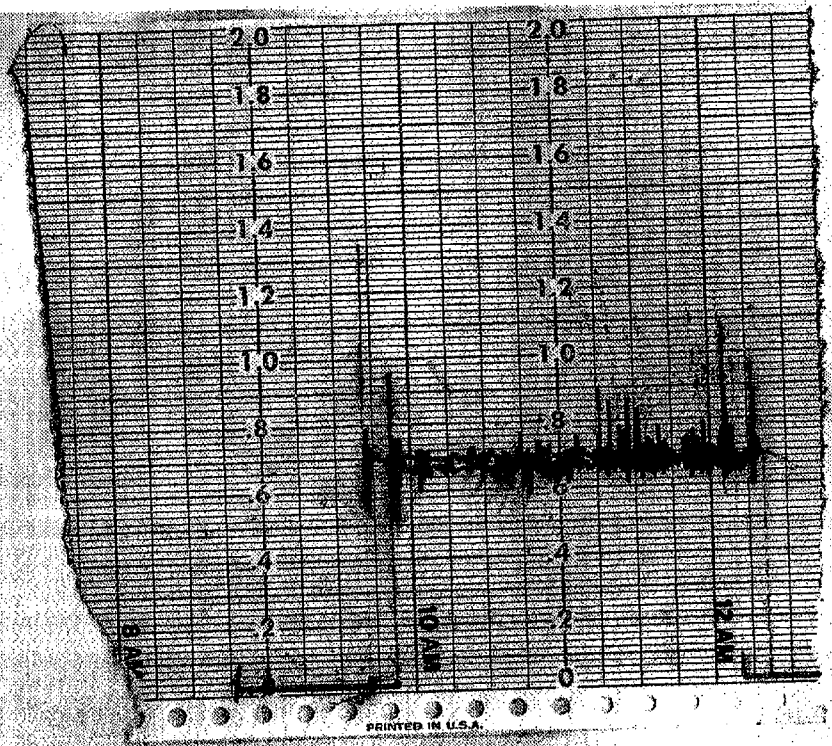
10:40/PM



N32220.01

DUP050457132





N32220.02

DUP050457134

