

CG 03 CODE KY-781-D PKG

PROCESSES

APPROVED BY

LOT

38147x

Dec 4, '80

OK

() KY-781-D (N) FWP 12/05/80

() (XOB-17: 3/4

() N-32-D & 240

() MIN STRIKE)

() ()

STANDARD HRS. 8.2

TIME

M

COMTYP JOB NAME: XOB17:781N

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC003B	13071	93	3500
14	YC003B		93	
14	YC003B		93	

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

Homog 24-1st P, 3
" 8 24-2nd P, 3

TOTAL EST'D WGT 4628

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.			
205	2 WEIGH IN DRUM & POUR IN	485	983-D	485
	3 DUMP IN AND STIR 5 MIN	70X50	YC-3-B	3500
	RECORD: START LOT 13071			
	FIN			
	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 4.3" & 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 10:25A TOTAL MINUTES 165			
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	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 1 (V-243) OR POSITION 6 (V-244)			
CP	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 17% PRESET #1 187 GAL		15-A	374
	145 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	2FD10 (N-27-D CONTROLLER) IN MANUAL 0.71 GPM		27-D	373
	3FD20 (N-27-D WATER) IN MANUAL LOCAL 5.0 GPM			
	3PR10 (N-27-D/WATER) RATIO 0.7			
	3FD10 (N-32-D CONTROLLER) IN MANUAL 0.92 GPM		983-D	2580
	3FD20 (N-32-D WATER) IN MANUAL LOCAL 4.0 GPM			
	3FC20 (N-32-D WATER) IN REMOTE			
	3PR10 (N-32-D/WATER) RATIO 0.9			

V-243

SV	146	OPERATOR STEP PB			
SP	147	RECORD LEVEL 2LG 82% IF <35% FOLLOW SOLUTION			
CP	148	MAKE-UP PROCEDURE FOR N-27-D			
	149	ADJUST SV TO 54" (2800 G)			
	150	RECORD PH 10.2 ADJ TO 11.4-11.6 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.4 ASSUME 50%	50	7-D	25
	151	OPERATOR STEP PB			

SV	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
SP	122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	123	OPERATOR STEP PB			
	124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	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)	PH 9.3	RANGE 9.3-10.0	TIME 3:20P
		14/47 (60 MIN)	PH 9.3	RANGE 9.3-10.0	TIME 3:30P
		15/48 (2 HRS)	PH 9.3	RANGE 9.3-10.0	TIME 4:30P
		16/49 (3 HRS)	PH 9.3	RANGE 9.3-10.0	TIME 5:30P
		16/49 (4 HRS)	PH 9.3	RANGE 9.3-10.0	TIME 6:30P
		17/50 (FINISH)	PH 7.0	RANGE 7.5-8.5	TIME 7:35P
		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

302	128	RUN 31" (379 G) WATER INTO V-302			
6	129	ADD & STIR 5 MIN ASSUME 50%	124	7-D	62

SV	130	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SP	131	SP STEP 23/53 - RECORD: PH 3.6 (3.3-3.7)			
&	132	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
CP		RECORD: PH ---			
7		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
		*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			
	133	SIFT IN	150	128-A	150
	134	RUN IN N-7-D FROM S-29 IN 10-12 MIN & STIR			
		5 MIN			
	135	RECORD: PH 4.1 (4.2-4.4) & IF NECESSARY ADJ TO			
		PH 4.0-4.2 & RECORD: PH --- ASSUME 77%			
		(DILUTE 10 TO 1 WITH WATER) ASSUME 50%			
		SIPHON N-7-D INTO SV			
	136	OPERATOR STEP PB			
	137	SP STEP 24/54 - POUR IN & STIR 15 MIN	20	978-A	20
	138	OPERATOR STEP PB			
	139	SP STEP 60 - BATCH COMPLETE			
	140	OPERATOR STEP PB			

Pump to 240

START
TIME SP STEP2:00P
3:20P

FINISH

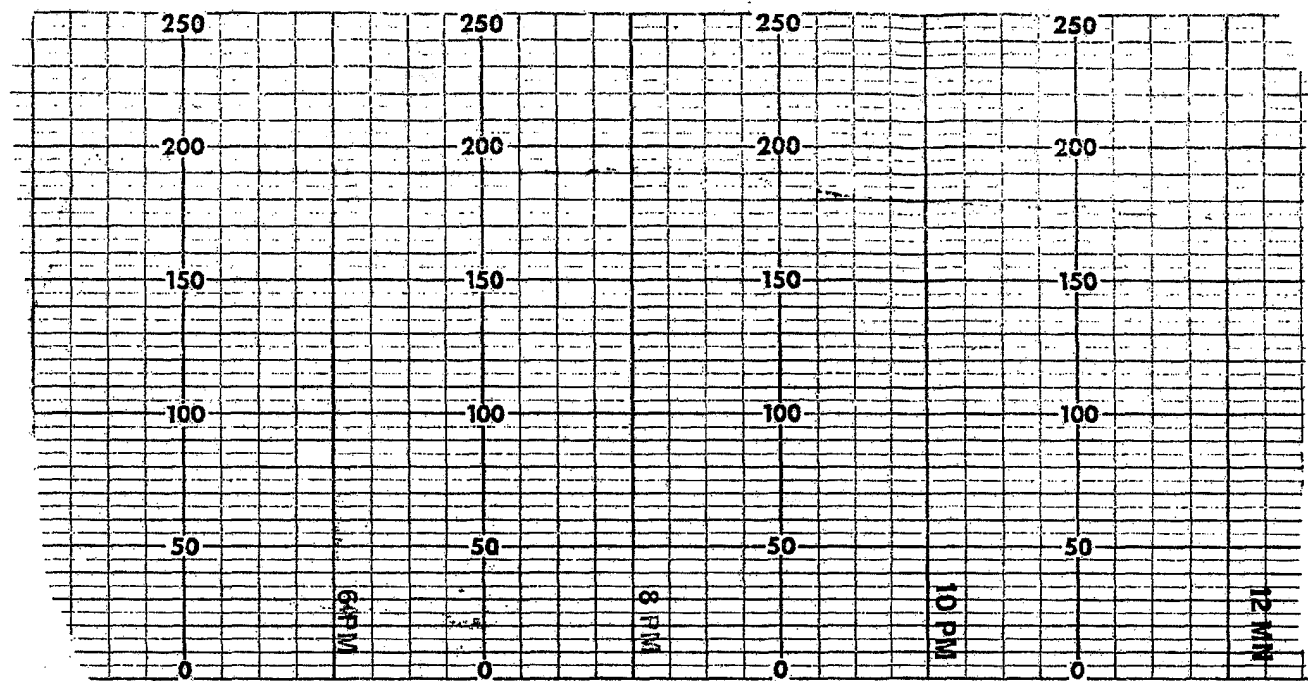
TIME SP STEP

3:00P
9:32P

OPTR

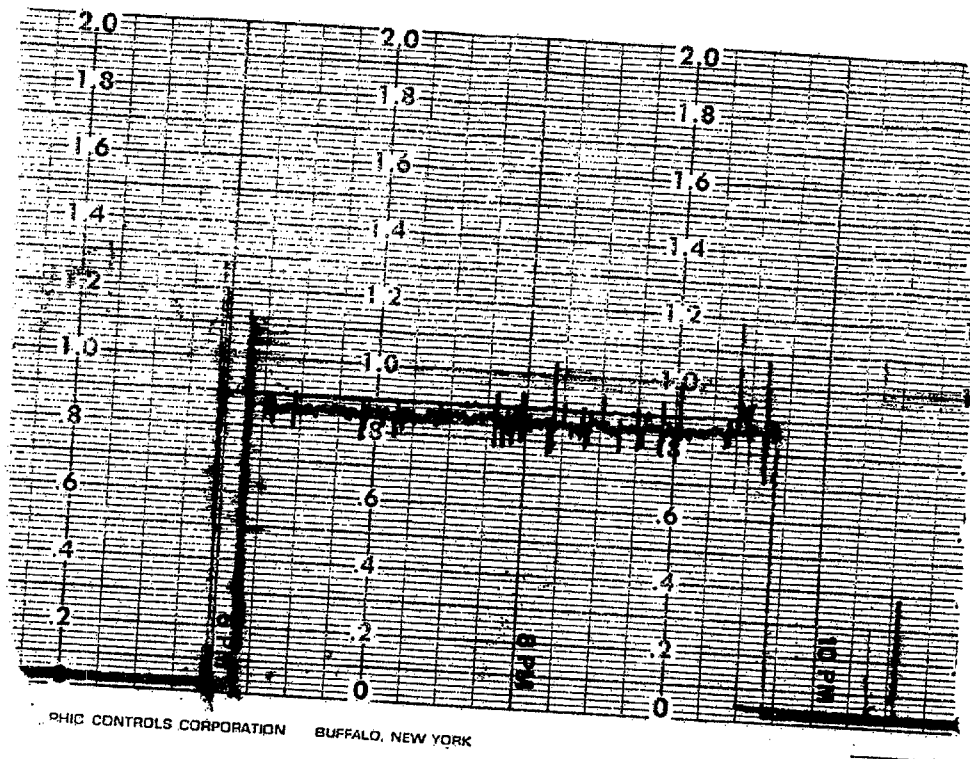
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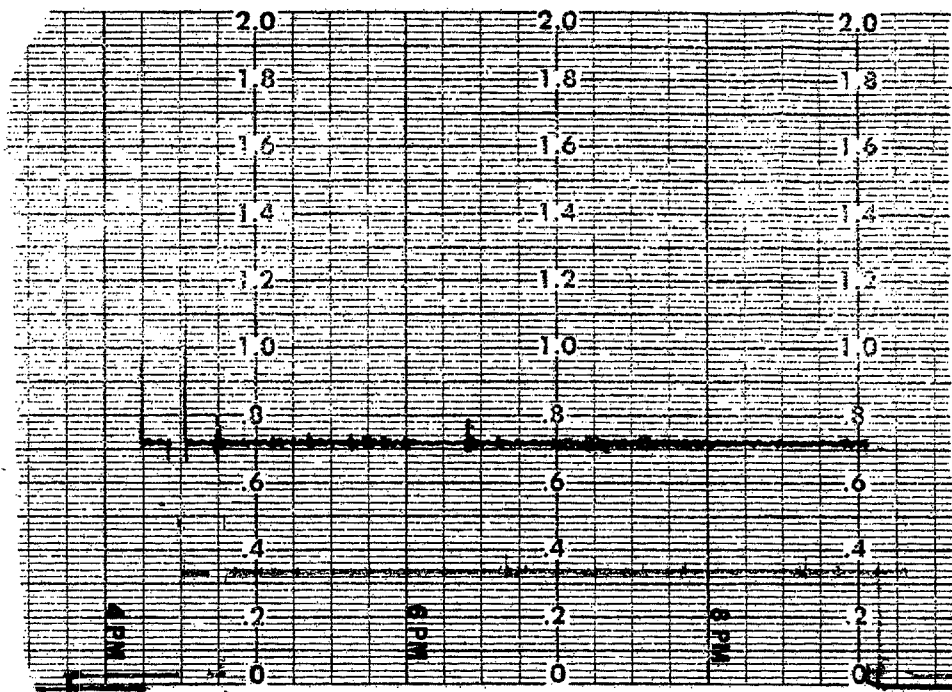
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