(AUTOMATED)
S.V. 243, 244 C.V. MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-787-D PKG
LOT NOV-3 80 37640
EST'D WGT 932 LBS
STANDARD HRS. 8.9 TIME ____ M

7:AM 01/ KP

PROCESSES
( ) KY-787-D
( )
( )
( )
( )

APPROVED BY
(Q) FWP 9/23/80
( ) (XOB-17: 25%
( ) LESS N-32-D
( ) & 240 MIN
( ) STRIKE)
TYPED BY: FP 9/23/80

COMPONENT CONSUMPTION

	CODE	LOT	PQ	LBS
1*	YC002B	13196	93	2000
14	YC002B	13197	93	700
14	YC002B	_____	93	_____

CG	CODE	LOT	PQ	LBS
14	YC002B	_____	93	_____
14	YC002B	_____	93	_____
14	YC002B	_____	93	_____

PUNCHED & CHECKED
NOV - 7 1980

TOTAL EST'D WGT 3332 NON-BLEEDING

EQUIP		NAME: "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203 & 205 1	1	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2	WEIGH IN DRUM & POUR IN	240	983-D D	240
	3	DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
		RECORD: START 5:00 P LOT 13196	2000		
		FIN 6:30 P 13197	700		
	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 42 " & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 SV 2	9	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
		RECORD: TIME START 12:45 P TOTAL MINUTES 135			
		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 3	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
	13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194*F)			
	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
		M. 11LG 67 % PRESET #1 80 GAL		15-A	160
		P. 13LG 67 % PRESET #6 135 GAL		20-A	135
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		✓3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
		✓3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
		✓3FR10 (N-27-D/WATER) RATIO 1.35		983-D D	
		✓8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM			1376
		✓8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
		✓8FC20 (N-32-D WATER) IN REMOTE			
		✓8FR10 (N-32-D/WATER) RATIO 1.82			

QUIP	PAGE 2 CG 03 RT-787-D EST WGT 5332# V-243	USE LBS	N= CODE	USE LBS
	16 OPERATOR STEP PB			
20	17 RECORD LEVEL 2LG 55% IF BELOW 35% FOLLOW SOL'N			
/	MAKE-UP PROCEDURE FOR N-27-D			
>	18 ADJUST SV TO 48" (2470 G)			
>	19 RECORD PH 9.5. 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 11.2 ASSUME 50%	20	221D	20
	120 OPERATOR STEP PB			
→	21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5.			
/	22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
>	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: 7:49			

SP STEP V-243/V-244	PH	RANGE	TIME
13/46 (30 MIN)	9.2	9.0-10.0	8:10 AM
14/47 (60 MIN)	9.1	9.0-10.0	8:40 AM
15/48 (2 HRS)	9.1	9.0-10.0	9:40 AM
16/49 (3 HRS)	9.4	9.0-10.0	10:40 AM
16/49 (4 HRS)	9.1	9.0-10.0	11:40 AM
17/50 (FINISH)	9.1	7.5-8.5	12:25 PM

	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			
	29 ADD IN 7-8 MIN	350	530-A	350
39	30 ADJ TO 49" (382 G) AT 80-100*F			
5	31 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)			
	32 STIR 15 MIN OR LONGER FOR SP STEP 26			
	33 RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	34 SET PRESET #8 TO 38.2 GAL FROM S 33			
02	35 RUN 30" (360 G) WATER INTO V-302			
7	36 ADD & STIR 2 MIN FOR S 40 ASSUME 50%	160	7-D	80
	37 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.	✓		
	38 LIFT IN	100	128-A	100
TV	39 SP STEP 23/53. RECORD: PH 3.8 (3.7-4.2)			
IP	40 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
3	41 RECORD: PH 9.4 (9.0-9.5). ADJ IF NECESSARY &			
	RECORD: PH___ ASSUME 77%	____	27-D	____
	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	____	7-D	____
	(SIPHON N-7-D INTO SV)			
	42 OPERATOR STEP PB			
	43 SP STEP 29/58. RECORD: PH 9.5 & TIME ____			
	44 OPERATOR STEP PB			
	45 SP STEP 60. BATCH COMPLETE.			

46 PUMP TO 240

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
11:00 PM	____	7:00 AM	____	237-244
7 AM	____	12:00	____	223-232

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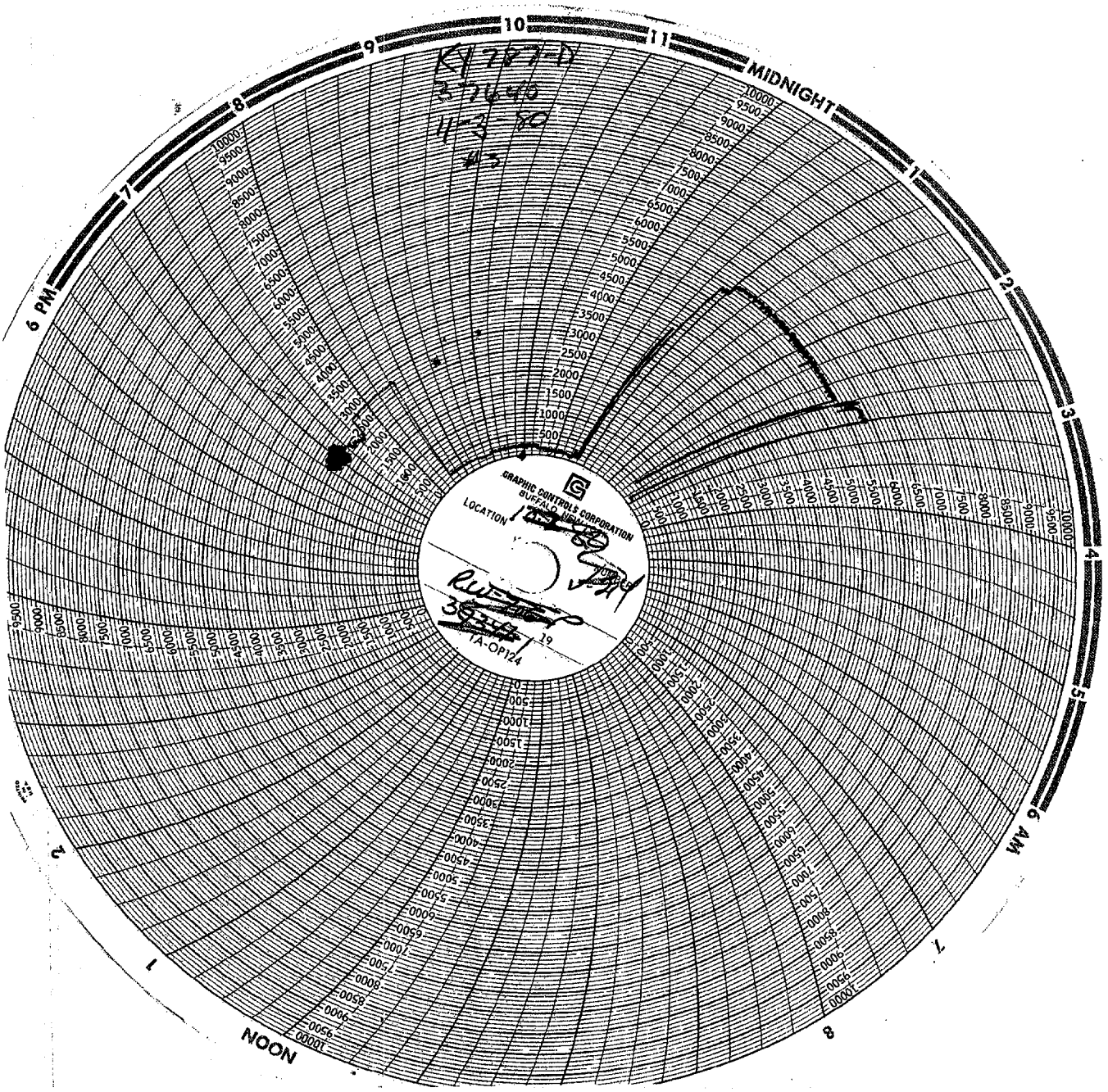

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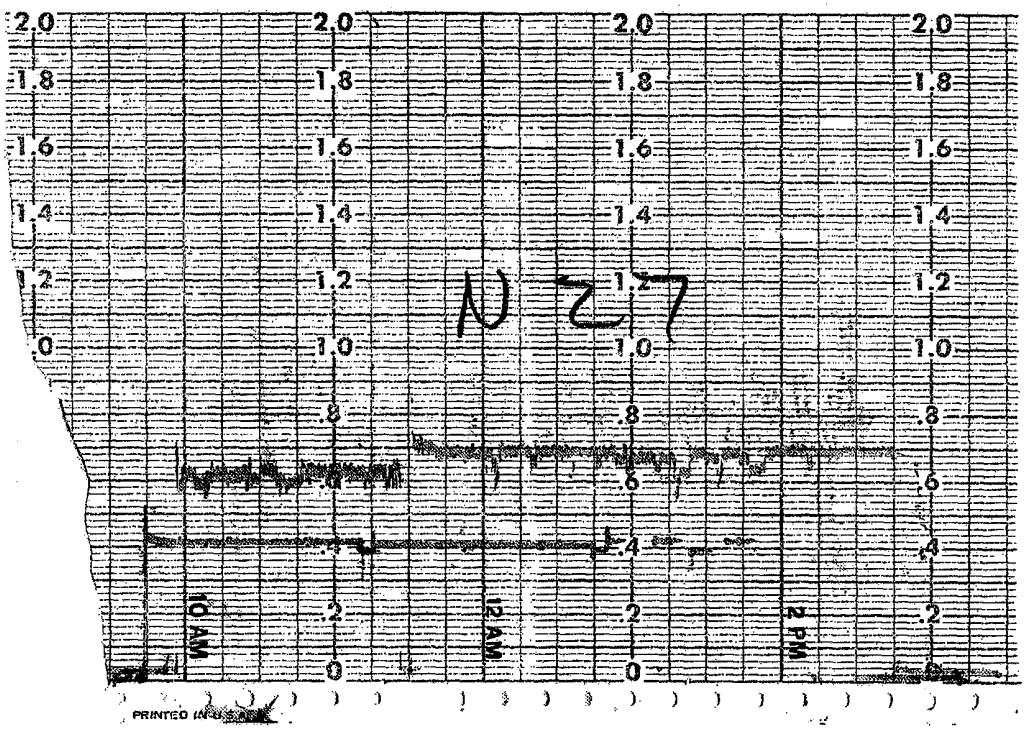

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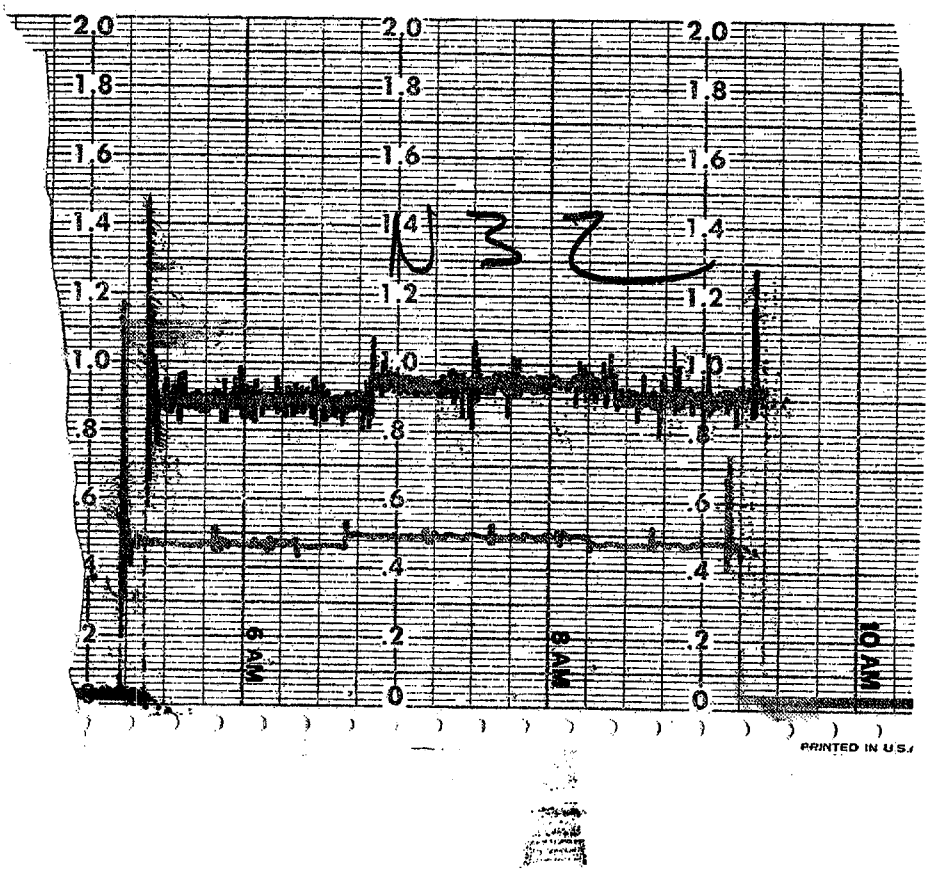
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