AGITATOR(S)
S.V. 243 244 C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V. -

CG 03 CODE KY-787-D PKG
LOT MAY -0-81-E1560

PROCESSES
( ) KY-787-D (T) FWP 4/30/81
( ) ( )
( ) ( )
( ) ( )
( ) ( )

APPROVED BY

STANDARD HRS. 8.9 TIME _____ M

JOB NAME 03KY787DMT

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	83609-1	93	2000	14	YC002B	_____	93	_____
14	YC002B	83609-2	93	500	14	YC002B	_____	93	_____
14	YC002B	_____	93	_____	14	YC002B	_____	93	_____

Do not use YC-2-B lots 13839 thru 13855

TOTAL EST'D WGT 3464 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	250	32-D	250
	3	DUMP IN AND STIR 5 MIN LOT 83609-1	50X50	YC-2-B	2500
1		RECORD: START 3:PM 83609-2	2000		
		FIN 4:15PM	500		
	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	9	RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV-2			
		RECORD: TIME START 11:20 AM TOTAL MINUTES 100			
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-2			
SP & CP	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) MAY 21 1981			
3	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
		A. 11LG 57 % PRESET #1 84 GAL		15-A	168
		B. 13LG 46 % PRESET #6 141 GAL		20-A	141
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM		27-D	213
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM			
		3FR10 (N-27-D/WATER) RATIO 1.31			
		8FC10 (N-32-D CONTROLLER) IN MANUAL .84 GPM		32-D	1425
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.76			

EQUIP		PAGE 2 CG 03 KY-787-D EST WGT 3464# 244	USE LBS	N-CODE	USE LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 53 % IF BELOW 35% FOLLOW SOL'N			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 48" (2470 G)			
CP	19	RECORD PH 9.9. 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%	40	7-D	20
	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:			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.6 9.0-10.0 4:00			
		14/47 (60 MIN) 9.6 9.0-10.0 4:30			
		15/48 (2 HRS) 9.5 9.0-10.0 5:30			
		16/49 (2 HRS, 25 MIN) 9.6 9.0-10.0 5:55			
		17/50 (FINAL 3 HRS) 7.4 7.5-8.5 6:30			
		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	____
	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
	29	ADD IN 7-8 MIN	365	530-A	365
339	30	ADJ TO 49" (382 G) AT 80-100*F			
6	31	STIR 5 MIN & RECORD: PH ___ (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			
302	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	SIFT IN	100	128-A	100
SV	39	SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)			
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
		MIN			
8	41	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	___
		(SIPHON N-7-D INTO SV)			
	42	OPERATOR STEP PB			
	43	SP STEP 29/58. RECORD: PH 9.2 & TIME ____			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
11:00 PM	____	7:00AM	____	409-30/
7:00A	____	7:30AM	____	235-1244
____	____	____	____	____

DUP050096469