

DUMP COLOR + WATER ONLY

243

AUTOMATED
V. 243, 244

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-795-D PKG

LOT

APR 28

35541

APR 29 1980

PROCESSES

APPROVED BY

EST'D WGT 1110 880 LBS

STANDARD HRS. 8.2 TIME 7A M

() KY-795-D (H) FWP 4/23/80

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TYPED BY: FWP 4/23/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	24845	93	3500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

NOTE: WATER & COLOR ONLY

ADD N-32 & ADJUST

TOTAL EST'D WGT 4380

1 INCHES

NON-BLEEDING

QUIP	NAME	USE LBS	N- CODE	ACCT LBS
203 & 205	NAME: "KROLOR" YELLOW MEDIUM			
1	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
2	2 WEIGH IN DRUM & POUR IN	475	32-D	475
2	2 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
1	RECORD: START			
	FIN 7:15 A			
14	14 ADJUST TO 75" (1275 G)			
5	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
6	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
7	7 RECORD: V-205 VOL 46" & ADJ TO 60" (2100 G)			
8	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
105	105 RUN 10" (514 G) WATER INTO V-203 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 7:00 P TOTAL MINUTES 1:10			
11	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 112 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (V-244)

CP 113 PRESS SV CAM RESET PB - SET 22 TC IN AUTO

3 114 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:

A. 11LG 62% PRESET #1 104 GAL

115 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:

3FC10 (N-27-D CONTROLLER) IN MANUAL 0.78 GPM

3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM

3FC10 (N-27-D/WATER) RATIO 0.8

3FC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM

3FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM

3FC20 (N-32-D WATER) IN REMOTE 1.0

15-A 208

27-D 296

32-D 2475

1885

V-243

QUIP PAGE 2 CG 03 KY-795-D EST WGT 4612# USE LBS N-CODE USE LBS

116 OPERATOR STEP PB
 117 RECORD LEVEL 2LG 60% IF <35% FOLLOW SOLUTION
 V MAKE-UP PROCEDURE FOR N-27-D
 118 ADJUST SV TO 68" (3495 G)
 119 RECORD PH 10.3 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 11.3 ASSUME 50% 76 7-D 13
 120 OPERATOR STEP PB

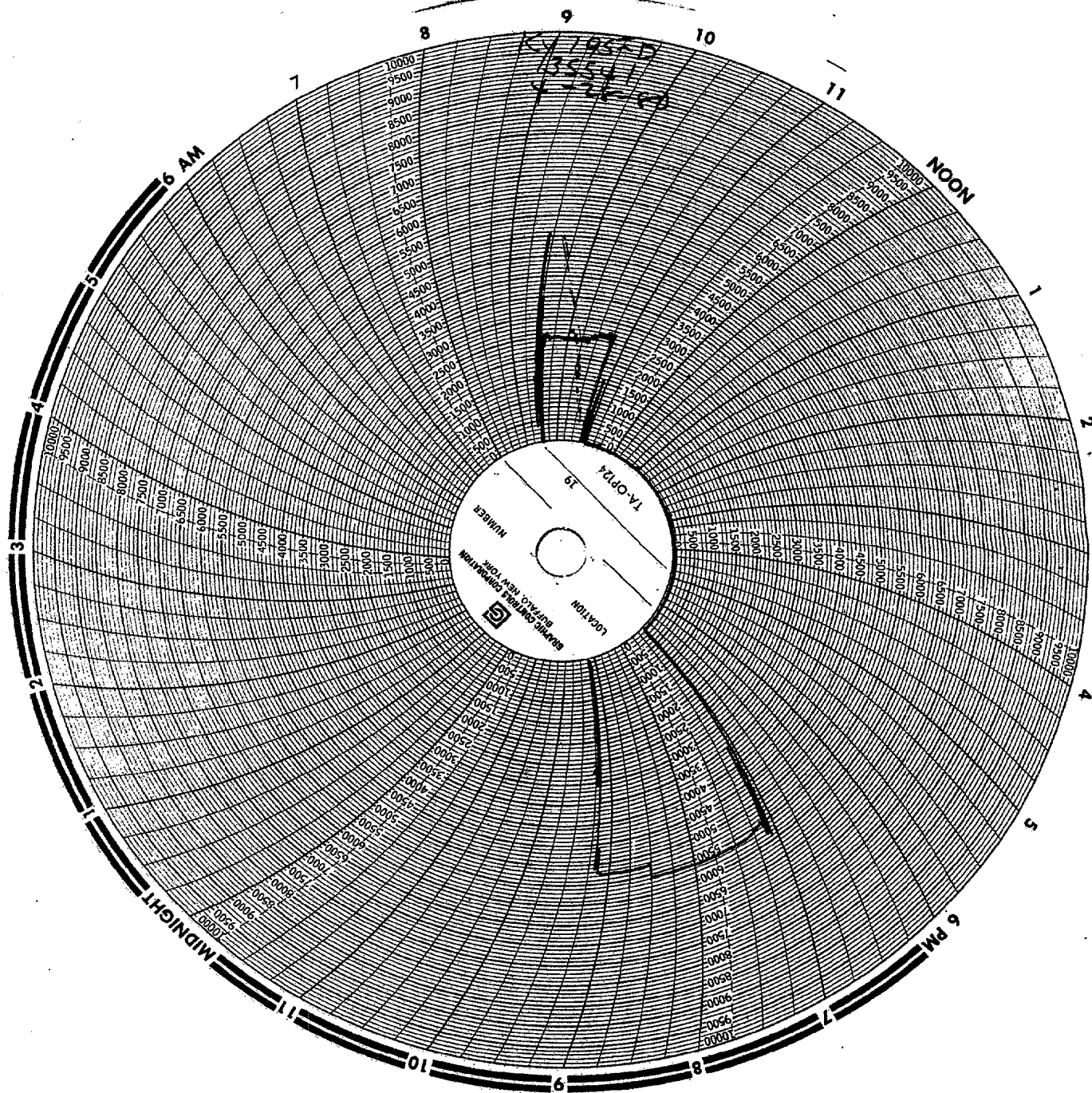
21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 28
 SV 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 23 OPERATOR STEP PB
 24 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 25 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
 26 OPERATOR STEP PB
 27 DURING STRIKE RECORD:
 SP STEP
 V-243/V-244
 13/46 (30 MIN) 9.5 9.0-10.0 11:55 AM
 14/47 (60 MIN) 9.5 9.0-10.0 12:05 PM
 15/48 (2 HRS) 9.5 9.0-10.0 1:35 PM
 16/49 (3 HRS) 9.5 9.0-10.0 2:05 PM
 17/50 (FINAL 3 HRS) 2.5 7.5-9.5 3:10 PM
 NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE
 IN LOG. IF FINAL PH >9.5, ADJ TO 7.5-8.5.
 & RECORD: PH ASSUME 77% 27-D

DRUM 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
 SV 31 SP STEP 23/53 - RECORD: PH 2.9 (3.3-3.7)
 SP 32 IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7
 & RECORD: PH 15-A
 33 NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140
 34 ME IN DRUM. USE 30 GAL WATER TO 50% N-15-A.
 STIR 5 MIN AFTER EACH ADDITION.
 35 SIFT IN 150 12B-A 150
 36 SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR
 5 MIN
 37 RECORD: PH 3.6 (4.0-4.2) & IF NECESSARY ADJ TO
 PH 4.0-4.2 & RECORD: PH 4.0 ASSUME 77% 27-D
 (DILUTE 10 TO 1 WITH WATER) ASSUME 50% 34 7-D 17
 38 SIPHON N-7-D INTO SV
 39 OPERATOR STEP PB
 40 SP STEP 24/54 - POUR IN & STIR 15 MIN 22 978-A 22
 41 OPERATOR STEP PB
 42 SP STEP 60 - BATCH COMPLETE

43 OPERATOR STEP PB
 44 PUMP TO V-240

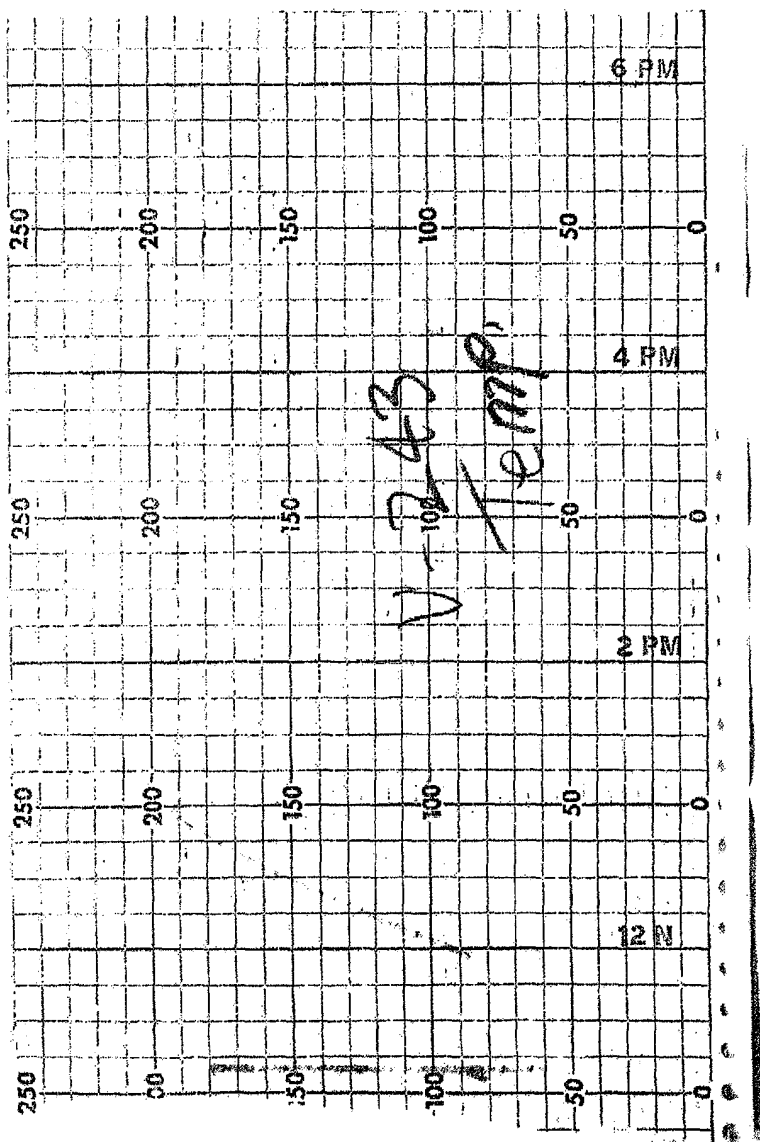
START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
7 AM		3 PM		282-201
3:00 P		11:00 P		120-259
				275-317

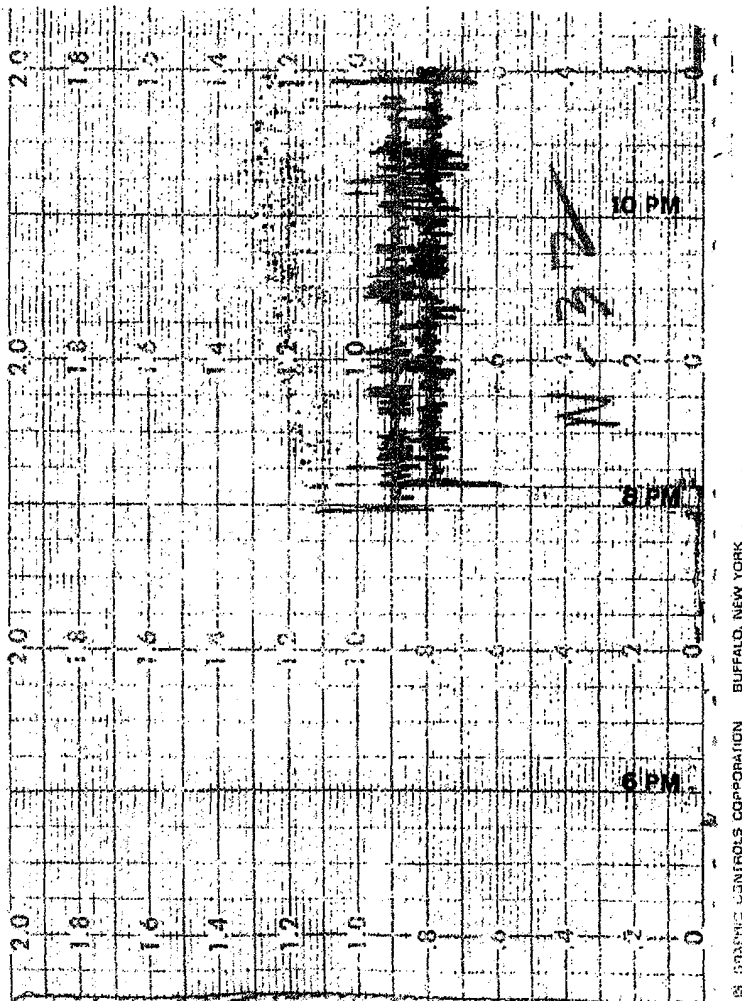


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