

JUN 17 1982

F2K64

3394*

COMTYP JOB NAME: 03KY787DMT

(DATE)

(LOT)

(EST WGT)

TYPED BY: JMW

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
14	YC0028	93	01402	F2K64 D2E18	2000 500	XX.XX	---	---	---	---
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NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ALCT LBS
203	"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
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	50X50	YC-2-B	2500
1	RECORD: START 6:30 PM FIN 7:30 PM	2000 500		
263	4 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
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 " & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
9	RUN 10" (514 G) WATER INTO V-203 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 11:35 PM TOTAL MINUTES 150			
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	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION		
&	1	2 (V-243). OR POSITION 7 (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 64% PRESET #1 32 GAL	115-D	168
		B. 13LG 44% 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		

JUN 23 1982

N38005

EQUIP

PAGE 2 CG 02 KY-787-D
CONTYP JOB NAME: 03KY787DMTUSE
LBSN-
CODEUSE
LBS

243

320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 85% IF BELOW 35% FOLLOW SOL'N			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 48" (2470 G)			
	19	RECORD PH 10.8. 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%	30	7-D	15
	20	OPERATOR STEP PB			

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5.			
SP	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:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) 9.1 9.0-10.0 4:25 AM			
		14/47 (60 MIN) 9.1 9.0-10.0 4:55 AM			
		15/48 (2 HRS) 9.1 9.0-10.0 5:35 AM			
		16/49 (2 HRS, 25 MIN) 9.1 9.0-10.0 6:20 AM			
		17/50 (FINAL 3 HRS) 5.5 7.5-8.5 6:55 AM			
		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	

356	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-332			
356	29	ADD IN 7-8 MIN. CHECK FOR DRAFT IN VENT STACK	365	530-A	365
		BEFORE DUMPING.			
	30	ADJ TO 49" (382 G) AT 80-100°F			
	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 --- & CALC --- X 0.78 = --- GAL			
	34	SET PRESET #B TO --- GAL FROM S 33			

385	35	RUN 47" (360 G) WATER INTO V-385			
7	36	ADD & STIR 2 MIN FOR S 40	160	7-D	80

	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	38	SIFT IN	100	128-A	110
SV	39	SP STEP 23/53. RECORD: PH 3.3 (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 8.0 (9.0-9.5). ADJ IF NECESSARY &			
		RECORD: PH 9.2			
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 77%		27-D	
		(SIPHON N-7-D INTO SV) ASSUME 50%	7.9	7-D	5
	42	OPERATOR STEP PB			
	43	SP STEP 29/58. RECORD: PH 9.1 & TIME ---			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START
TIME SP STEPFINISH
TIME SP STEP

OPTR

7:00 AM

2:50 AM







