

CG 03 CODE KY-788-D PKG

LOT DEC--3 80 38132

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 11/20/80
() () 4 HOUR STRIKE
() () AS FOR XOB-17
() ()
() ()

JOB NAME: XOB17:788J

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	13077	93	2000	14	YC003B		93	
14	YC003B	13066	93	200	14	YC003B		93	
14	YC003B		93		14	YC003B		93	

CLEAN UP
AS YOU GO ALONG

Homog #4-1 ST Pass

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
	KRODOR YELLOW-LIGHT			
203	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	350	983-D	350
	RECORD START 5:57	52X50	YC-3-B	2600
	FIN 6:30	2000		200
	ADJUST TO 75" (1275 G)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL 56" & ADJ TO 60" (2100 G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:30 TOTAL MINUTES 150			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 24% PRESET #2 208 GAL		15-A	416
	B. 13LG 20% PRESET #6 135 GAL		20-A	135
	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM		27-D	180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.8			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM		983-D	1240
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM			
	8FR10 (N-32-D/WATER) RATIO 1.1			

AM

V-243

16 OPERATOR STEP PB
 320 17 RECORD LEVEL 2LG 45% IF (35% FOLLOW SOLUTION
 SV 18 MAKE-UP PROCEDURE FOR N-27-D
 SP 19 ADJUST SV TO 47" (2400 G)
 CP 19 RECORD PH 10.1 ADJ TO 11.0-11.2 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 20 SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50% 20 7-D 10
 20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7
 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
9.4	9.3-10.0	10:45
9.4	9.3-10.0	11:13
9.4	9.3-10.0	12:13
9.3	9.3-10.0	1:13
9.1	9.3-10.0	2:13
7.5	7.5-8.5	3:00

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

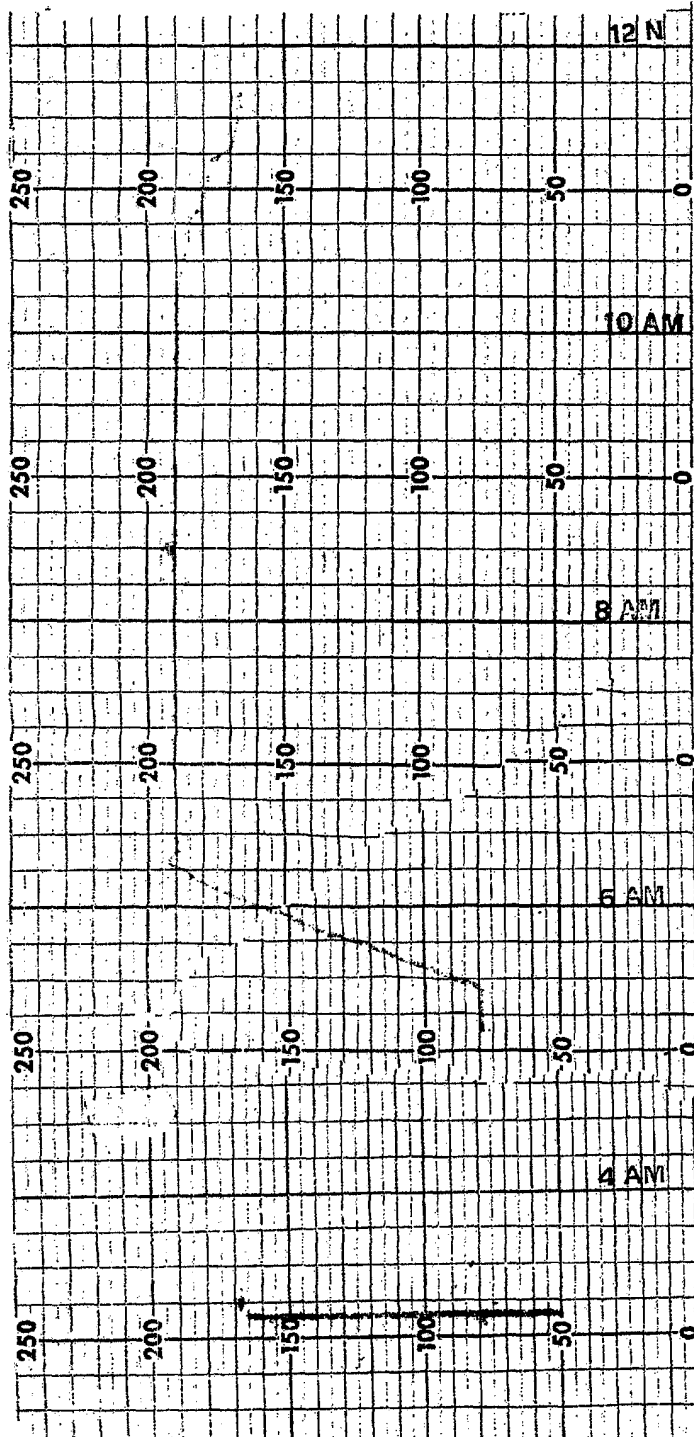
128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 129 ADD IN 7-8 MIN 350 530-A 350
 339 130 ADJ TO 49" (382 G) AT 80-100*F
 6 131 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
 132 STIR 15 MIN OR LONGER FOR SP STEP 26/56
 133 RECORD: VOL 49" & CALC 49" X 0.78 = 382 CAL
 134 SET PRESET #8 TO 382 CAL FROM S 33

302 135 RUN 40" (440 G) WATER INTO V-302
 7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 360 7-D 180

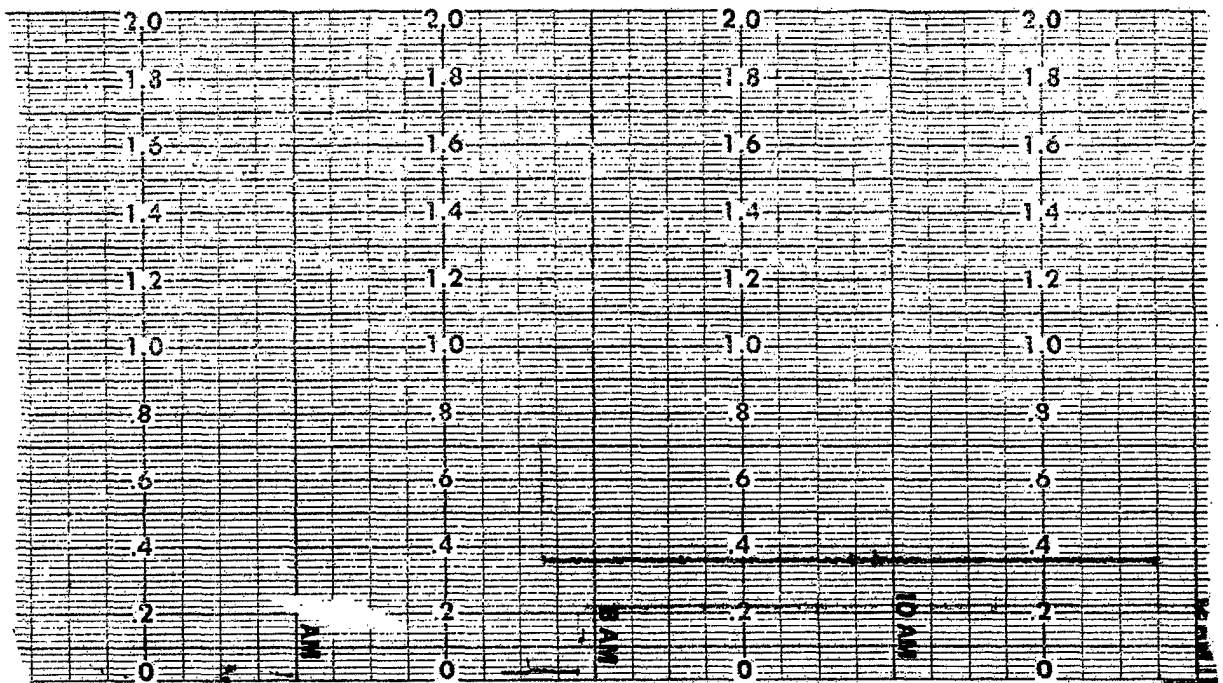
137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 138 SIFT IN 100 128-A 100
 SV 139 SP STEP 23/53. RECORD: PH 3.1 (3.7-4.2)
 SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
 MIN
 8 141 RECORD: PH 9.5 (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH ____ ASSUME 77% 27-D
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 7-D
 (SIPHON N-7-D INTO SV)

142 OPERATOR STEP PB
 143 SP STEP 29. RECORD: PH 9.4 & TIME 3:45 AM
 144 OPERATOR STEP PB
 145 SP STEP 60. BATCH COMPLETE.
 45-A PUMP V-243 OVER TO V-240

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
2:00 PM	3:00 PM	320-235
3 PM	11 PM	282-342
11:15 AM	3:45 AM	54



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



PRINTED IN U.S.A.

