

CC 03
DEC 30 1981

CODE KY-788-D PKG
A2H13
LOT NUMBER

PROCESSES APPROVED BY
() KY-788-D (J) FWP 12/09/81

STANDARD HRS. 8.8

TIME 11 PM

JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	14858	93	2000	14	YC-3-B		93	
14	YC-3-B	14877	93	600	14	YC-3-B		93	
14	YC-3-B		93		14	YC-3-B		93	

DO NOT USE YC-3-B LOTS 14001 THRU 14004

TOTAL EST'D WGT 3489* LBS.

NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
	NAME : "KROLOR" YELLOW-LIGHT			
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN	345	32-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
1	RECORD: START 3:15 PM 14858	2000		
	FIN 4:15 PM 14877	600		
	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 4.9" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
235	9 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 3:00A TOTAL MINUTES 190			
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			
SP & CP	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)			
	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 56% PRESET #2 78 GAL	115-A		416
	B. 13LG 72% PRESET #6 135 GAL	20-A		135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM	27-D		180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.8			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM	32-D		1215
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.1			

EQUIP MENT;	PAGE 2 OG 03 KY-788-D COMTYP JOB NAME: 03KY788DMJ	USE LBS	N- CODE	ACCT LBS
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320	116	OPERATOR STEP PB			
SV	117	RECORD LEVEL 2LG <u>12%</u> IF <35% FOLLOW SOLUTION			
SP	118	MAKE-UP PROCEDURE FOR N-27-D			
CP	119	ADJUST SV TO 47" (2400 G)			
	120	RECORD PH <u>10.0</u> . ADJ TO 11.0-11.2 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH <u>11.1</u> . ASSUME 50%	<u>40</u>	7-D	<u>20</u>
	120	OPERATOR STEP PB			

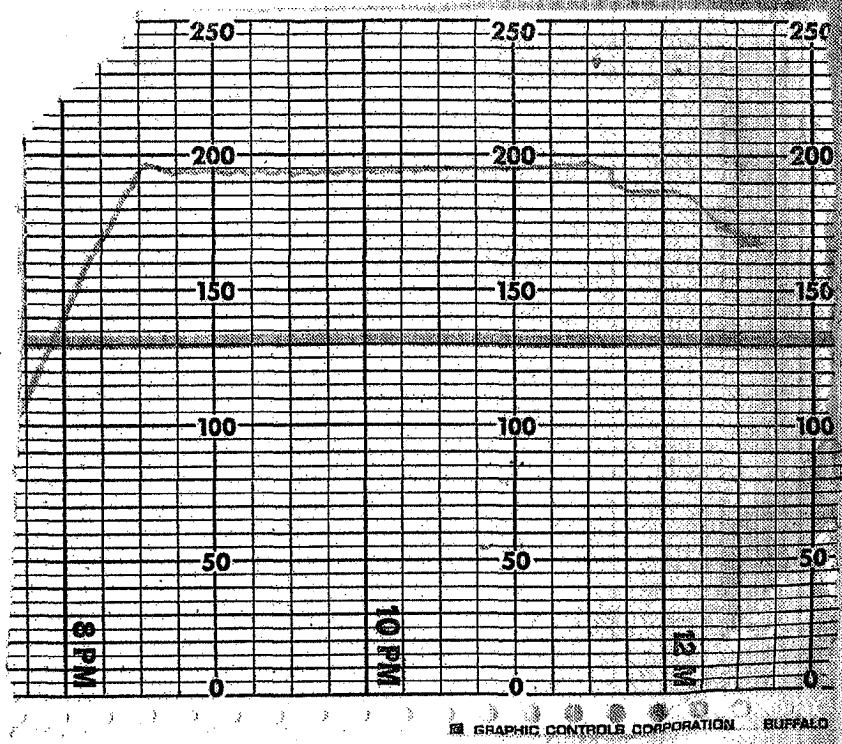
SV	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.2</u> .			
SP	122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	123	OPERATOR STEP PB			
	124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	125	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	126	OPERATOR STEP PB			
	127	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) <u>9.5</u> 9.3-10.0 <u>8.5</u>			
		14/47 (60 MIN) <u>9.5</u> 9.3-10.0 <u>9.5</u>			
		15/48 (2 HRS) <u>9.5</u> 9.3-10.0 <u>10.5</u>			
		16/49 (2 HRS, 25 MIN) <u>9.5</u> 9.3-10.0 <u>10.30</u>			
		17/50 (FINAL 3 HRS) <u>7.5</u> 7.5-8.5 <u>11.5</u>			
		NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.			
		& RECORD: PH <u>7.5</u> ASSUME 77%		27-D	

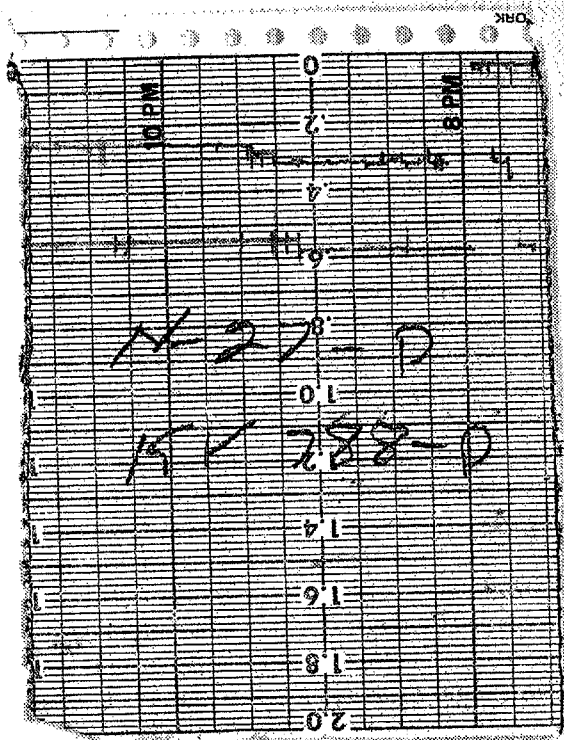
339	128	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
	129	ADD IN 7-8 MIN	350	530-A	350
6	130	ADJ TO 49" (382 G) AT 80-100°F			
	131	STIR 5 MIN & RECORD: PH <u>10.0</u> (9.5-10.5)			
	132	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
	133	RECORD: VOL <u>19</u> & CALC <u>19</u> X 0.78 = <u>382</u> GAL			
	134	SET PRESET #8 TO <u>382</u> GAL FROM S 33			

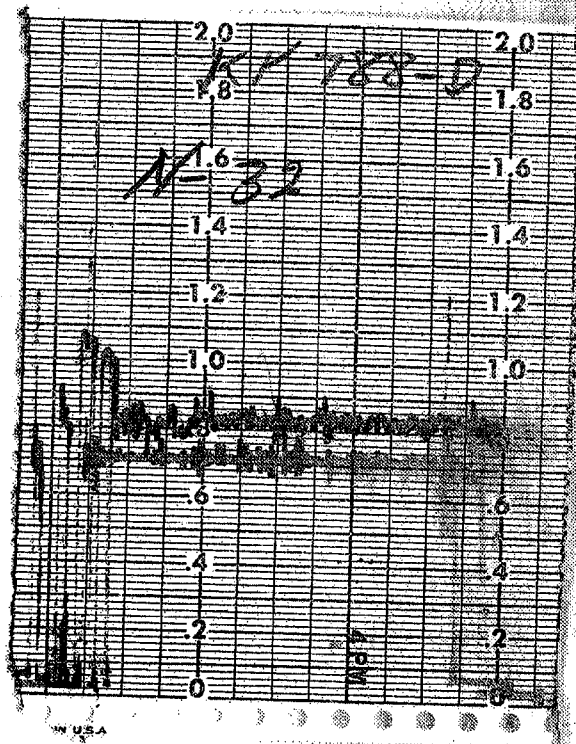
385	135	RUN 57" (440 G) WATER INTO V-385			
7	136	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180

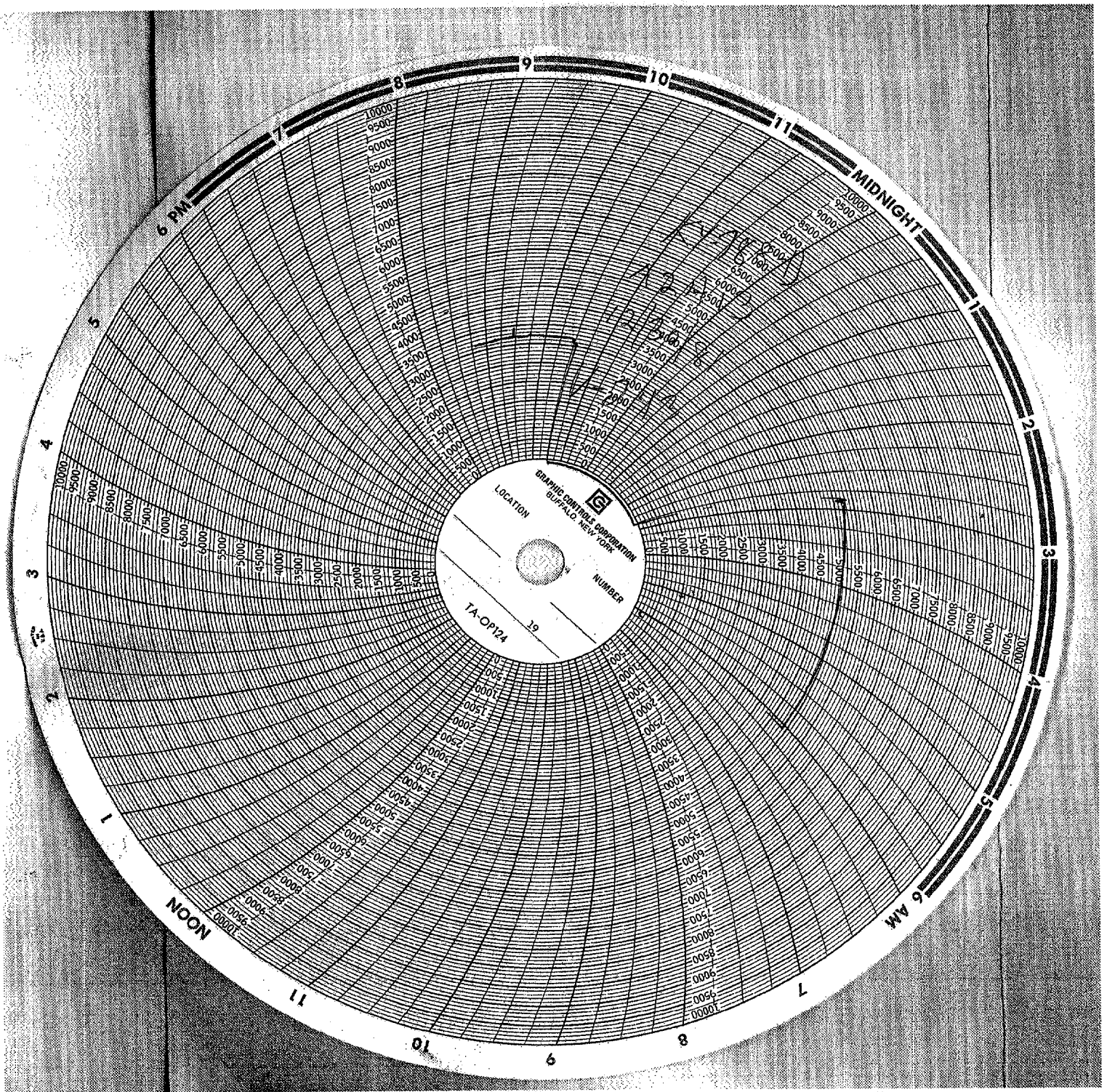
	137	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	138	STIR IN	100	120-A	100
SV	139	SP STEP 23/53. RECORD: PH <u>3.7</u> (3.7-4.2)			
SP	140	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
8	141	RECORD: PH <u>8.7</u> (9.0-9.5). ADJ IF NECESSARY & RECORD: PH <u>2.2</u> ASSUME 77%		27-D	
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	<u>30</u>	7-D	<u>15</u>
		(SIPHON N-7-D INTO SV)			
	142	OPERATOR STEP PB			
	143	SP STEP 29. RECORD: PH <u>9.2</u> & TIME <u>12.34 P</u>			
	144	OPERATOR STEP PB			
	145	SP STEP 60. BATCH COMPLETE.			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>11:00</u>	<u>12:30 P</u>	<u>12:30</u>
<u>7:00</u>	<u>12:30 P</u>	<u>12:30</u>









2 slow