

(AUTOMATED)
S.V. 243

JUN 13 1980

MAKING INSTRUCTIONS CATCH UNIT
D.V.

CG 03 CODE KY-787-D PKG
LOT JUN 12 36095

PROCESSES

APPROVED BY

EST'D WGT 1090 LBS

STANDARD HRS. 8.9 TIME 3P M

() KY-787-D (Q) FWF 5/20/80
()
()
()
()
()

TYPED BY: FP 5/20/80

COMPONENT CONSUMPTION

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

One regular YC-2-B (not re-ground)
TOTAL EST'D WGT 3490
Homog #4 - 1ST Pass
11 543 NON-FEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
263	WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	320	32-D	320
1	RECORD: START 10AM 24787-48 FIN 330AM	48X50	YC-2-B	2400
5	ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
4	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
2	RECORD: V-205 " & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
263	RUN 10" (514 G) WATER INTO V-243 START			
SV	AGITATOR PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 10:50AM TOTAL MINUTES 130			
11	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 112 STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)

CP 113 PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)

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

A. 11LG 80% PRESET #1 80 GAL 15-A 160
B. 13LG 32% PRESET #4 135 GAL 20-A 135

115 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:

3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM 27-D 275
3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM
3FB10 (N-27-D/WATER) RATIO 0.64
BFC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM 32-D 1840
BFC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM
BEG20 (N-32-D WATER) IN REMOTE
BFR10 (N-32-D/WATER) RATIO 0.83

USE
LBSN-
CODEUSE
LBS

116 OPERATOR STEP PB
 320 117 RECORD LEVEL 2LG **62** IF BELOW 35% FOLLOW SOL'N
 SV 118 MAKE-UP PROCEDURE FOR N-27-D
 SP 119 ADJUST SV TO 48" (2470 G)
 CP 120 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)
 4 121 SIPHON INTO SV. RECORD: PH **11.3** ASSUME 50% **26** 7-D **15**
 122 OPERATOR STEP PB

123 SP STEP 06/39. AFTER HEAT-UP RECORD: PH **10.1**
 SV 124 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 125 OPERATOR STEP PB
 126 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 127 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE

128 OPERATOR STEP PB
 129 DURING STRIKE RECORD:
 SP STEP

V-243/V-244

13/46 (30 MIN)

14/47 (60 MIN)

15/48 (2 HRS)

16/49 (2 HRS, 25 MIN)

17/50 (FINAL 3 HRS)

PH RANGE

TIME

9.9

9.0-10.0

2:45**9.9**

9.0-10.0

3:15**9.9**

9.0-10.0

4:15**9.9**

9.0-10.0

4:40**7.2**

7.5-8.5

5:15

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

130 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 131 ADD IN 7-8 MIN 350 530-A 350
 339 132 ADJ TO 49" (382 G) AT 80-100°F
 6 133 STIR 5 MIN & RECORD. PH **10.1** (9.5-10.5)
 134 STIR 15 MIN OR LONGER FOR SP STEP 26
 135 RECORD: VOL **49** " & CALC **49** " X 0.78 = **38.2** GAL
 136 SET PRESET #8 TO **38.2** GAL FROM S 33

302 137 RUN 30" (360 G) WATER INTO V-302
 7 138 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

139 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 140 SIFT IN 100 ✓ 128-A 100
 SV 141 SP STEP 23/53. RECORD: PH **3.6** (3.7-4.2)
 SP 142 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
 MIN
 8 143 RECORD: PH **9.1** (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH **9.1** ASSUME 77% 27-D
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 7-D
 (SIPHON N-7-D INTO SV)
 144 OPERATOR STEP PB
 145 SP STEP 29/58. RECORD: PH **9.1** & TIME **6:30 PM**
 146 OPERATOR STEP PB
 147 SP STEP 60. BATCH COMPLETE.

START

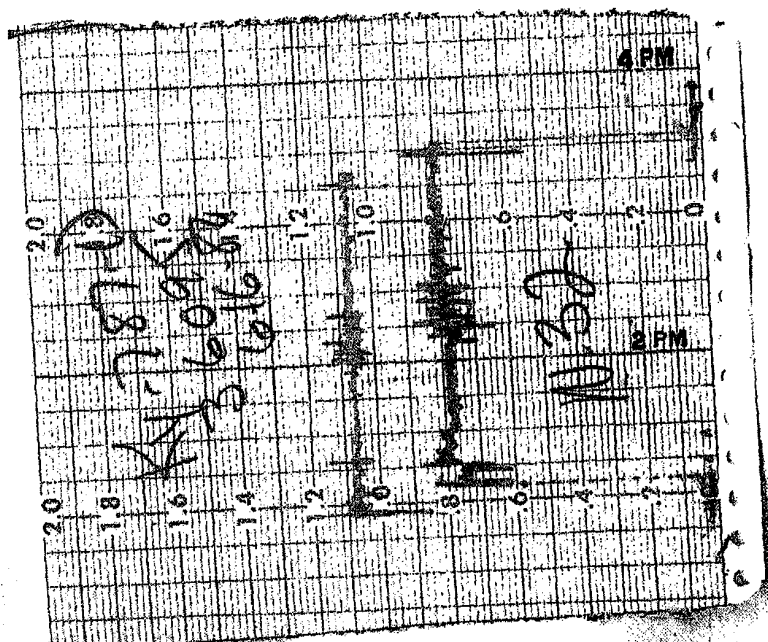
TIME SP STEP

FINISH

TIME SP STEP

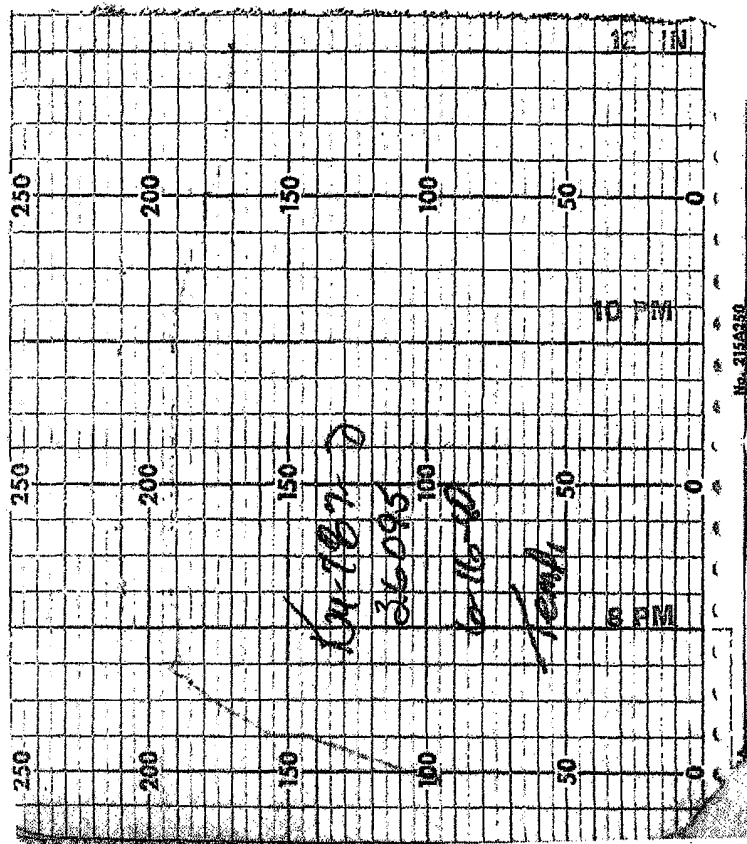
OPTR

6:30 A**2:00 A****3:00 A****7:00 A****3:00 P****6:30 P****235-323****235-323****6-16-80**

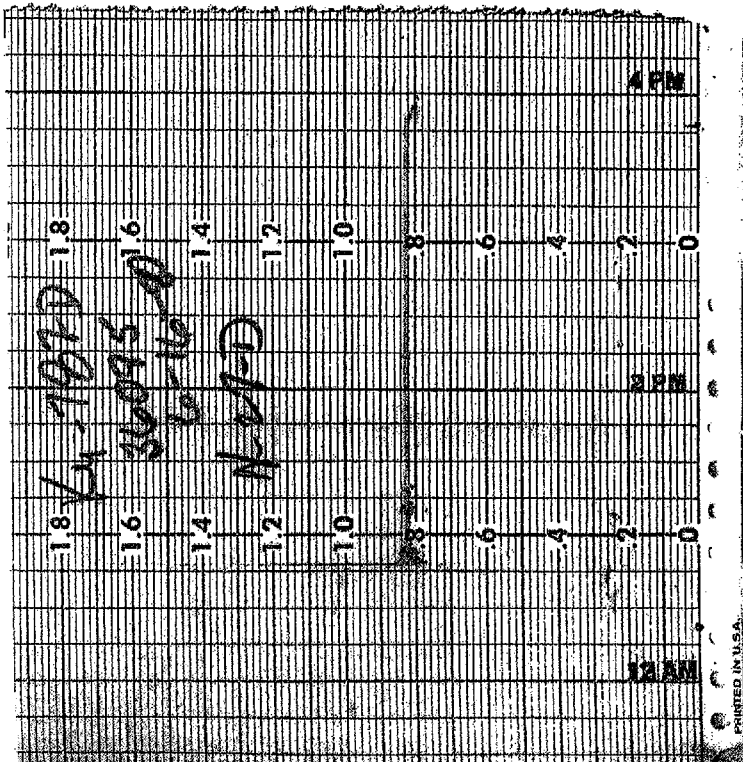


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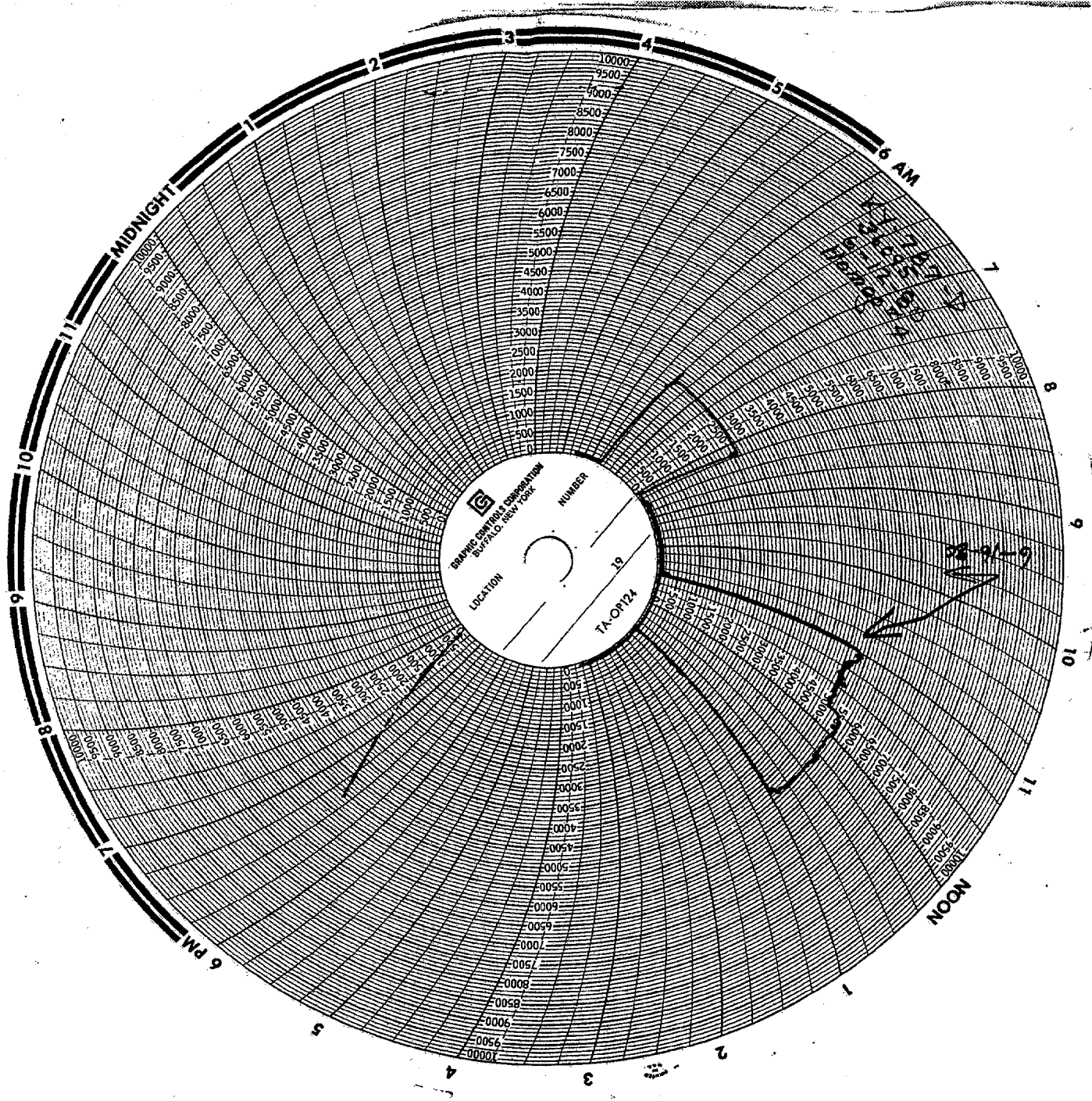
N32070.01



DUP050456457



DUP050456458



DUP050456459

N32070.02

V-243