

S.V. 244

C.V.

D.V.

CG 03
LOTCODE KY-795-D
JUN 17 36188

PUNCHED & CHECKED

PROCESSES

APPROVED BY

EST'D WGT

BB0

LBS

JUN 2 1981

STANDARD HRS. 8.2

TIME

7A M

() KY-795-D (H) FWP 5/22/80
() 3/4 N-32-D STRIKE TO
() IMPROVE GLOSS
()
()
()

TYPED BY: FWP 5/22/80

COMPONENT CONSUMPTION

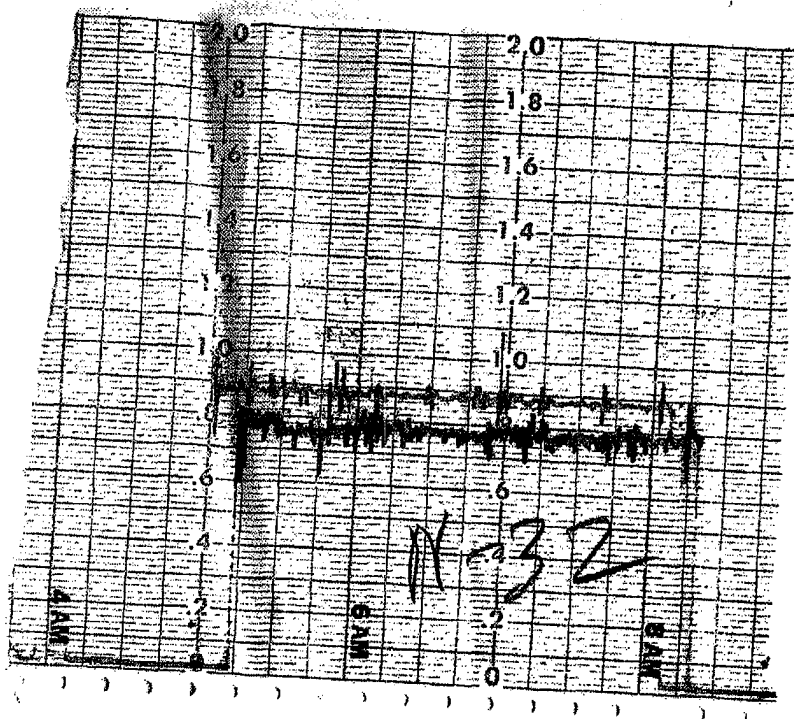
CG	CODE	LOT	PR	LBS	CG	CODE	LOT	PR	LBS
14	YC002B	82204-3	93	3750	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 4630

NON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
203	"KROLOR" YELLOW MEDIUM			
205	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	475	32-D	475
1	RECORD: START 12:30 PM FIN 8 PM	75X50	YC-2-B	3750
	ADJUST TO 75" (1275 G) 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 43" & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
2	RECORD: TIME START 12:45 PM TOTAL MINUTES 195			
	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 11	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
3	REMOTE (TEMP IS SET AT 190-194°F)			
	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG % PRESET #1 104 GAL		15-A	208
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	ZPC10 (N-27-D CONTROLLER) IN MANUAL 0.71 GPM		27-D	296
	ZPC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
	ZFR10 (N-27-D/WATER) RATIO 0.8			
	SFC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM		32-D	1885
	SFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	SFC20 (N-32-D WATER) IN REMOTE			
	SFR10 (N-32-D/WATER) RATIO 1.0			

		LBS	CODE	LBS
	116 OPERATOR STEP PB			
	117 RECORD LEVEL 2LG 90% IF <35% FOLLOW SOLUTION			
SV	118 MAKE-UP PROCEDURE FOR N-27-D			
SP	119 ADJUST SV TO 68" (3495 G)			
CP	120 RECORD PH 10.7. 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 11.1. ASSUME 50%	20	7-D	10
	122 OPERATOR STEP PB			
	123 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9			
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)	9.7	9.0-10.0	8:10
	14/47 (60 MIN)	9.65	9.0-10.0	8:40
	15/48 (2 HRS)	9.55	9.0-10.0	9:40
	16/49 (3 HRS)	9.5	9.0-10.0	10:40
	17/50 (FINISH)	7.4	7.5-8.5	11:25
	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	
DRUM	130 WEIGH INTO 55 GAL DRUM	ASSUME 50%	56	7-D 28
6	131 FILL WITH WATER & STIR 2 MIN			
	132 SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	133 SP STEP 23/53 - RECORD: PH 3.5 (3.3-3.7)			
SP	134 IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
A	135 RECORD: PH			
CP	136 NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7	137 *F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
	138 STIR 5 MIN AFTER EACH ADDITION.			
	139 SIF IN	150	128-A	150
	140 SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
	141 RECORD: PH 3.8 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH 4.1			
	(DILUTE 10 TO 1 WITH WATER)	ASSUME 77%		
	SIPHON N-7-D INTO SV	ASSUME 50%	14	27-D 7
	142 OPERATOR STEP PB			
	143 SP STEP 24/54 - POUR IN & STIR 15 MIN	22	978-A	22
	144 OPERATOR STEP PB			
	145 SP STEP 60 - BATCH COMPLETE			
	146 OPERATOR STEP PB			
	For 93 Press	2000	7-D	1000
	START TIME SP STEP	FINISH TIME SP STEP	OPTR	
	2:00P	3:00P	235-37	
	11:00P	7:00P	201-27	
	7:00A	12:05PM	235-320	



N32123.02

