

LOT NOV-18 80 37933

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 7A M

TYPED BY: FP 11/3/80

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	-----

TOTAL EST'D WGT 3332

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	240	983-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 3:20 AM	2400		
	FIN 4:20 AM			
	4 ADJUST TO 75" (1275 G)			
	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			
205	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 4:55 PM TOTAL MINUTES 165			
	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 2 (V-243) OR POSITION 7 (V-244)			
&	13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
CP	14 REMOTE (TEMP IS SET AT 190-194°F)			
3	15 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 32% PRESET #1 80 GAL	15-A		160
	B. 13LG 34% PRESET #6 135 GAL	20-A		135
	16 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM	27-D		206
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.35			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM	983-D		1376
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.82			

HOMOG # 3. 1ST PASS

USE FLOW CONTROLLER

N34717

146 OPERATOR STEP PB
 320 147 RECORD LEVEL 2LG 76% IF BELOW 35% FOLLOW SOL'N
 SV 148 MAKE-UP PROCEDURE FOR N-27-D
 SP 149 ADJUST SV TO 48" (2470 G)
 CP 150 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)
 4 151 SIPHON INTO SV. RECORD: PH 11.3. ASSUME 50% 20 724 1-D 20
 152 OPERATOR STEP PB

153 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0
 SV 154 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 155 OPERATOR STEP PB
 156 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 157 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
 158 OPERATOR STEP PB
 159 DURING STRIKE RECORD:

SP STEP
 V-243/V-244

	PH	RANGE	TIME
13/46 (30 MIN)	9.5	9.0-10.0	8:25 PM
14/47 (60 MIN)	9.5	9.0-10.0	8:55
15/48 (2 HRS)	9.4	9.0-10.0	9:55
16/49 (3 HRS)	9.4	9.0-10.0	10:55
16/49 (4 HRS)	9.3	9.0-10.0	11:55
17/50 (FINISH)	7.0	7.5-8.5	12:40 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

160 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 161 ADD IN 7-8 MIN 350 530-A 350
 339 162 ADJ TO 49" (382 G) AT 80-100°F
 6 163 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
 164 STIR 15 MIN OR LONGER FOR SP STEP 26
 165 RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL
 166 SET PRESET #8 TO 38.2 GAL FROM S 33

302 167 RUN 30" (360 G) WATER INTO V-302 DR AT 244 80
 7 168 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 724 80

169 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 170 SIFT IN 100 128-A 100
 SV 171 SP STEP 23/53. RECORD: PH 3.8 (3.7-4.2)
 SP 172 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
 MIN
 8 173 RECORD: PH 9.4 (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)
 174 OPERATOR STEP PB
 175 SP STEP 29/58. RECORD: PH 9.3 & TIME ____
 176 OPERATOR STEP PB
 177 SP STEP 60. BATCH COMPLETE.

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
8:30 PM		3:00 PM		381-223
2:00 PM		11:00 PM		322-322
11 PM		1:30		282



