

CG 03 CODE KY-795-D PKG
LOT

001-21 80 37516

PROCESSES APPROVED BY
() KY-795-D (H) FWP 10/14/80
() (XOB-17: 3/4
() N-32-D & 240
() MIN STRIKE)
()

STANDARD HRS. 8.2 TIME 7A M

TYPED BY: FWP 10/14/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	<u>13182</u>	93	<u>2200</u>	14	YC002B		93	
14	YC002B	<u>13178</u>	93	<u>1300</u>	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 438

LEAVE ONE STUMP ONLY
Homog 3-151

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N-CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	475	32-D	475
3	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
1	RECORD: START <u>12:08</u> LOT <u>13182</u>	<u>44</u>		
	FIN <u>1:13</u> <u>13178</u>	<u>26</u>		
4	4 ADJUST TO 75" (1275 G)			
5	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
6	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
7	7 RECORD: V-205 VOL <u>40</u> " & ADJ TO 60" (2100 G)			
8	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			
2	RECORD: TIME START <u>1:15A</u> TOTAL MINUTES <u>135</u>			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
11	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 5 (V-243) OR POSITION 10 (V-244)			
3	13 PRESS SV CAM RESET PB - SET 22 TO IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. TILG <u>70%</u> PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: BFC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM		27-D	296
	BFC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
	SPR10 (N-27-D/WATER) RATIO 1.04			
	BFC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM		32-D	1885
	BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	BFC20 (N-32-D WATER) IN REMOTE			
	SPR10 (N-32-D/WATER) RATIO 1.59			

4380
3500
880

She

N35029

USE
LBS

N

CODE

USE

LBS

1.244

146 OPERATOR STEP PB
 117 RECORD LEVEL 2LG 88% IF <35% FOLLOW SOLUTION
 SV MAKE-UP PROCEDURE FOR N-27-D
 SP 118 ADJUST SV TO 58" (2980 G)
 CP 119 RECORD PH 10.4 ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50%
 120 OPERATOR STEP PB

20

721

20

121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8
 SV 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 123 OPERATOR STEP PB 5:55A
 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)	9.6	9.0-10.0	6:25
14/47 (60 MIN)	9.6	9.0-10.0	6:55
15/48 (2 HRS)	9.55	9.0-10.0	7:55
16/49 (3 HRS)	9.5	9.0-10.0	8:55
16/49 (4 HRS)	9.45	9.0-10.0	9:55
17/50 (FINISH)	7.7	7.5-8.5	10:40

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 128 WEIGH INTO 55 GAL DRUM ASSUME 50% 50 7-B 28
 6 129 FILL WITH WATER & STIR 2 MIN FLAKE 28 721

130 SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.
 SV 131 SP STEP 23/53 - RECORD: PH 3.3 (3.3-3.7)
 SP 132 IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7
 & RECORD: PH ____ 15-A
 CP NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140
 7 *F IN DRUM. USE 30 GAL WATER TO 50% N-15-A.
 STIR 5 MIN AFTER EACH ADDITION.

133 SIFT IN 150 128-A 150
 134 SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR
 5 MIN

135 RECORD: PH 3.6 (4.0-4.2) & IF NECESSARY ADJ TO
 PH 4.0-4.2 & RECORD: PH 4.0 ASSUME 77%
 (DILUTE 10 TO 1 WITH WATER) AT FLAKE 15 721-D 15

SIPHON N-7-D INTO SV

136 OPERATOR STEP PB

137 SP STEP 24/54 - POUR IN & STIR 15 MIN 22 978-A 22

138 OPERATOR STEP PB

139 SP STEP 60 - BATCH COMPLETE

140 OPERATOR STEP PB

START
TIME SP STEP

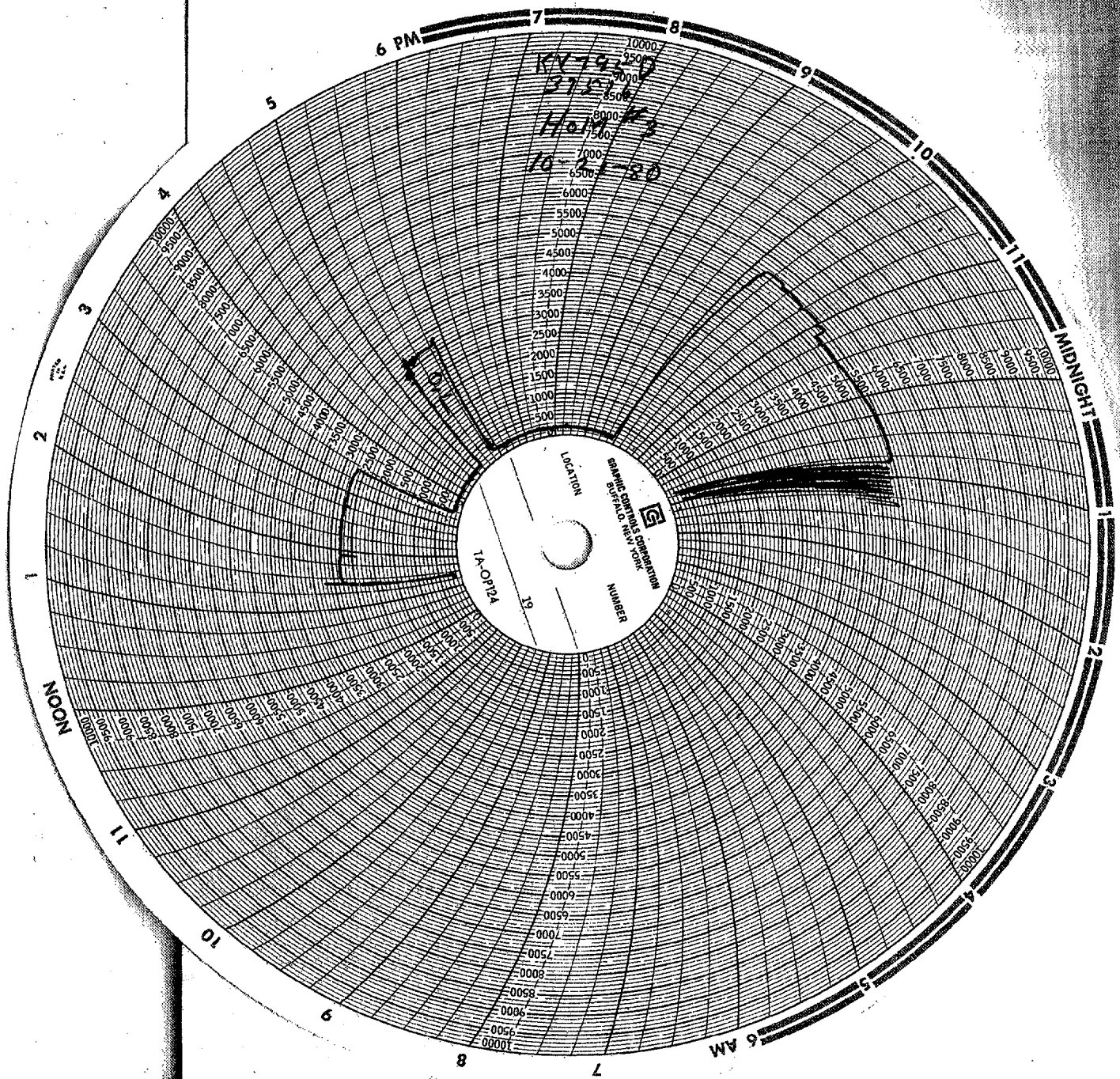
FINISH
TIME SP STEP

OPTR

7:15 A
7:20 A

7:00 A
7:45 A.M.

120-126
235-244



244

