(AUTOMATED) PUNCHED & CHECKED MAKING INSTRUCTIONS: BATCH UNIT
S.V. 243, 244 C.V. D.V.

JUN 17 1983

CG 03 CODE KY-787-D PKG
LOT 36080 JUNE 11

EST'D WGT 1090 LBS

STANDARD HRS. 8.9 TIME 11 PM

OK
AP

PROCESSES APPROVED BY
( ) KY-787-D (Q) FWP 5/20/80
( ) ( )
( ) ( )
( ) ( )
( ) ( )
TYPED BY: FP 5/20/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	24287	93	2400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

Homog # 4 - 1ST Pass

(1)

TOTAL EST'D WGT 3490 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.			
	2	WEIGH IN DRUM & POUR IN	320	32-D	320
	3	DUMP IN AND STIR 5 MIN LOT	48X50	YC-2-B	2400
		RECORD: START 7:10 PM / 24287 8	2400		
1		FIN 8:45 PM			
	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 42" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	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 1:00 PM TOTAL MINUTES 130			
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 2 (V-243) OR POSITION 7 (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 88 % PRESET #1 80 GAL		15-A	160
		B. 13LG 44 % PRESET #6 135 GAL		20-A	135
	15	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			
		3FR10 (N-27-D/WATER) RATIO 0.64			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM		32-D	1840
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 0.83			

TJW

EQUIP		PAGE 2 CG 03 KY-787-D EST WGT 3490# V-243	USE LBS	N-CODE	USE LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 86% IF BELOW 35% FOLLOW SOL'N			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 48" (2470 G)			
CP	19	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 11.2. ASSUME 50%	20	7-D	10
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9.			
SV	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	23	OPERATOR STEP PB			
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD: 530 P			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.8 9.0-10.0 600 P			
		14/47 (60 MIN) 9.8 9.0-10.0 630 P			
		15/48 (2 HRS) 9.8 9.0-10.0 730 P			
		16/49 (2 HRS, 25 MIN) 9.8 9.0-10.0 755 P			
		17/50 (FINAL 3 HRS) 7.4 7.5-8.5 830 P			
		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	___
	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
	29	ADD IN 7-8 MIN	350	530-A	350
339	30	ADJ TO 49" (382 G) AT 80-100*F			
6	31	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26			
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	34	SET PRESET #8 TO 38.2 GAL FROM S 33			
302	35	RUN 30" (360 G) WATER INTO V-302			
7	36	ADD & STIR 2 MIN FOR S 40 ASSUNE 50%	160	7-D	80
	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	38	SIFT IN	100	128-A	100
SV	39	SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)			
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
		MIN			
8	41	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)			
	42	OPERATOR STEP PB			
	43	SP STEP 29/58. RECORD: PH 9.4 & TIME 945 P			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
10 PM	___	11 PM	___	54-120
11:00 P	___	7:00 A	___	235-B23
300 P	___	945 P	___	259

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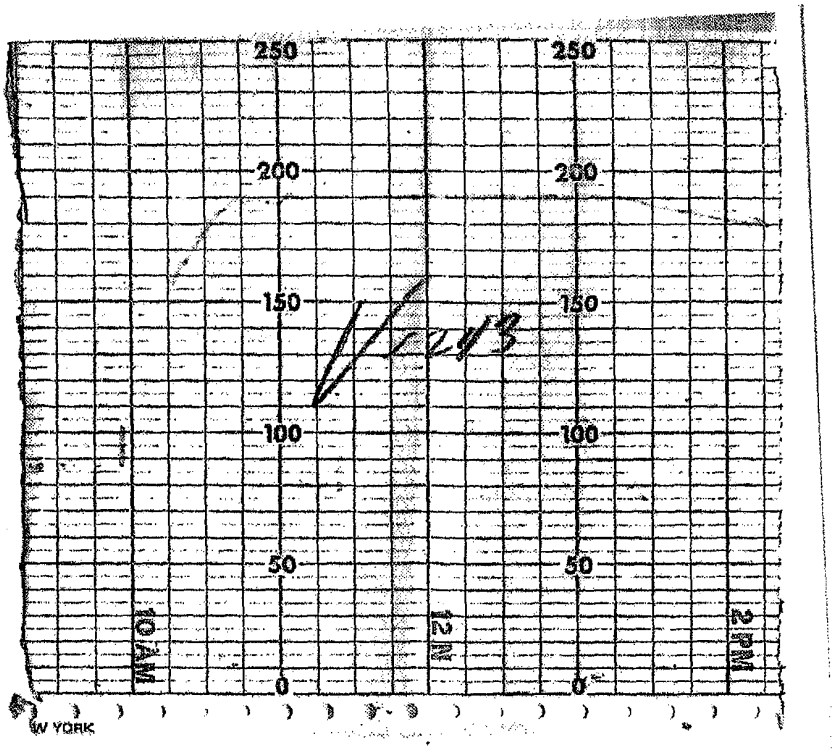

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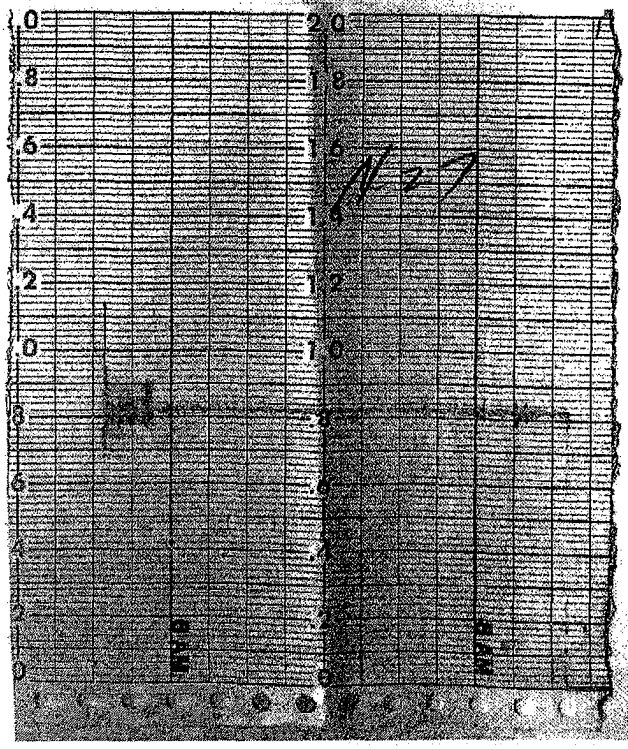

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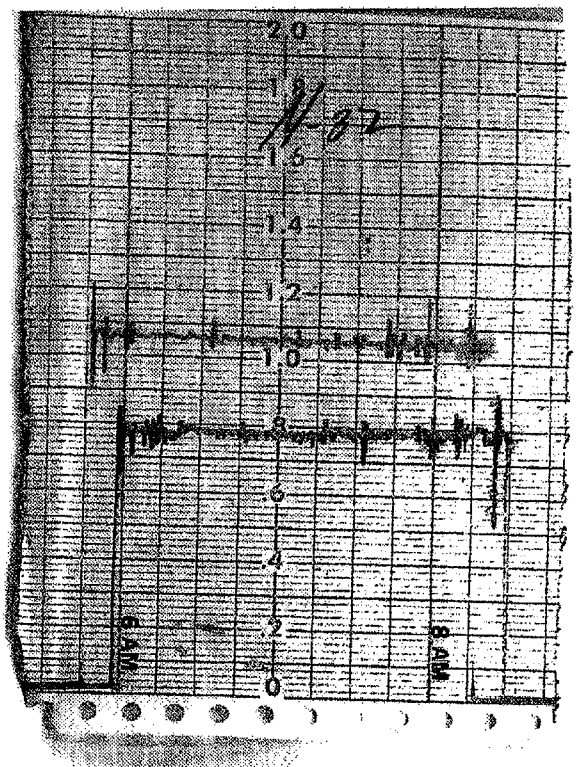

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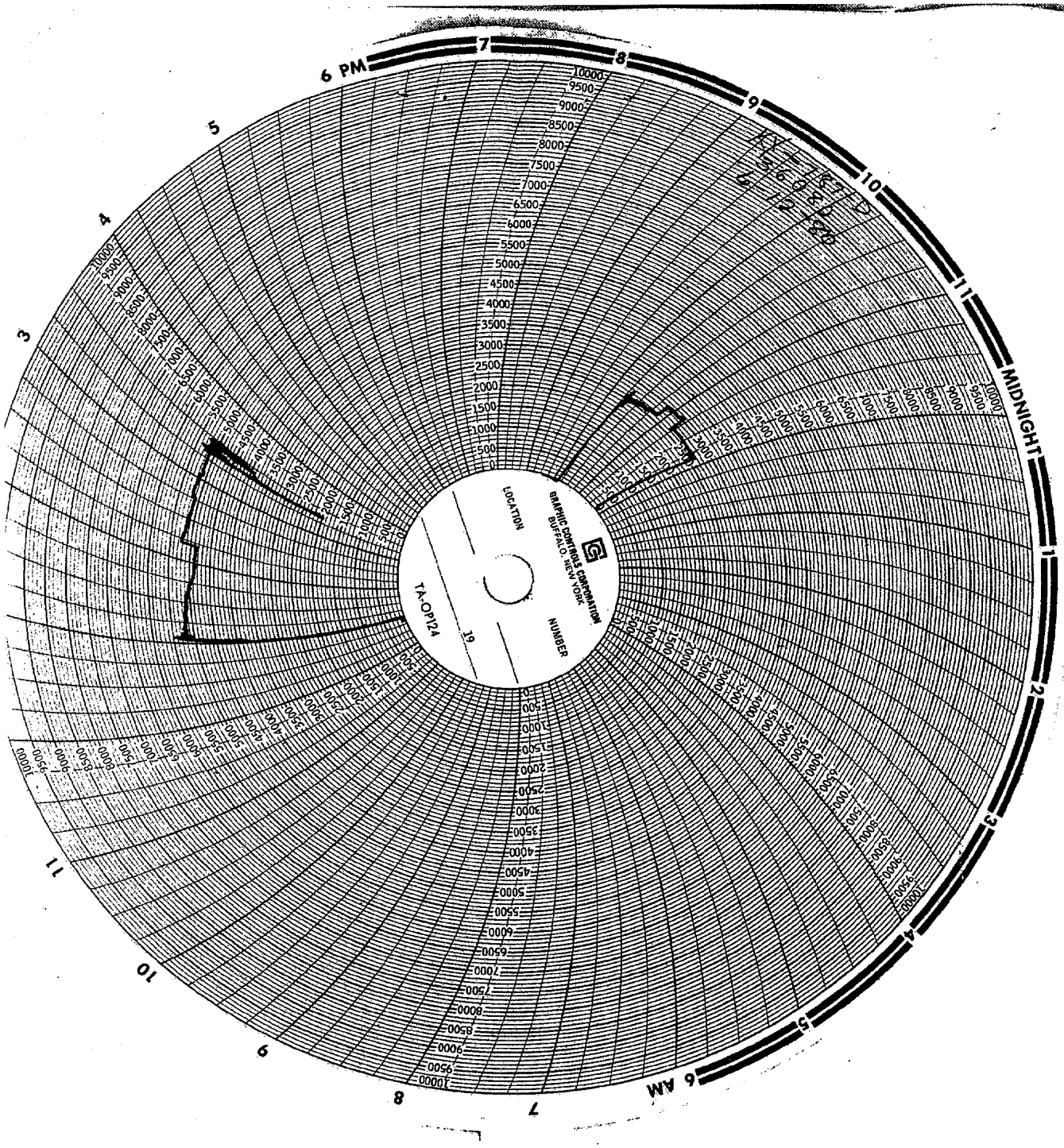

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