

CG 03 CODE KY-787-D PKG

LOT 134-12-00 37806

EST'D WGT 932 LBS

STANDARD HRS. 8.9

TIME

PROCESSES

APPROVED BY

() KY-787-D (Q) FWP 11/3/80

() () (XOB-17: 25%

() () LESS N-32-D

() () & 240 MIN

() () STRIKE)

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	13193	93	2000
14	YC002B	13192	93	400
14	YC002B		93	

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

CLEAN UP
AS YOU GO ALONG

TOTAL EST'D WGT 3332

7 MIN-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 12:30 PM 13193	2000		
	FIN 1:13 AM 13172	400		
	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 4.2 & 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 10:30 AM TOTAL MINUTES 1.35			
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	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
CP	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 50 % PRESET #1 80 GAL	15-A		160
	B. 13LG 38 % PRESET #6 135 GAL	20-A		135
	15 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			
	3FC10 (N-27-D/WATER) RATIO 1.35			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM	983-D		1376
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	3FC20 (N-32-D WATER) IN REMOTE			
	3PR10 (N-32-D/WATER) RATIO 1.82			

N34760

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USE N- USE

DUP050105206

EQUIP		PAGE 2	243	LBS	CODE	LBS
320	16	OPERATOR STEP PB				
SV	17	RECORD LEVEL 2LG 92% IF BELOW 35% FOLLOW SOL'N				
SP	18	MAKE-UP PROCEDURE FOR N-27-D				
CP	19	ADJUST SV TO 48" (2470 G)				
	20	RECORD PH 9.8 ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)		20	721	20
4	21	SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50%				
	22	OPERATOR STEP PB				
SV	23	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5				
SP	24	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
	25	OPERATOR STEP PB				
5	26	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB				
	27	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE				
	28	OPERATOR STEP PB				
	29	DURING STRIKE RECORD: 8:40				
		SP STEP				
		V-243/V-244				
		13/46 (30 MIN)	9.0	9.0-10.0	3:10	
		14/47 (60 MIN)	9.0	9.0-10.0	3:40	
		15/48 (2 HRS)	9.3	9.0-10.0	4:40	ACID OFF 10 MIN
		16/49 (3 HRS)	9.1	9.0-10.0	5:40	
		16/49 (4 HRS)	9.0	9.0-10.0	6:40	
		17/50 (FINISH)	9.1	7.5-8.5	7:45 PM	7:45
		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
128	30	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339		350	530-A	350
33	31	ADD IN 7-8 MIN				
8	32	ADJ TO 49" (382 G) AT 80-100°F				
	33	STIR 5 MIN & RECORD: PH 10.0 (9.5-10.5)				
	34	STIR 15 MIN OR LONGER FOR SP STEP 26				
	35	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL				
	36	SET PRESET #8 TO 382 GAL FROM S 33				
302	37	RUN 30" (360 G) WATER INTO V-302 2 DRUMS BOTTLED				
7	38	ADD & STIR 2 MIN FOR S 40 ASSUME 50%		160	7-D	80
	39	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.				
	40	SIFT IN		100	128-A	100
SV	41	SP STEP 23/53. RECORD: PH 3.4 (3.7-4.2)				
SP	42	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN				
8	43	RECORD: PH 9.3 (9.0-9.5). ADJ IF NECESSARY & RECORD: PH ____ ASSUME 77%				27-D
	44	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%				7-D
	45	(SIPHON N-7-D INTO SV)				
	46	OPERATOR STEP PB				
	47	SP STEP 29/58. RECORD: PH 9.3 & TIME 9-P				
	48	OPERATOR STEP PB				
	49	SP STEP 60. BATCH COMPLETE.				
		46 pump 240 VAT				
		START TIME SP STEP		FINISH TIME SP STEP		OPTR
		11:00P		7:00A		126-259
		7:00A		3:00P		322-244
		3:00P		9:00P		282-223

