

CG 03 CODE KY-788-D PKG

LOT MAY -0-81-21314

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 5/14/80

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JOB NAME 03KY788DHJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	14024	93	2600	14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	

03 127781D 82946-1 98 50

DO NOT USE YC-3-B LOTS 14001 THRU 14004

1st Pass - #3

TOTAL EST'D WGT 3560 3610

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	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 DUMP IN AND STIR 5 MIN	345	32-D	345
1	3 RECORD: START 7:30 AM FIN 7 AM	52X50 2600	YC-3-B	2600
263	4 ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205	14024		
	5 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205	82946-1		
	6 RECORD: V-205 VOL " & ADJ TO 60" (2100 G)	1 x 50		50
	7 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	8 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	9 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	10 RECORD: TIME START 5:40 PM TOTAL MINUTES 12:00			
	11 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	12 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP & CP	13 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)			
3	14 PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
	15 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 6.6% PRESET #2 208 GAL	15-A		416
	B. 13LG 7.2% PRESET #6 135 GAL	20-A		135
	16 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM	27-D		180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
	3FB10 (N-27-D/WATER) RATIO 0.8			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM	32-D		1215
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.1			

EQUIP

PAGE 2 CG 2 KY-788-D EST WGT 3560#

USE
LBSN-
CODEUSE
LBS

V-244

16	OPERATOR STEP PB			
320	17 RECORD LEVEL 2LG 6% IF <35% FOLLOW SOLUTION			
SV	18 MAKE-UP PROCEDURE FOR N-27-D			
SP	19 ADJUST SV TO 47" (2400 G)			
CP	20 RECORD PH 10.0. ADJ TO 11.0-11.2 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4	21 SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50%	210	7-D	20
	22 OPERATOR STEP PB			

SV	21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH			
SP	22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	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: SP STEP			
	V-243/V-244			
	PH RANGE TIME			
	13/46 (30 MIN) 9.6 9.3-10.0 10:05			
	14/47 (60 MIN) 9.6 9.3-10.0 10:25			
	15/48 (2 HRS) 9.5 9.3-10.0 11:35			
	16/49 (2 HRS, 25 MIN) 9.4 9.3-10.0 12:00			
	17/50 (FINAL 3 HRS) 7.3 7.5-8.5 12:55			
	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.			
	& RECORD: PH		27-D	
	ASSUME 77%			

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 26/56			
	33 RECORD: VOL 1" & CALC 1" X 0.78 = 0.78 GAL			
	34 SET PRESET #8 TO 38.2 GAL FROM S 33			

302	35 RUN 40" (440 G) WATER INTO V-302			
7	36 ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180

37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
38	SIET IN	100	128-A	100
SV	39 SP STEP 23/53. RECORD: PH 3.3 (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 9.3 (9.0-9.5). ADJ IF NECESSARY & RECORD: PH		27-D	
	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 77%		7-D	
	(SIPHON N-7-D INTO SV) ASSUME 50%			
	42 OPERATOR STEP PB			
	43 SP STEP 29. RECORD: PH 9.2 & TIME 1:45 AM			
	44 OPERATOR STEP PB			
	45 SP STEP 60. BATCH COMPLETE.			

START
TIME SP STEP

11:20 F

FINISH
TIME SP STEP

11:00 AM
11:45 AM

OPTR

120-409
225-244