

CG 03 CODE KY-787-D PKG

LOT

OCT 13 1980 37340

EST'D WGT 932

LBS

STANDARD HRS. 8.9

TIME 7A M

PROCESSES

APPROVED BY

() KY-787-D (Q) FWP 9/23/80
 () (XOB-17: 25%
 () LESS N-32-D
 () & 240 MIN
 () STRIKE)

TYPED BY: FP 9/23/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13098	93	2420	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

CM

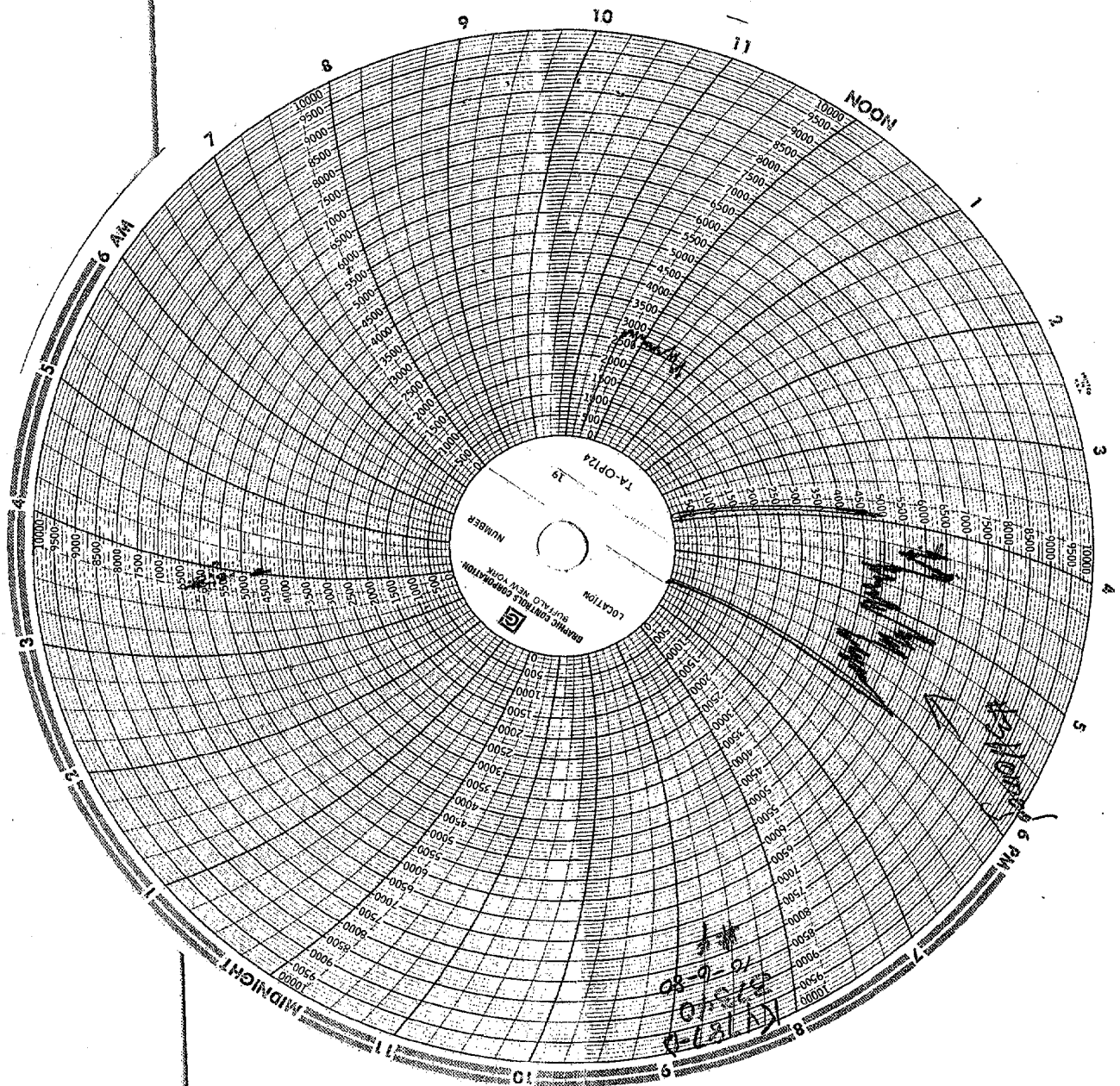
Homog 4-1st Pass
" 8-3-204 "

TOTAL EST'D WGT 3332

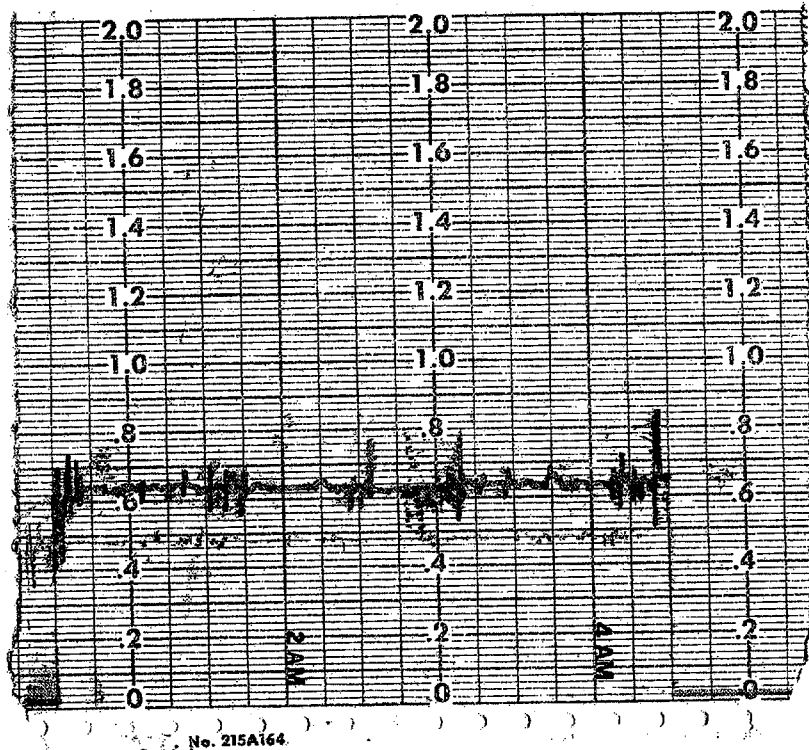
NON-BLEEDING

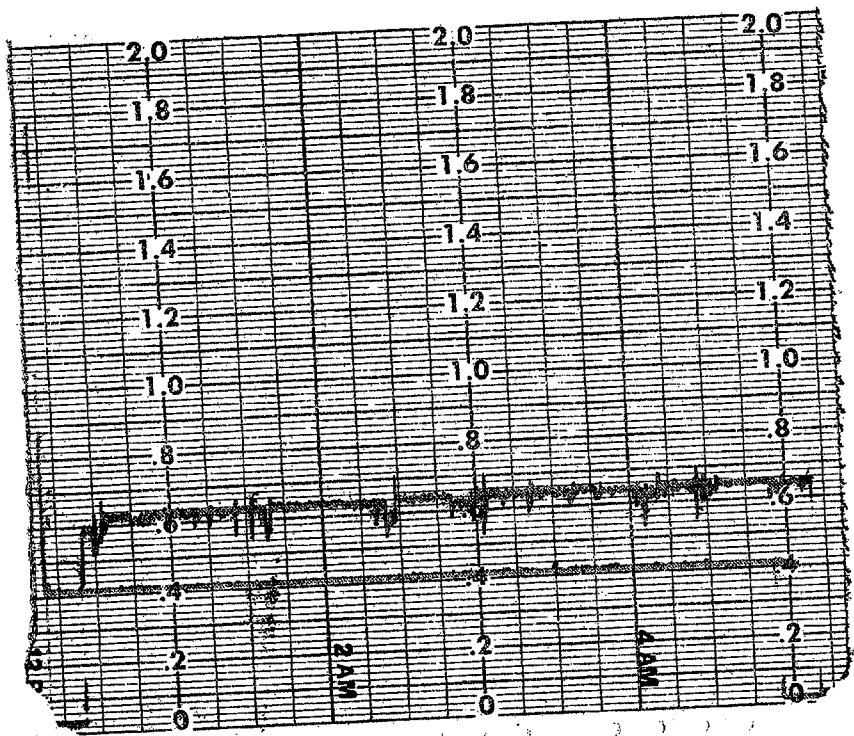
EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	240	32-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 7:15 PM LOT 13098			
	FIN 9:00 PM			
	4 ADJUST TO 75" (1275 G)			
	5 WITH 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 43 " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-244 START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 4:00 PM TOTAL MINUTES 120			
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 73% PRESET #1 80 GAL		15-A	160
	B. 13LG 38% PRESET #4 135 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			
	3FR10 (N-27-D/WATER) RATIO 1.35			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		32-D	1376
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	3FC20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.82			

EQUIP	PAGE 2	CG 03	KY-787-D	EST WGT 3332#	USE LBS	N- CODE	USE LBS
V-244							
116	OPERATOR STEP PB						
320	RECORD LEVEL 2LG 69% IF BELOW 35% FOLLOW SOL'N						
SV	MAKE-UP PROCEDURE FOR N-27-D						
SP	ADJUST SV TO 48" (2470 G)						
CP	RECORD PH 10.2 ADJ TO 11.1-11.3 WITH N-7-D AT						
4	5% (10 PARTS WATER TO 1 PART N-7-D)						
	SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50%	24		7-D		12	
120	OPERATOR STEP PB						
124	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9						
SV	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO						
SP	OPERATOR STEP PB						
24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS						
	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB						
5	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						
	13/46 (30 MIN)	PH 9.7	RANGE 9.0-10.0	TIME 9:45			
	14/47 (60 MIN)	PH 9.65	RANGE 9.0-10.0	TIME 10:15			
	15/48 (2 HRS)	PH 9.6	RANGE 9.0-10.0	TIME 11:15			
	16/49 (3 HRS)	PH 9.6	RANGE 9.0-10.0	TIME 12:15			
	16/49 (4 HRS)	PH 9.6	RANGE 9.0-10.0	TIME 1:15			
	17/50 (FINISH)	PH 8.0	RANGE 7.5-8.5	TIME 2:00			
	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	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339						
129	ADD IN 7-8 MIN				350	530-A	350
339	ADJ TO 49" (382 G) AT 80-100*F						
6	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)						
132	STIR 15 MIN OR LONGER FOR SP STEP 26						
133	RECORD: VOL 49 " & CALC 49 " X 0.78 = 38.2 GAL						
134	SET PRESET #8 TO 38.2 GAL FROM S 33						
302	RUN 30" (360 G) WATER INTO V-302						
7	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	160		7-D		80	
37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.						
38	SIFT IN						
SV	SP STEP 23/53. RECORD: PH 3.8 (3.7-4.2)	100		128-A		100	
SP	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5						
	MIN						
8	RECORD: PH 9.3 (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 9.3 & TIME 3:15 AM						
44	OPERATOR STEP PB						
45	SP STEP 60. BATCH COMPLETE.						
	START	FINISH	OPTR				
	TIME SP STEP	TIME SP STEP					
	3:00 PM	11:00 PM	2:35				
	11:00 AM	3:50 AM	201 438				

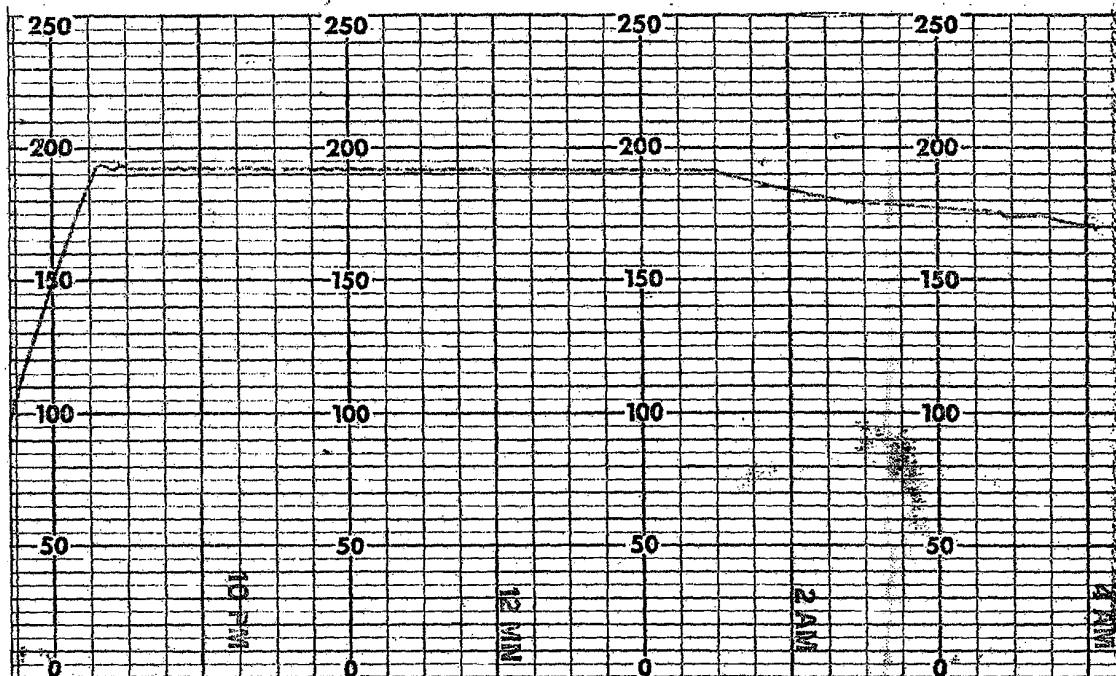


V-244





No. 215A164



No. 215A250

DUP050105820