

1/25/82

A2 K 73

(DATE)

LOT NUMBER

STANDARD HRS. 8.9

TIME ----- M

JOB NAME 03KY787DMT

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	M1U62	93	2500	14	YC002B	-----	93	-----
14	YC002B	-----	93	-----	14	YC002B	-----	93	-----
14	YC002B	-----	93	-----	14	YC002B	-----	93	-----

DO NOT USE LOTS 13839 - 13855

TOTAL EST'D WGT 3394* LBS.

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	250	32-D	250
	3 DUMP IN AND STIR 5 MIN	50X50	YC-2-B	2500
	RECORD: START <u>11:30 PM</u> LOT <u>M1U62</u>	2500		
	FIN <u>12:30 PM</u>			
205	1 ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER			
	THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	2 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	HOMOG AT 2400-2600 PSI INTO V-205			
	3 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	OF HOT WATER AT 2400-2600 PSI INTO V-205			
	4 RECORD: V-205 VOL <u>42</u> & ADJ TO 60" (2100 G)			
	5 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	1 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 <u>11:30 PM</u> TOTAL MINUTES <u>95</u>			
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 <u>100</u> % PRESET #1 32 GAL	115-A		168
	B. 13LG <u>52</u> % PRESET #6 141 GAL	20-A		141
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM	27-D		213
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.31			
	8FC10 (N-32-D CONTROLLER) IN MANUAL .84 GPM	32-D		1425
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.76			

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16 OPERATOR STEP PB
320 17 RECORD LEVEL 2LG 6.2 % IF BELOW 35% FOLLOW SOL'N
SV 18 MAKE-UP PROCEDURE FOR N-27-D
SP 18 ADJUST SV TO 48" (2470 G)
CP 19 RECORD PH 10.1 ADJ TO 11.1-11.3 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 20 SIPHON INTO SV. RECORD: PH 11.3. ASSUME 50% 28 7-D 14
20 OPERATOR STEP PB

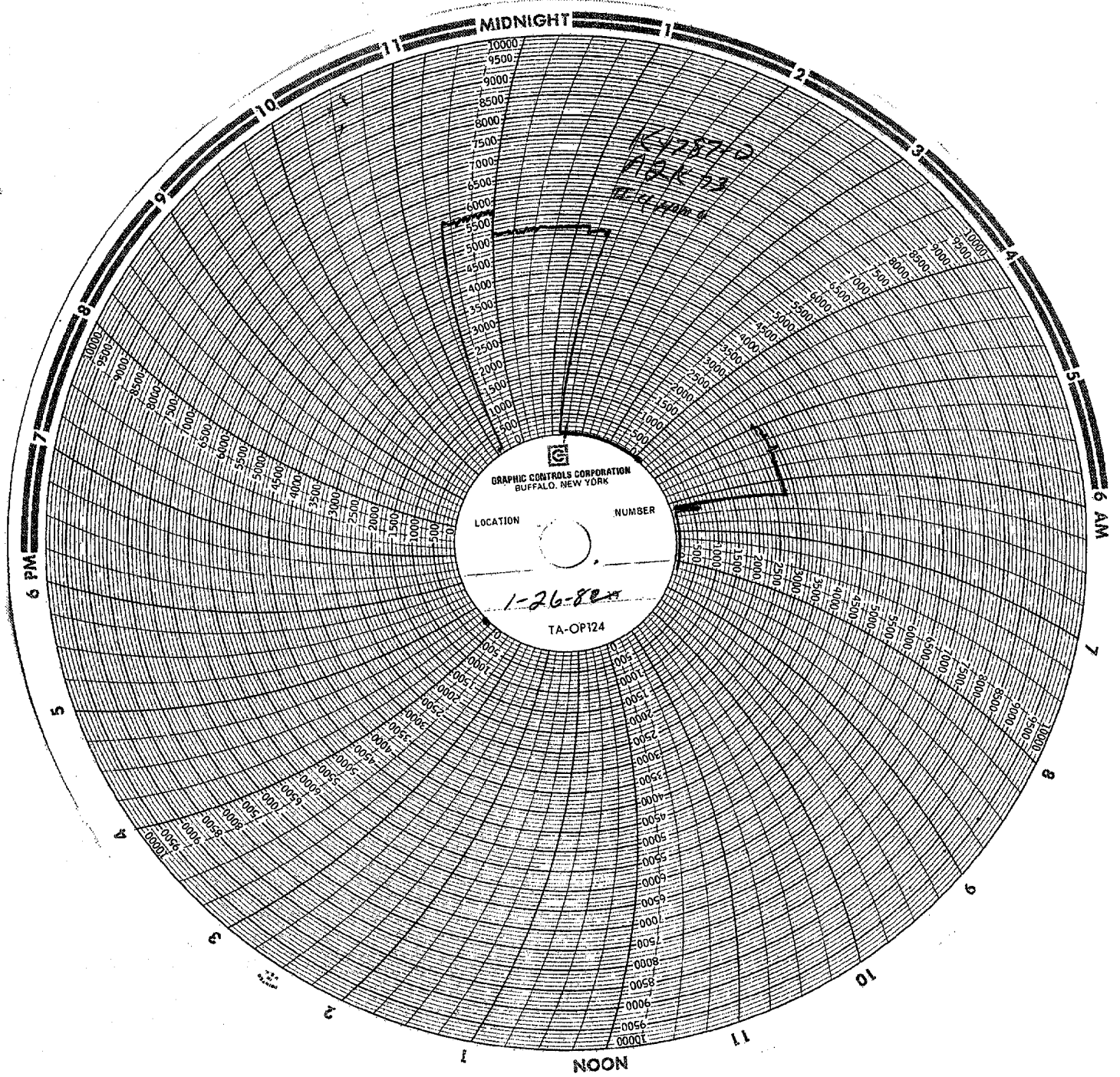
21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.6
22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
23 OPERATOR STEP PB
24 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 25 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
26 OPERATOR STEP PB
27 DURING STRIKE RECORD:
SP STEP
V-243/V-244
PH RANGE TIME
13/46 (30 MIN) 9.5 9.0-10.0 3:55 AM
14/47 (60 MIN) 9.5 9.0-10.0 4:25 AM
15/48 (2 HRS) 9.5 9.0-10.0 5:25 AM
16/49 (2 HRS, 25 MIN) 9.5 9.0-10.0 5:50 AM
17/50 (FINAL 3 HRS) 9.6 7.5-8.5 6:35 AM
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 ____

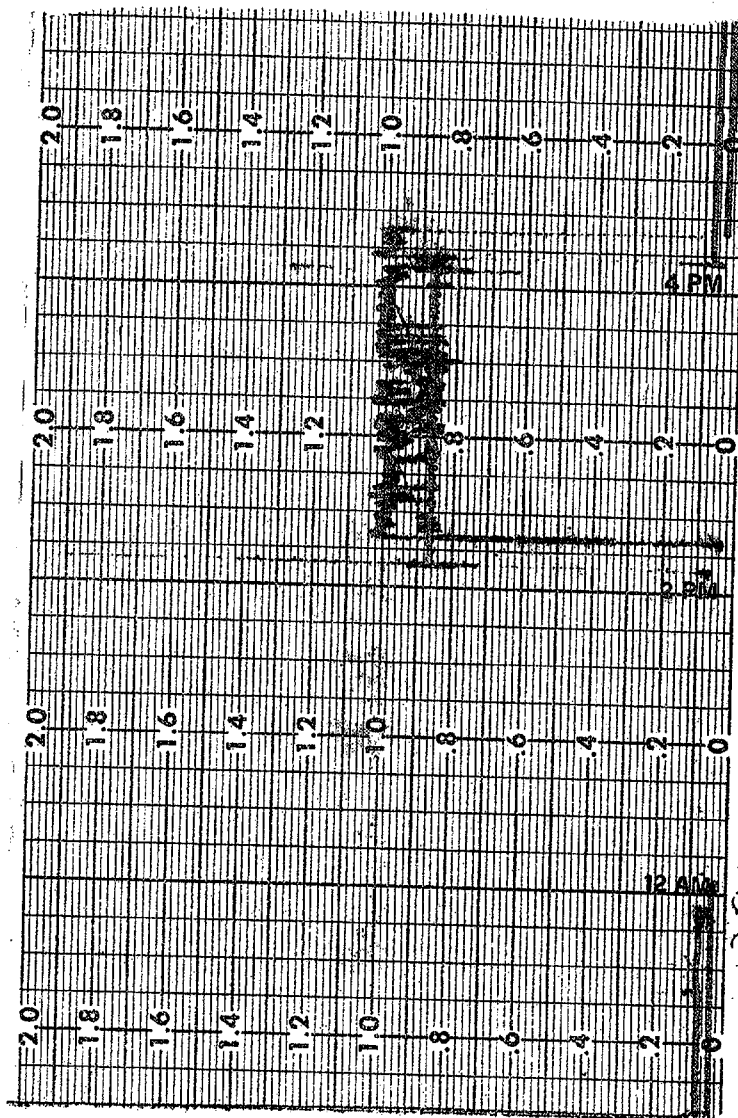
128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
129 ADD IN 7-8 MIN 365 330-A 365
339 130 ADJ TO 49" (382 G) AT 80-100*F
6 131 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
132 STIR 15 MIN OR LONGER FOR SP STEP 26
133 RECORD: VOL 49 " & CALC 49 " X 0.78 = 38.6 GAL
134 SET PRESET #8 TO 20.2 GAL FROM S 33

385 135 RUN 47" (360 G) WATER INTO V-385
7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

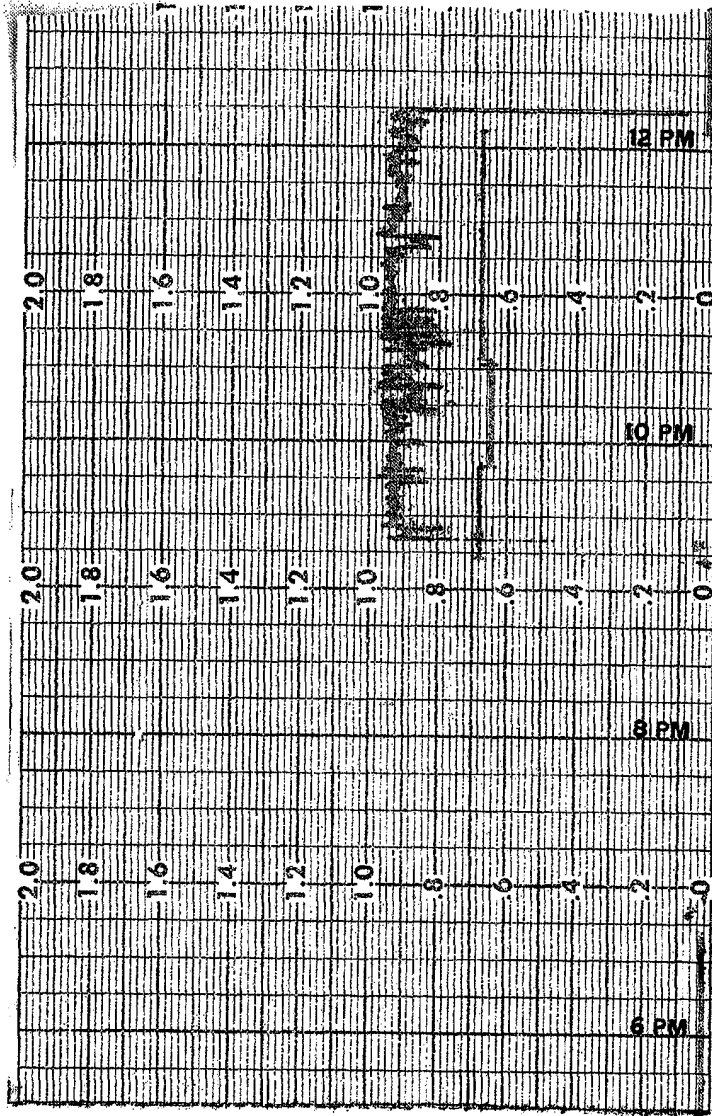
137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
138 SIFT IN 100 125-A 100
SV 139 SP STEP 23/53. RECORD: PH 2.7 (3.7-4.2)
CP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
8 141 RECORD: PH 9.1 (9.0-9.5). ADJ IF NECESSARY &
RECORD: PH ____ ASSUME 77% ____ 27-D ____
(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% ____ 7-D ____
(SIPHON N-7-D INTO SV)
142 OPERATOR STEP PB
143 SP STEP 29/58. RECORD: PH 9.0 & TIME 8:00A
144 OPERATOR STEP PB Pump to J-240
145 SP STEP 60. BATCH COMPLETE.

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
<u>11:00 AM</u>	____	<u>11:05 AM</u>	____	<u>22-144</u>
<u>1:00 PM</u>	____	____	____	<u>259-320</u>

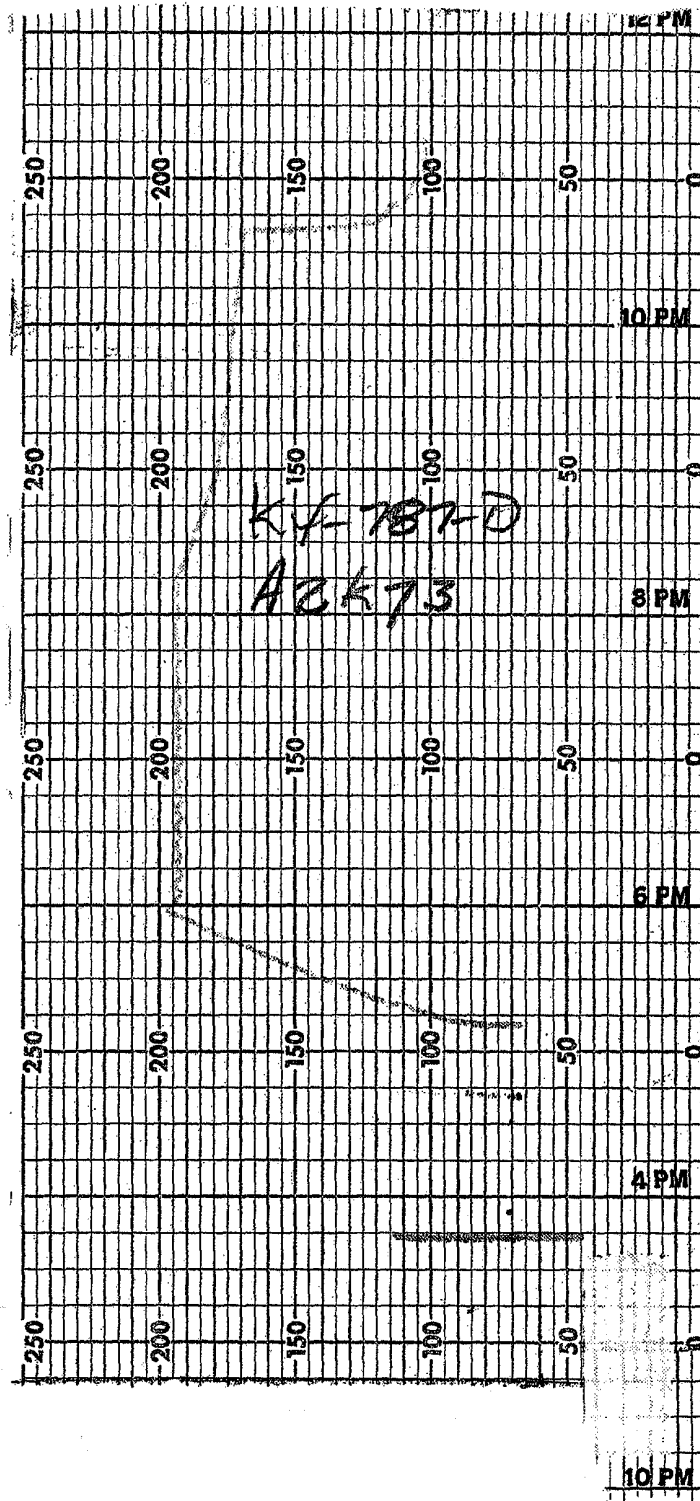




PRINTED IN U.S.A.



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