

CAUTION (ED)
S.V. 244

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-781-D PKG
LOT JUN 30 1980
JUN 27 36300
EST'D WGT 1128 LBS
STANDARD MRS. TIME 7P M

PROCESSES APPROVED BY
() KY-781-D (N) FWP 6/20/80
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()
()
()
TYPED BY: FWP 6/20/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	

JUN 25 1980

TOTAL EST'D WGT 4428

NON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
203	RUN 60" (990 G) WATER IN V-203 & ADD ASSUME 50% & SET AGITATOR ON HIGH SPEED.	36	7-D	18
205	WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN RECORD: START 12 PM FIN 3 PM	442 66X50 3300	32-D YC-3-B	442 3300
	ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205 RECORD: V-205 VOL " & ADJ TO 45" (1662 G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
SV	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 12:45P TOTAL MINUTES 120 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	SP STEP 01 - SET FORMULA SELECTOR TO POSITION & 1 (V-243) OR POSITION 6 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO. REMOTE (TEMP IS SET AT 190-194°F)			
3	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 58% PRESET #3 187 GAL		15-A	374
115	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.9 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM 3FR10 (N-27-D/WATER) RATIO 0.7 3FC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM 3FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM 3FC20 (N-32-D WATER) IN REMOTE 3FR10 (N-32-D/WATER) RATIO 0.7		27-D 32-D	373 252 2527

To
UAT-263

UAT
263

(Jhe)

(Jhe)

V-244

LB5 P CODE LB5

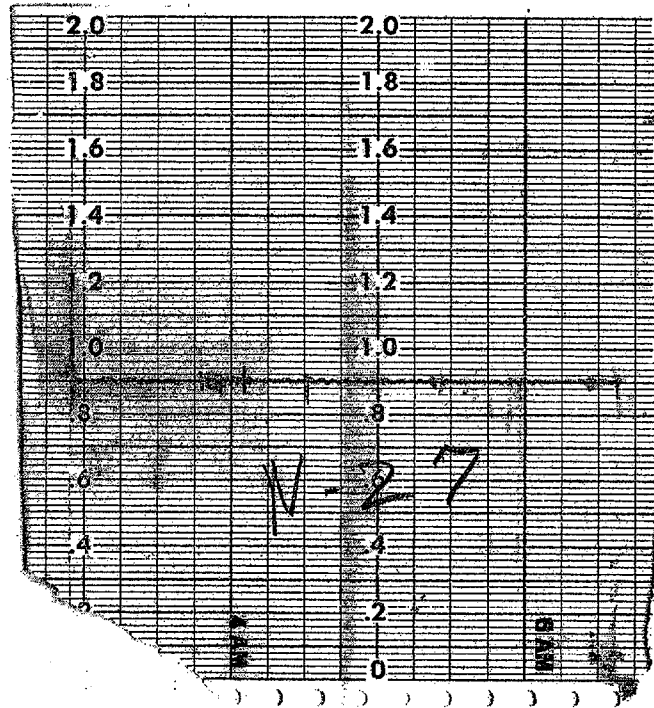
116	OPERATOR STEP PB			
117	RECORD LEVEL 2LG 73% IF <35% FOLLOW SOLUTION			
SV	MAKE-UP PROCEDURE FOR N-27-D			
SP	ADJUST SV TO 54" (2800 G)			
CP	RECORD PH 10.4, ADJ TO 11.4-11.6 WITH N-7-D AT			
	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	SIPHON INTO SV. RECORD: PH 11.4 • ASSUME 50%	36	7-D	18
120	OPERATOR STEP PB			
121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
SV	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	OPERATOR STEP PB			
124	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			
126	OPERATOR STEP PB			
127	DURING STRIKE RECORD:			
	SP STEP			
	V-243/V-244			
	13/41 (30 MIN)	9.8	9.3-10.0	5:15
	14/47 (60 MIN)	9.8	9.3-10.0	5:45
	15/48 (2 HRS)	9.8	9.3-10.0	6:45
	16/49 (3 HRS)	9.75	9.3-10.0	7:45
	17/50 (FINAL)	8.0	7.5-8.5	8:30
	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
302	RUN 31" (379 G) WATER INTO V-302			
128	ADD & STIR 5-MIN	ASSUME 50%	124	7-D 62
129	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
SV	SIFT IN	✓	150	128-A 150
132	SP STEP 23/53.			
133	RECORD PH 3.4 (3.3-3.7) & IF NECESSARY ADJ			15-A
	(DOWN ONLY) TO 3.3-3.7 & RECORD: PH ____			
	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
	*F IN DRUM, USE 30 GAL WATER TO 50#			
	N-15-A. STIR SV 5 MIN AFTER EACH ADDITION			
SP	RUN IN N-7-D FROM S 29" IN 10-12 MIN & STIR 5			
	MIN			
7	RECORD: PH 4.0 (4.2-4.4). ADJ IF NECESSARY &			
	RECORD: PH 4.3 ASSUME 77%			
	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	32	27-D	16
	(SIPHON N-7-D INTO SV)			
136	OPERATOR STEP PB			
137	SP STEP 24/54 - ADD & STIR 5 MIN	✓	20	978-A 20
138	OPERATOR STEP PB			
139	SP STEP 60. BATCH COMPLETE.			

4:45 PM

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
7:00A	3:00P	126-259
3:00DP	9:30P	235

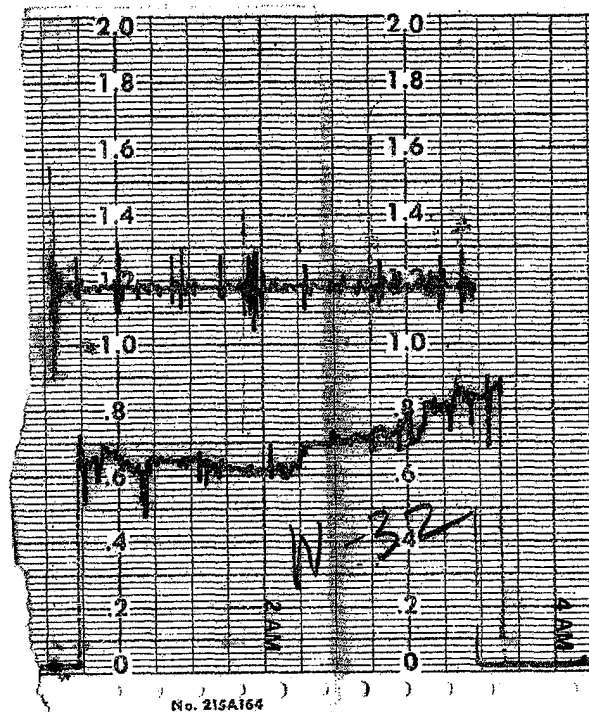
VAT 244 Rec'd 1230P

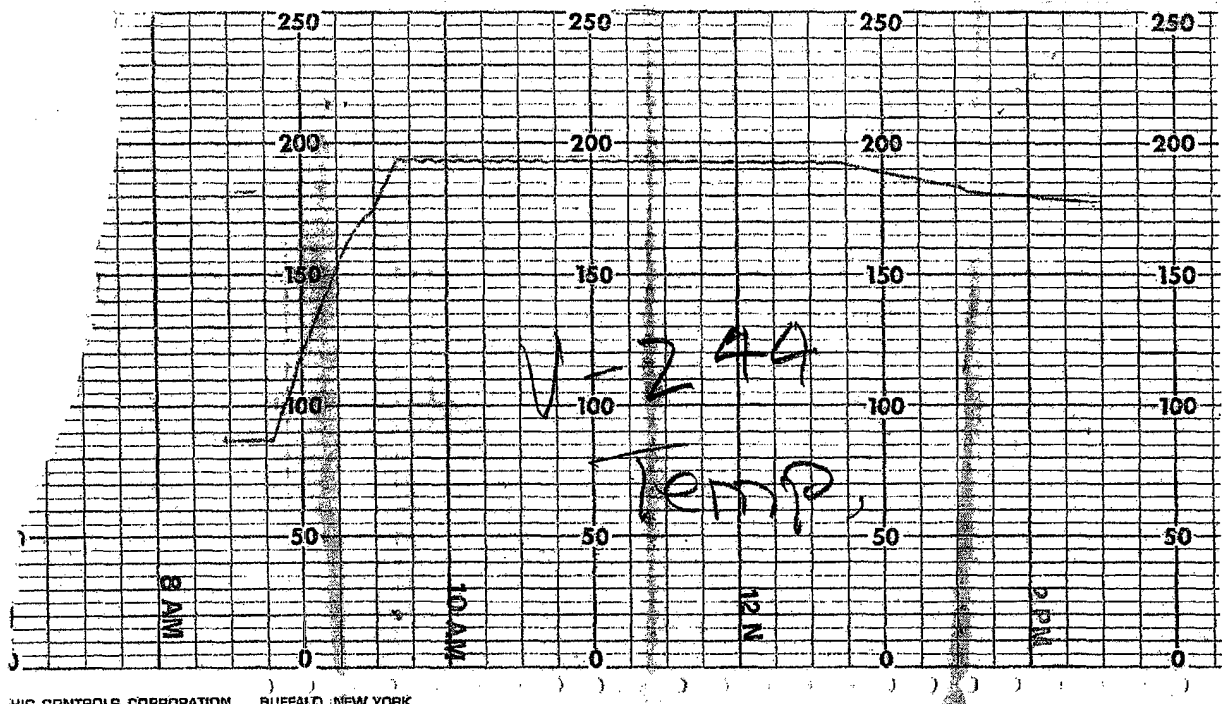
TIME	SP STEP	STEP
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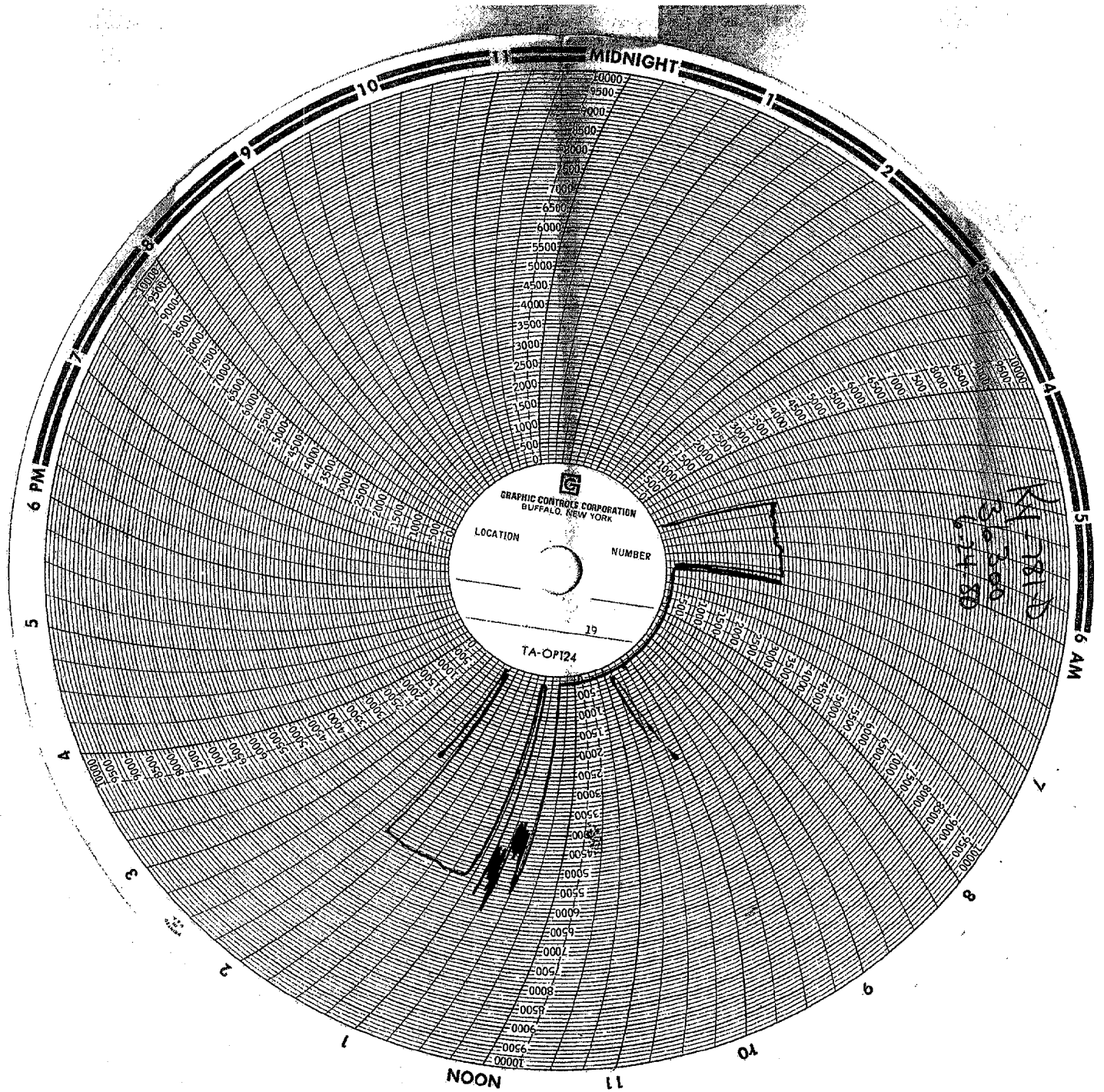
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DUP050457201





HIC CONTROLS CORPORATION BUFFALO, NEW YORK



N32233.02

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V-244