

PUNCHED & CHECKED
CONVERTED FROM MANUAL STRIKE TO AUTO.

(AUTOMATED)
S.V. (243), 244

MAY - 5 1980
C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-795-D PKG
LOT 35596 MAY-1-1980

PROCESSES APPROVED BY
() KY-795-D (H) FWP 4/23/80

EST'D WGT 4440 938 LBS

STANDARD HRS. 1.1 TIME 3 PM

TYPED BY: FWP 4/23/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	24776	93	1700	14	YC002B		93	
14	YC002B	24788	93	2000	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

by NemoC red PASS

TOTAL EST'D WGT 4442 4638

NON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN	475	32-D	475
	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3900
	RECORD: START	24788		
	FIN	24776		
	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 48" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-203. START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 9 AM TOTAL MINUTES 152			
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 & CP	12 SET STEP 01 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (V-244)			
	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 20% PRESET #1 110 GAL		15-A	200-220
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.75 GPM		27-D	574 312
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 6.7 GPM			
	2PR10 (N-27-D/WATER) RATIO 0.8			
	BFC10 (N-32-D CONTROLLER) IN MANUAL 0.95 GPM		32-D	2475
	BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.7 GPM			2000
	BPR20 (N-32-D WATER) IN REMOTE			
	BPR10 (N-32-D/WATER) RATIO 1.0			

243

SV	16	OPERATOR STEP PB			
SP	17	RECORD LEVEL 2LG 65% IF (35% FOLLOW SOLUTION			
CP	18	MAKE-UP PROCEDURE FOR N-27-D			
	19	ADJUST SV TO 68" (3495 G)			
	20	RECORD PH 11.2 ADJ TO 11.1-11.3 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	40	7-D	20
	20	OPERATOR STEP PB			

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
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 1 PM			
		13/46 (30 MIN) 9.8 9.0-10.0 11.30			
		14/47 (60 MIN) 9.8 9.0-10.0 21.00			
		15/48 (2 HRS) 9.7 9.0-10.0 31.00			
		16/49 (3 HRS) 9.65 9.0-10.0 41.00			
		17/50 (FINISH) 7.1 7.5-8.5 41.45			
		NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE			
		IN LOG. IF FINAL PH > 8.5, ADJ TO 7.5-8.5.			
		A RECORD: PH --- ASSUME 77%		27-D	

DRUM	28	WEIGH INTO 55 GAL DRUM	ASSUME 50%	160	7-D	30
6	29	FILL WITH WATER & STIR 2 MIN.				

SV	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SP	31	SP STEP 23/53 - RECORD: PH 3.7 (3.3-3.7)			
&	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
CP		RECORD: PH ---		15-A	
7		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
		*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			
	33	SIFT IN	150	128-A	150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR			
		5-MIN			
	35	RECORD: PH 4.0-4.2 & IF NECESSARY ADJ TO			
		PH 4.0-4.2 & RECORD: PH --- ASSUME 77%		27-D	
		(DILUTE 10 TO 1 WITH WATER) ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN & STIR 15 MIN	45	978-A	45
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	44	OPERATOR STEP PB			

START
TIME SP STEP

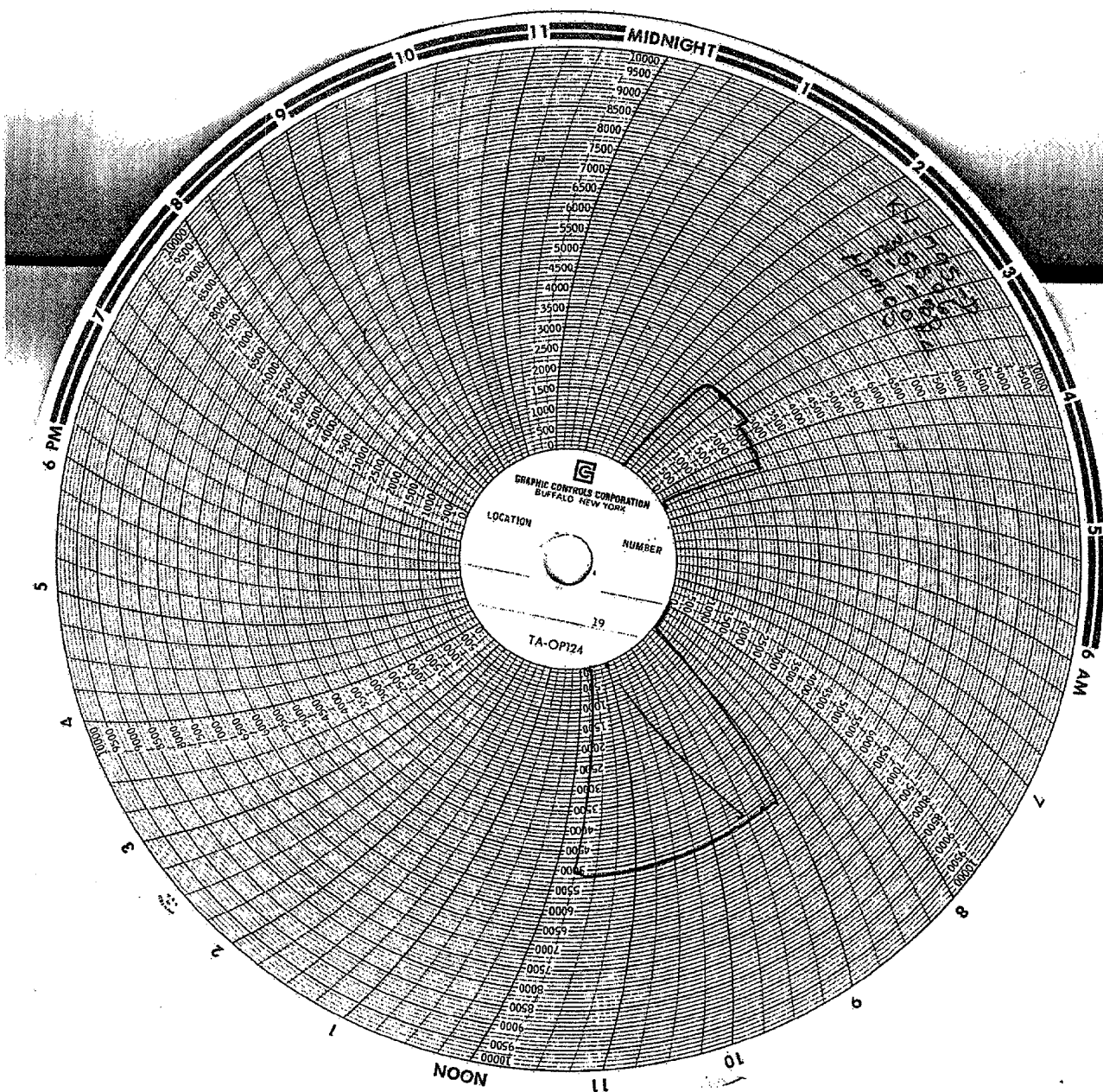
FINISH
TIME SP STEP

OPTR

9 PM

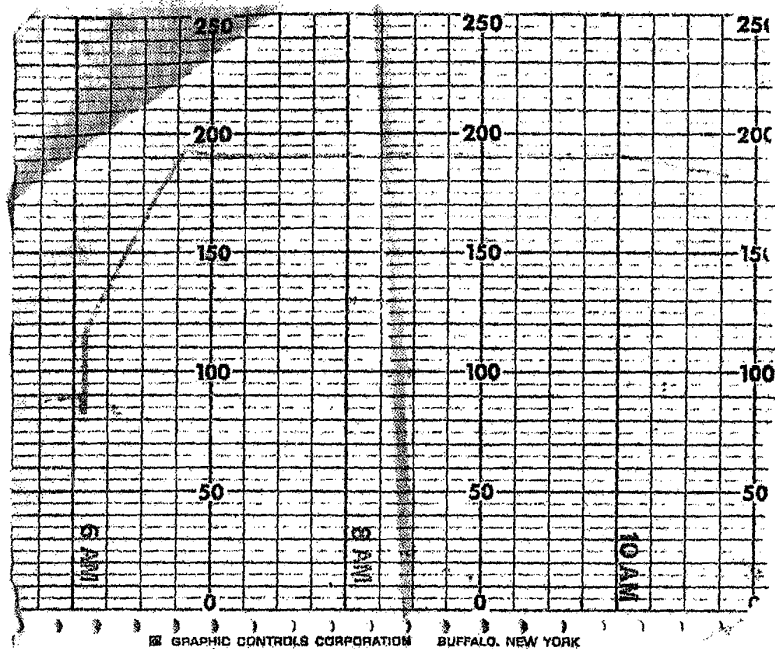
5:15 P

282
720



DUP050456691

N32115.01



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