

CG 03 CODE KY-787-D PKG PROCESSES APPROVED BY
 LOT NOV-6 80 377800000 & 000000000 () KY-787-D (Q) FWP 11/3/80
 EST'D WGT 932 LBS () (XOB-17: 25%
 STANDARD HRS. 8.9 TIME 11:12 M () LESS N-32-D
 () & 240 MIN
 () STRIKE)
 TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13193	93	2400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YE002B		93		14	YC002B		93	

NOV 11 1980

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.			
203	2 WEIGH IN DRUM & POUR IN	240	983-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 13193	2400		
	FIN			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-263			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-263			
	7 RECORD: V-263 VOL 58" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	9 RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	10 PUMP V-203 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 6:45 PM TOTAL MINUTES 200			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
V-263	11 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP 142	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 50% PRESET #1 80 GAL		15-A	160
	B. 13LG 79% PRESET #6 135 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		983-D	1376
	3FR20 (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			

N-244

130	17	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 74% IF BELOW 35% FOLLOW SOL 'N			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	18	ADJUST SV TO 48" (2470 G)			
	19	RECORD PH 9.6. 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 11.4 ASSUME 50%	30	7-D	15
	20	OPERATOR STEP PB			

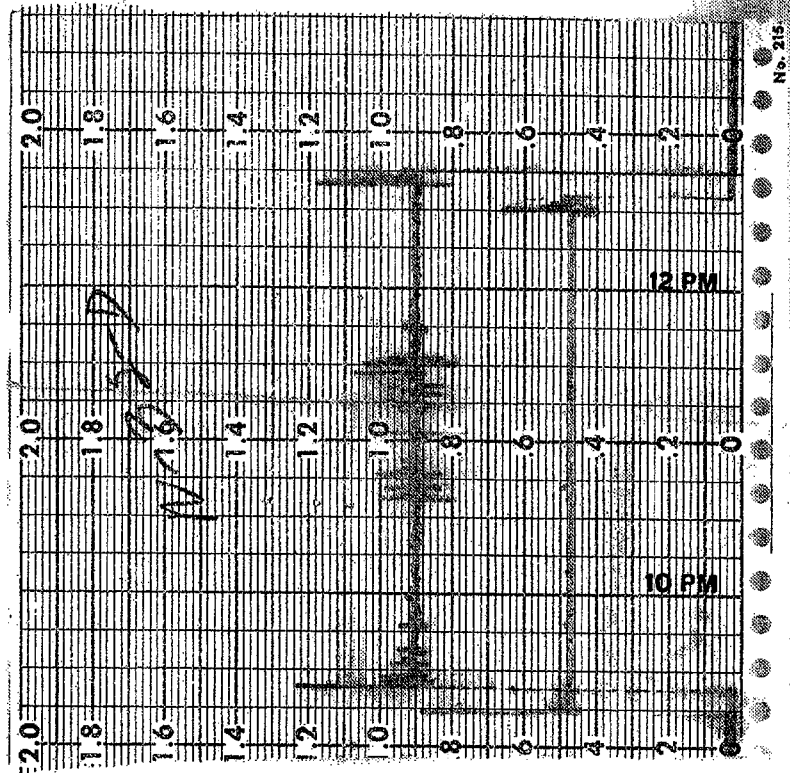
SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.15			
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	23	OPERATOR STEP PB			
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 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 9.0-10.0 1.15/A			
		14/47 (60 MIN) 9.5 9.0-10.0 1.45/A			
		15/48 (2 HRS) 9.3 9.0-10.0 2.45/A			
		16/49 (3 HRS) 9.3 9.0-10.0 3.45/A			
		16/49 (4 HRS) 9.0 9.0-10.0 4.45/A			
		17/50 (FINISH) 7.5 7.5-8.5 5.30/A			
		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	

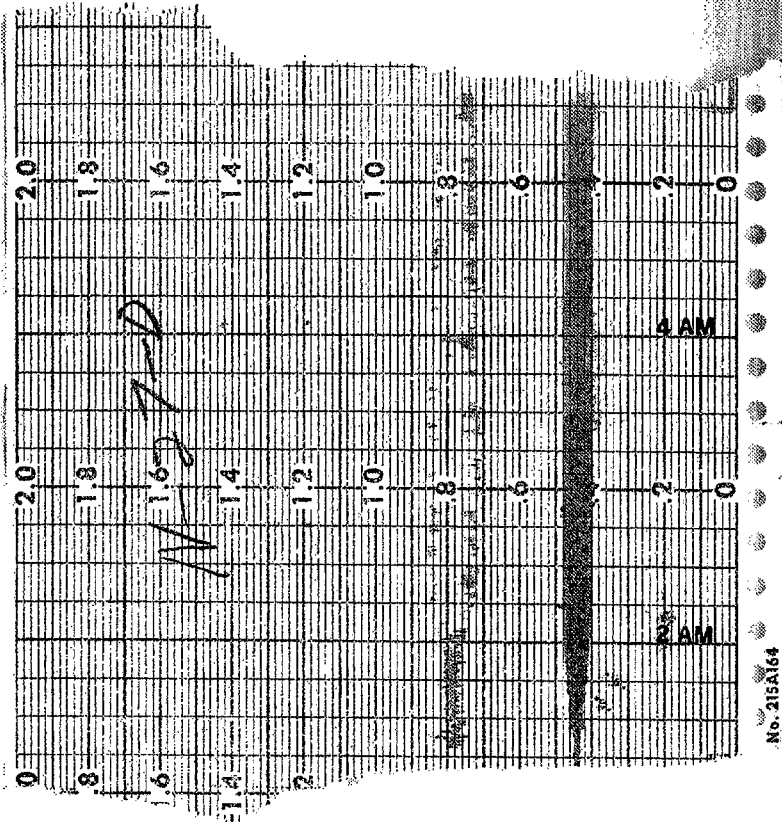
128	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
129	29	ADD IN 7-8 MIN	350	530-A	350
339	30	ADJ TO 49" (382 G) AT 80-100*F			
6	31	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26			
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	34	SET PRESET #8 TO 38.2 GAL FROM S 33			

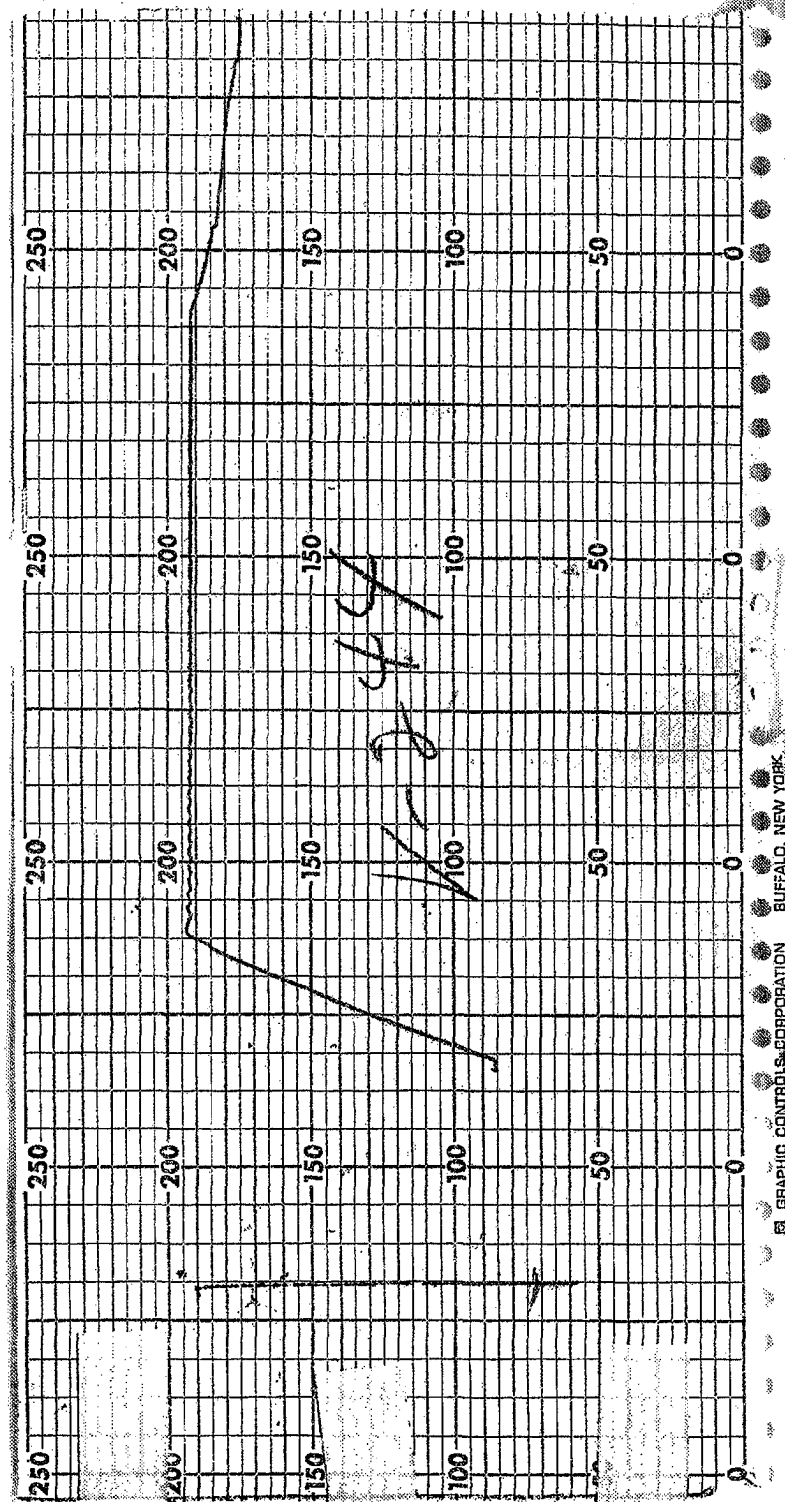
302	35	RUN 30" (360 G) WATER INTO V-302			
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	160	7-D	80

SV	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	38	SIFT IN	100	128-A	100
SP	39	SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)			
	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
		MIN			
8	41	RECORD: PH 9.65 (9.0-9.5). ADJ IF NECESSARY &			
		RECORD: PH 9.2 ASSUME 77%	6	27-D	5
		(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 9.1 & TIME 6:50 A.M.			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
3:00		11:00		120.30
3:00		6:50 A.M.		223
11:00				54-101







GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

