

(AUTOMATED)
S.V. 243

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.CG 03 CODE KY-7B7-D PKG
LOT E1593 MAY 21 1981

PROCESSES APPROVED BY

() KY-7B7-D (T) FWP 4/30/81

STANDARD HRS. 8.9 TIME _____ M

JOB NAME 03KY7B7DMT

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	13359	93	2000
14	YC002B	83613-1	93	500
14	YC002B		93	

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

TOTAL EST'D WGT 3464

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 DUMP IN AND STIR 5 MIN	250	32-D	250
	RECORD: START 11:20 PM	50X50	YC-2-B	2500
	FIN 12:10 AM	2000		500
	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 40" & ADJ TO 60" (2100 G)			
✓ 8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 6:58 TOTAL MINUTES 110			
	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 142 SP STEP 01 - SET FORMULA SELECTOR TO POSITION

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& 2 (V-243) OR POSITION 7 (V-244)

CP 143 PRESS SV CAM RESET PB - SET 22 TC IN AUTO

REMOTE (TEMP IS SET AT 190-194°F)

3 144 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:

A. 11LG 8.2% PRESET #1 84 GAL 15-A 168

B. 13LG 5.4% PRESET #6 141 GAL 20-A 141

145 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

8FC40 (N-32-D/WATER) RATIO

1.74

320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 52% IF BELOW 35% FOLLOW SOL'N			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 48" (2470 G)			
	20	RECORD PH 9.0 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 11.3 ASSUME 50%	64	7-D	32
	20	OPERATOR STEP PB			

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8			
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) 9.5 9.0-10.0 4:45			
		14/47 (60 MIN) 9.5 9.0-10.0 5:15			
		15/48 (2 HRS) 9.6 9.0-10.0 6:15			
		16/49 (2 HRS, 25 MIN) 9.8 9.0-10.0 6:40			
		17/50 (FINAL 3 HRS) 7.9 7.5-8.5 7:15			
		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	

4:15/p

	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
	29	ADD IN 7-8 MIN			
339	30	ADJ TO 49" (382 G) AT 80-100#F	365	530-A	365
6	31	STIR 5 MIN & RECORD: PH 9.1 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26			
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2AL			
	34	SET PRESET #8 TO 38.2AL 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

	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	38	SIFT IN	100	128-A	100
SV	39	SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)			
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
8	41	RECORD: PH 9.3 (9.0-9.5). ADJ IF NECESSARY & RECORD: PH --- ASSUME 77% (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% (SIPHON N-7-D INTO SV)		27-D	
				7-D	
	42	OPERATOR STEP PB			
	43	SP STEP 29/58. RECORD: PH 9.3 & TIME 8:40/p			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
7:00	1	7:01A	---	223-342
7:00A	---	3:00P	---	120-301
3:00P	---	8:45P	---	235-244