PUNCHED & CHECKED

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

C.V. MAY - 8 1980

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-795-D PKG
LOT MA'-6 35648

EST'D WGT ~~1410~~ 880 LBS

STANDARD HRS. 8.2 TIME 3P M

012
AP

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

APPROVED BY

COMPONENT CONSUMPTION

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

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

Homog #3-1 ST Pass
1980 #3-2 RD

TOTAL EST'D WGT ~~4612~~ 4380

NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW MEDIUM	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	3500
		RECORD: START 320 Am LOT 24845	2460		
1		FIN 4:30 24777	850		
	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 43 " & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
		RECORD: TIME START 8:10AM TOTAL MINUTES 140			
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	SP 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 69% PRESET #1 104 GAL		15-A	208
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL ~~0~~ GPM	0.71	27-D	~~394~~
		3FC20 (N-27-D WATER) IN MANUAL LOCAL ~~4.7~~ GPM	5.8		296
		3FR10 (N-27-D/WATER) RATIO 0.8			
		8FC10 (N-32-D CONTROLLER) IN MANUAL ~~1.27~~ GPM	0.90	32-D	~~2675~~
		8FC20 (N-32-D WATER) IN MANUAL LOCAL ~~6.2~~ GPM	5.4		585
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.0			

V-244

EQUIP		PAGE 2 CG 03 KY-795-D EST WGT 4612#	USE LBS		JPT
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 64% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 68° (3495 G)			
CP	19	RECORD PH 10.7 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 11.1 ASSUME 50%	26	7-D	13
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.95			
SV	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	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:	12:45 PM		

SP STEP

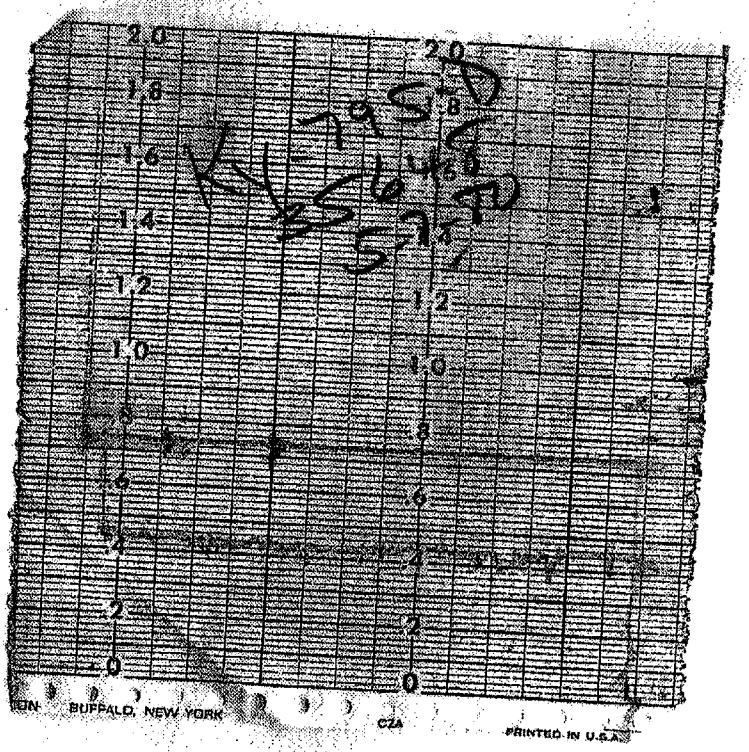
V-243/V-244	PH	RANGE	TIME
13/46 (30 MIN)	9.7	9.0-10.0	1:15
14/47 (60 MIN)	9.7	9.0-10.0	1:45
15/48 (2 HRS)	9.75	9.0-10.0	2:45
16/49 (3 HRS)	9.5	9.0-10.0	3:45
17/50 (FINAL 3 HRS)	7.8	7.5-8.5	4:30

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%

DRUM	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	56	7D	28
6	29	FILL WITH WATER & STIR 2 MIN			
	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	31	SP STEP 23/53 - RECORD: PH 4.2 (3.3-3.7)			
SP	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7	140		140
&		RECORD: PH 3.6.			
CP		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7		*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.		65	
	33	SIFT IN	150		150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
	35	RECORD: PH 4.2 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH ___ ASSUME 77%			
		(DILUTE 10 TO 1 WITH WATER) ASSUME 50%			
		SIPHON N-7-D INTO SV			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN &STIR 15 MIN	22	928	22
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	44	OPERATOR STEP PB			

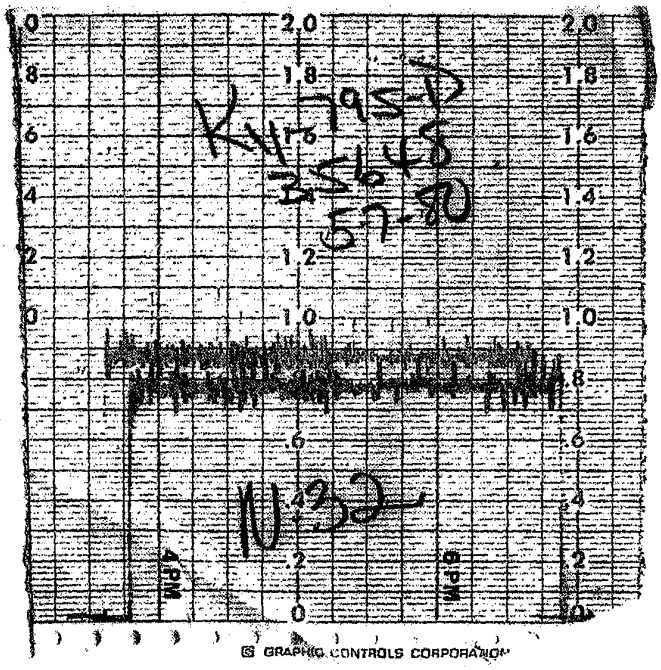
START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
11:00 P	____	7:00 A	____	254
7:10 PM	____	3:20 PM	____	235
3:00 PM	____	5:10 PM	____	381

DUP050456703

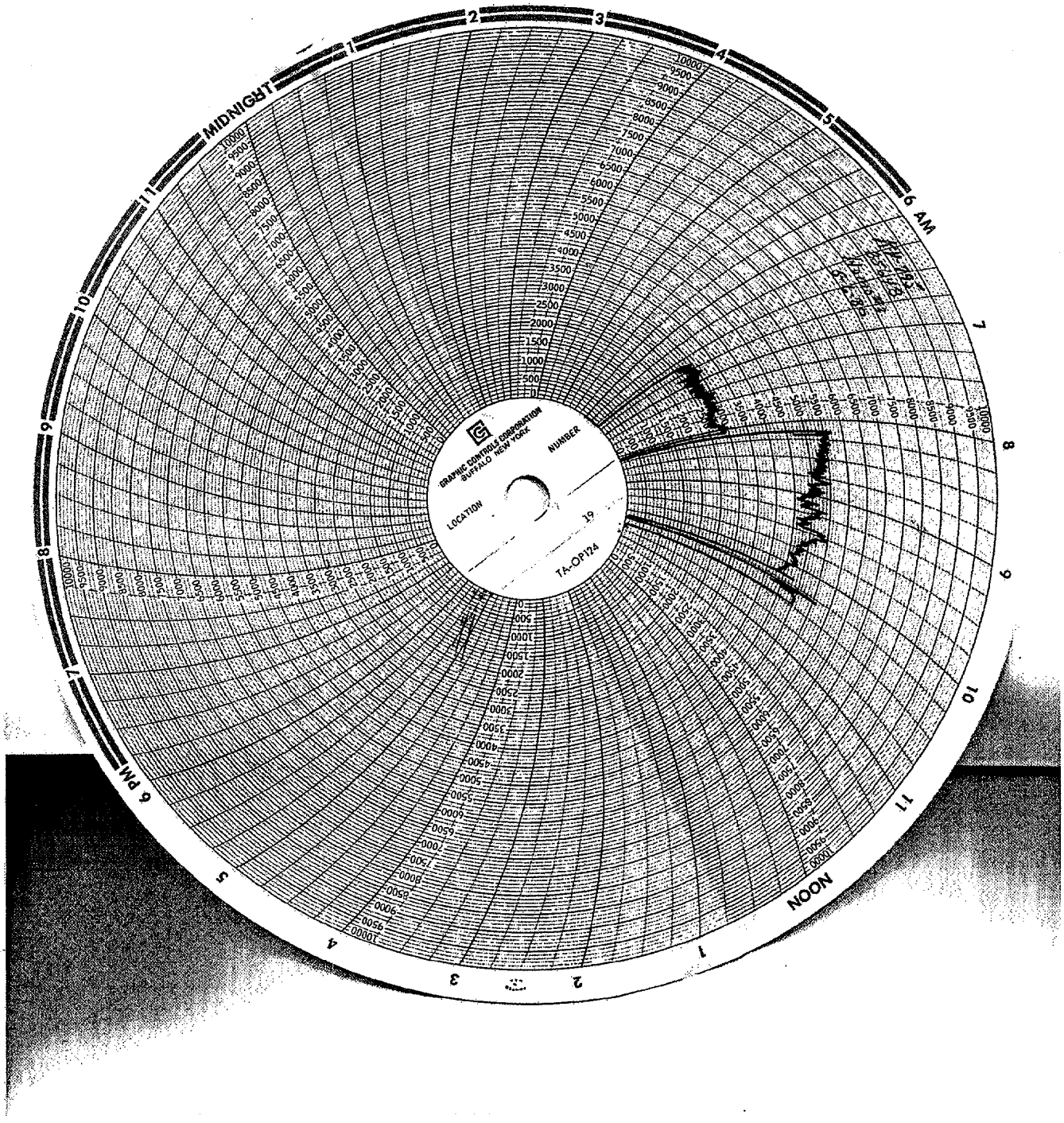


DUP050456704

N32117.01



DUP050456705



N32117.02

DUP050456706



V-249