

CG 03 CODE KY-795-D PKG
LOT OCT-20-80 37501

PROCESSES APPROVED BY
() KY-795-D (H) FWP 10/14/80
() () (XOB-17: 3/4
() () N-32-D & 240
() () MIN STRIKE)
() ()

STANDARD HRS. 8.2 TIME 7A M

TYPED BY: FWP 10/14/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13170	93	3500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

Note: V-32-D strike run ± 1 hr. longer than it should have when control panel did not advance into water flush stage.

TOTAL EST'D WGT 4380

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	475	32-D	475
	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
	RECORD: START 1:35 A.M. FIN 2:30 P.M. LOT 13170	3500		
1	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 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			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 9:15 AM TOTAL MINUTES 165			
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	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)			
CP	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 44% PRESET #1 104 GAL		15-A	208
3	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3PC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM 3PC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM 3PR10 (N-27-D/WATER) RATIO 1.04 BPC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM BPC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM BPR10 (N-32-D/WATER) RATIO 1.59		27-D	296
			32-D	1885

FN

(Handwritten signature)

N35033

V-243

USE LBS N CODE LBS

16 OPERATOR STEP PB
 17 RECORD LEVEL 2LG 100% IF <35% FOLLOW SOLUTION
 SV MAKE-UP PROCEDURE FOR N-27-D
 SP ADJUST SV TO 68" (3495 G) 58" (2980 G)
 CP RECORD PH 10.1. 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% 20 721-D 20
 20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9.
 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:

SP STEP

V-243/V-244

13/46 (30 MIN)

14/47 (60 MIN)

15/48 (2 HRS)

16/49 (3 HRS)

17/50 (FINISH)

PH RANGE TIME
 9.65 9.0-10.0 3:05/A
 9.6 9.0-10.0 3:35/A
 9.6 9.0-10.0 4:35/A
 9.4 9.0-10.0 5:35/A
 7.7 7.5-8.5 6:30/A ← 7:15/AM

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

DRUM 28 WEIGH INTO 55 GAL DRUM

ASSUME 50%

56

721-D

28

6 29 FILL WITH WATER & STIR 2 MIN

28

721-D

130 SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.
 SV 131 SP STEP 23/53 - RECORD: PH 3.25 3.3-3.7
 SP 132 IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7
 & RECORD: PH ____
 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.

15-A

133 SIFT IN

150 ✓

128-A

150

134 SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR
5 MIN

135 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%

27-D

7-D

136 SIPHON N-7-D INTO SV

137 OPERATOR STEP PB

138 SP STEP 24/54 - POUR IN & STIR 15 MIN

22 ✓

978-A

22

139 OPERATOR STEP PB

140 SP STEP 60 - BATCH COMPLETE

141 OPERATOR STEP PB

START
TIME SP STEPFINISH
TIME SP STEP

OPTR

11:00 AM
7:00 AM7:00 AM
8:00 AM54-120
235-244Note: batch high volume in V-243
243
2m.



