

CG 03 CODE KY-795-D PKG

LOT

DEC-8 38171

PROCESSES

APPROVED BY

() KY-795-D (H) FWP 11/20/80
 () (XOB-17: 3/4
 () N-32-D & 240
 () MIN STRIKE)
 ()

STANDARD HRS. 8.2

TIME M

JOB NAME: XOB17:795H

COMPONENT CONSUMPTION

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

14 g-469-D 13380 93 3500 (2A)

TOTAL EST'D WGT 438

Warehouse Request 3641

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.			
205	2 WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	485	983-D	485
1	RECORD: START <u>2:55 PM</u> LOT <u>13380</u>	70X50	<u>Y-467-D</u>	3500
	FIN <u>4:15 PM</u>		<u>816-A</u>	
	Use minimum to reduce foam →			
1	4 ADJUST TO 75" (1275 G)			
1	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
1	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
1	7 RECORD: V-205 VOL <u>42"</u> & ADJ TO 60" (2100 G)			
1	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.			
2	RECORD: TIME START <u>9:30 PM</u> TOTAL MINUTES <u>165</u>			
1	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
1	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)			
3	13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A, 11LG <u>50</u> % PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM		27-D	296
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.04			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.69 GPM		983-D	1925
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.5 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.59			

N34813

V-244

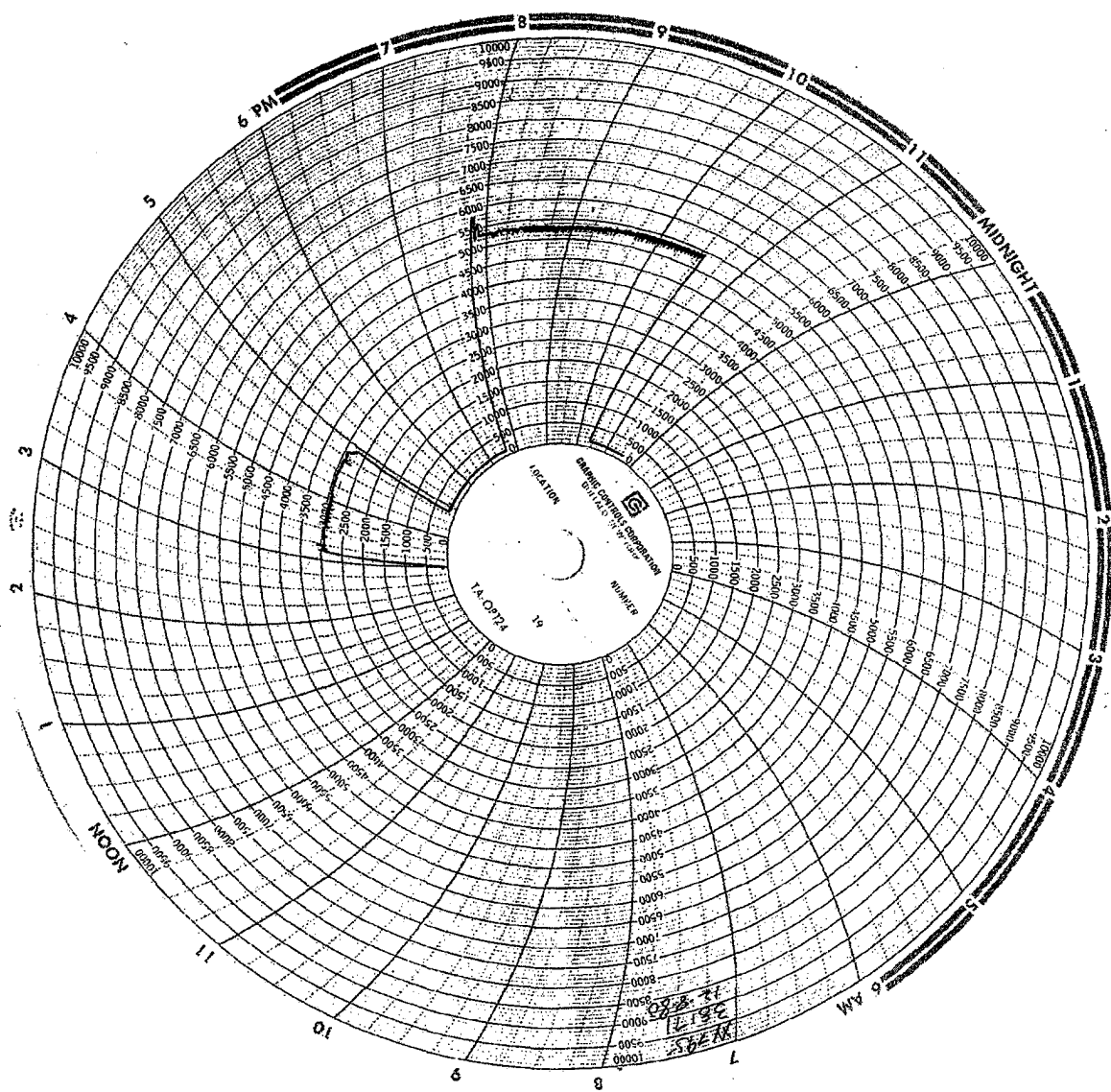
SV	16	OPERATOR STEP PB			
SP	17	RECORD LEVEL 2LG 72% IF (35% FOLLOW SOLUTION			
CP	18	MAKE-UP PROCEDURE FOR N-27-D			
	19	ADJUST SV TO 58" (2980 G)			
	20	RECORD PH 10.8 ADJ TO 11.1-11.3 WITH N-7-D AT			
		5% (1.0 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.3. ASSUME 50%	30	7-D	25
	20	OPERATOR STEP PB			

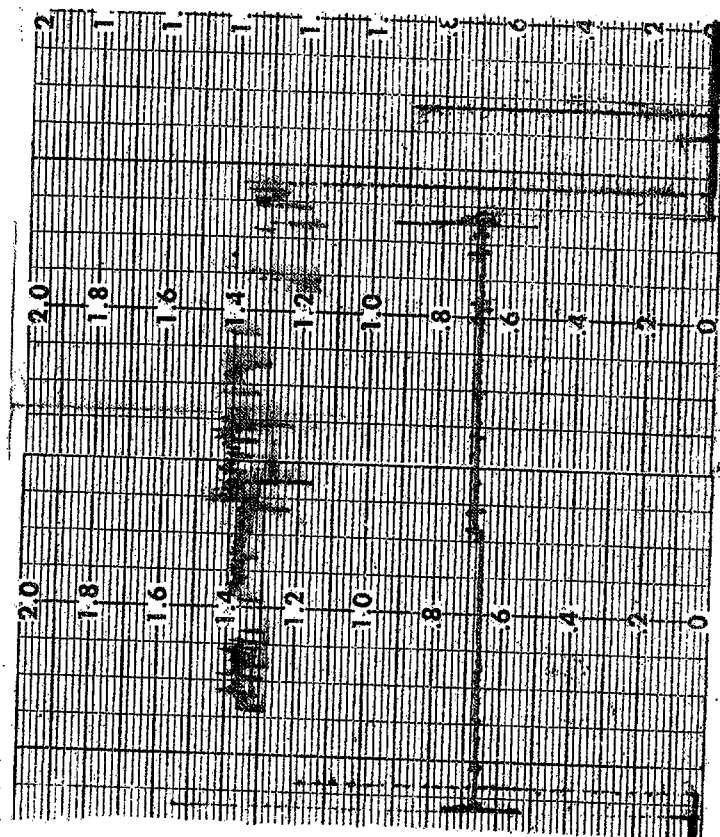
SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7.			
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	23	OPERATOR STEP PB			
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) 9.3 9.0-10.0 3:30 Am			
		14/47 (60 MIN) 9.3 9.0-10.0 3:50 Am			
		15/48 (2 HRS) 9.3 9.0-10.0 4:50 Am			
		16/49 (3 HRS) 9.3 9.0-10.0 5:50 Am			
		16/49 (4 HRS) 9.3 9.0-10.0 6:50 Am			
		17/50 (FINISH) 8.2 7.5-8.5 7:35 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	

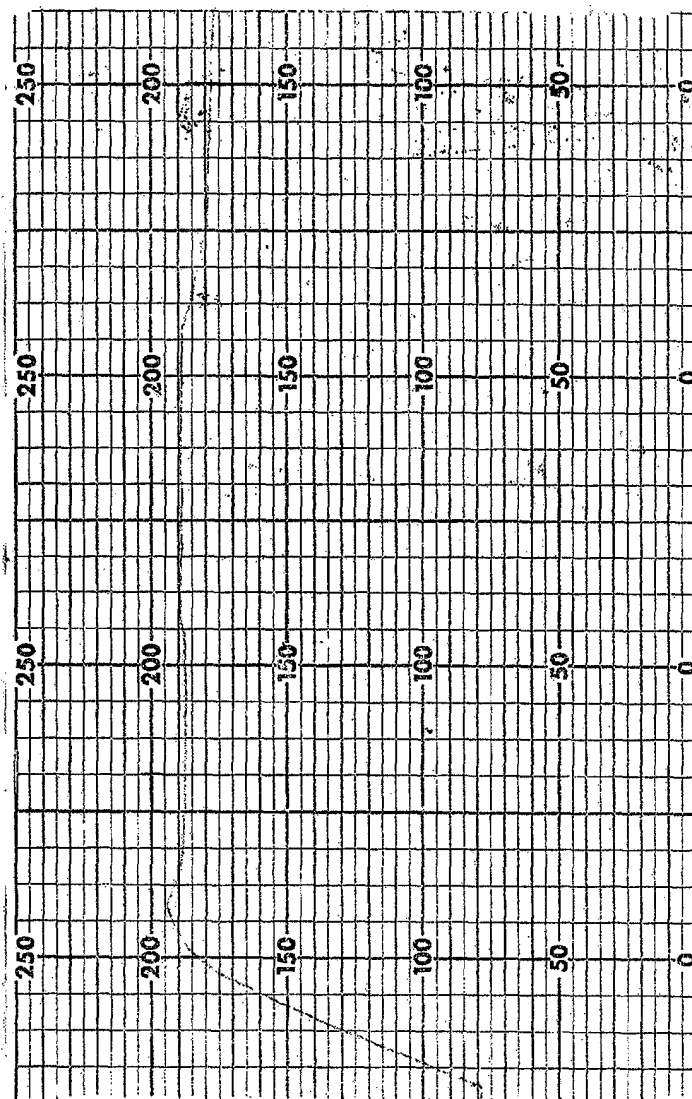
DRUM	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	56	7-D	28
6	29	FILL WITH WATER & STIR 2 MIN			

SV	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SP	31	SP STEP 23/53 - RECORD: PH 3.3 (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 8-22 IN 10-15 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%		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	22	978-A	22
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	40	OPERATOR STEP PB			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
3:30 PM	11:00 PM	237-244
7:10 AM	9:45 AM	54







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GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

