

CG 03 CODE KY-908-D PKG

PROCESSES

APPROVED BY

A2J57

() KY-908-D (D) FWP 12/17/81

DATE

LOT NUMBER

STANDARD HRS.

TIME _____ M

JOB NAME: 03KY908DMD

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	<u>14878</u>	93	<u>2000</u>	14	YC-3-B		93	
14	YC-3-B	<u>14878</u>	93	<u>600</u>	14	YC-3-B		93	
14	YC-3-B		93		14	YC-3-B		93	

EST. WT. 3495* LBS.

NON-BLEEDING

EQUIP	NAME : "KROLO" YELLOW-LIGHT	USE LBS	N-CODE	ACCT LBS
203	✓ RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	✓ WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN RECORD: . START <u>5:27</u> LOT <u>14852</u> FIN <u>7:27</u> <u>14878</u>	345 52X50 <u>2000</u> <u>600</u>	32-D YC-3-B	345 2600
✓	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
✓ 5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 V-263			
✓ 6	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205 V-263			
✓ 7	RECORD: V-205 VOL <u>4</u> " & ADJ TO 60" (2100 G)			
✓ 8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	✓ RUN 10" (514 G) WATER INTO V-243 & START AGITATOR V-263			
SV	✓ PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>8:35 AM</u> TOTAL MINUTES <u>1:50</u>			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205 V-263			
✓ 1	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 3 (V-243) OR POSITION 8 (V-244)			
CP	13 PRESS SV CAM RESET PB - SET 22 TO IN AUTO REMOTE (TEMP 13 SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG <u>20</u> % PRESET #2 76 GAL	832	115-A	416
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM		27-D	180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.8			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM		32-D	1215
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	9FC20 (N-32-D WATER) IN REMOTE			
	SFR10 (N-32-D/WATER) RATIO 1.1			

EQUIP PAGE 2 CG 03 KY-908-D
MENTI COMTYP JOB NAME: 03KY908DMD

V-243

USE N- ACCT
LBS CODE LBS

320 116 OPERATOR STEP PB
SV 117 RECORD LEVEL 2LG 54% IF <35% FOLLOW SOLUTION
SP 118 MAKE-UP PROCEDURE FOR N-27-D
CP 119 ADJUST SV TO 47" (2400 G)
119 RECORD PH 10.0 ADJ TO 11.0-11.2 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 120 SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50% 25 7-D 11
120 OPERATOR STEP PB

SV 121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9
SP 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
123 OPERATOR STEP PB
124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE.
126 OPERATOR STEP PB
127 DURING STRIKE RECORD: 1:05 PM
SP STEP
V-243/V-244
PH RANGE TIME
13/46 (30 MIN) 9.7 9.3-10.0 1:35 PM
14/47 (60 MIN) 9.7 9.3-10.0 2:05 PM
15/48 (2 HRS) 9.7 9.3-10.0 3:05 PM
16/49 (2 HRS, 25 MIN) 9.5 9.3-10.0 3:30 PM
17/50 (FINAL 3 HRS) 7.0 7.5-8.5 4:05 PM
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%
128 SIFT IN 50 27-D 128-A 50

385 129 ADD 42" (320 G) WATER TO V-385
6 130 ADD & STIR FOR 2 MIN FOR S 57, ASSUME 50% 160 7-D 80

387 131 DURING STRIKE CHECK LEVEL IN V-387.
7 132 IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35
133 IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING
THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE
134 IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW
STEARATE MAKE-UP PROCEDURE.

388 135 RUN IN 25" (244 GAL)
8 136 TURN ON STEAM & AGITATOR
137 ADJUST TO 32" (317 GAL) AT 178-182°F
138 SET BADGER METER FOR 384#
139 PUMP IN FROM V-387 THRU UNDERSURFACE
DISTRIBUTORS AS FAST AS POSSIBLE 312 169-A 312
36 155-A 36
36 160-A 36
140 SHUT OFF PUMP
141 STIR 30 MIN AT 178-182°F FOR S 48
142 DO NOT SHUT OFF AGITATOR

SV 143 WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN
& 144 5 TO 10 MIN
SP 144 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
9 PUMP
145 OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP
INLET
146 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER

EQUIP
MENT

PAGE 3 CG 03 KY-908-D

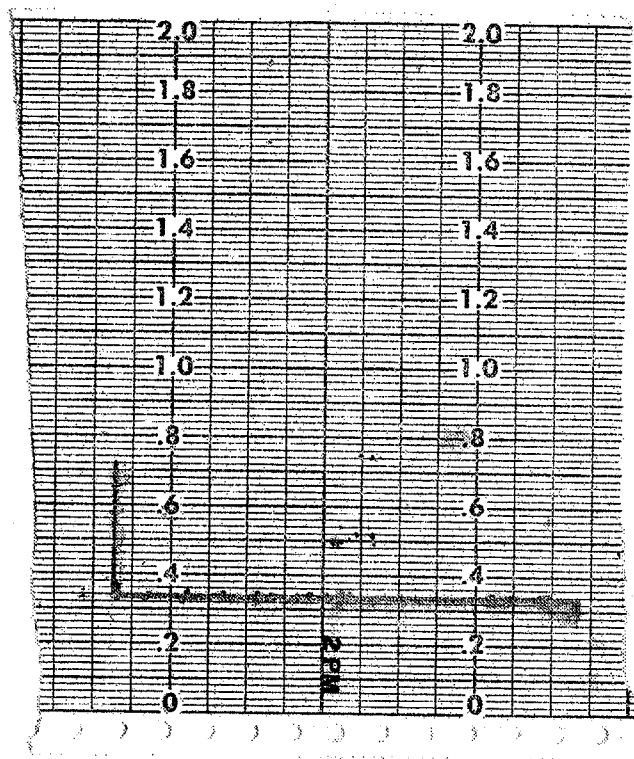
USE
LBSN-
CODEACCT
LBS

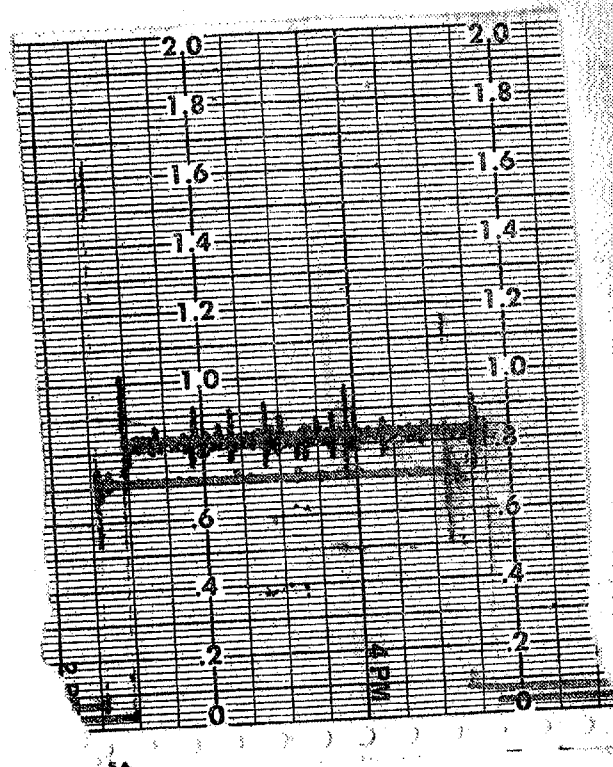
SV 47 WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG
& DISCHARGE VALVE TO SV AND CLOSE VALVE TO
SP SEWER
9 48 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
CONT TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.
49 WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP
50 WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT
WATER FROM HOT WATER MIXER
51 WHEN S50 COMPLETE TURN OFF HOMOG & STERATE PUMP
52 STIR 5 MIN AT 198-200°F
53 SHUT OFF STEAM
54 WHEN S53 COMPLETE, OPERATOR PB
55 SP STEP 23/53 RECORD PH 3.0 (3.3-3.7)
56 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)
& RECORD: PH ____
NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
BADGER METER. STIR 5 MIN AFTER EACH
ADDITION. ASSUME 50%
57 RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN
58 RECORD: PH 4.2 (4.2-4.4) & IF NECESSARY, ADJ
TO PH 4.2-4.4 & RECORD: PH ____ ASSUME 50%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%
SIPHON N-7-D INTO SV
59 OPERATOR STEP PB
60 OPERATOR STEP PB
61 SP STEP 60 - BATCH COMPLETE

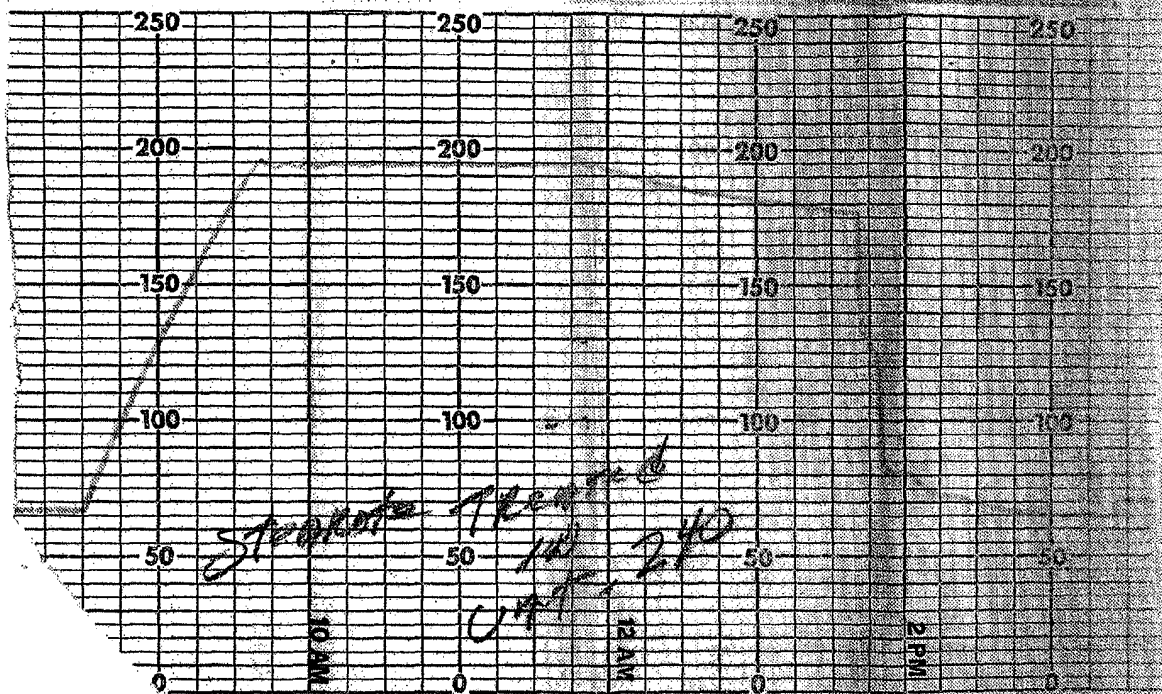
START		FINISH		OPERATOR
TIME	SP STEP	TIME	SP STEP	
<u>3:00P</u>	-----	<u>10:20PM</u>	-----	<u>126-301</u>

EQUIP
MENT

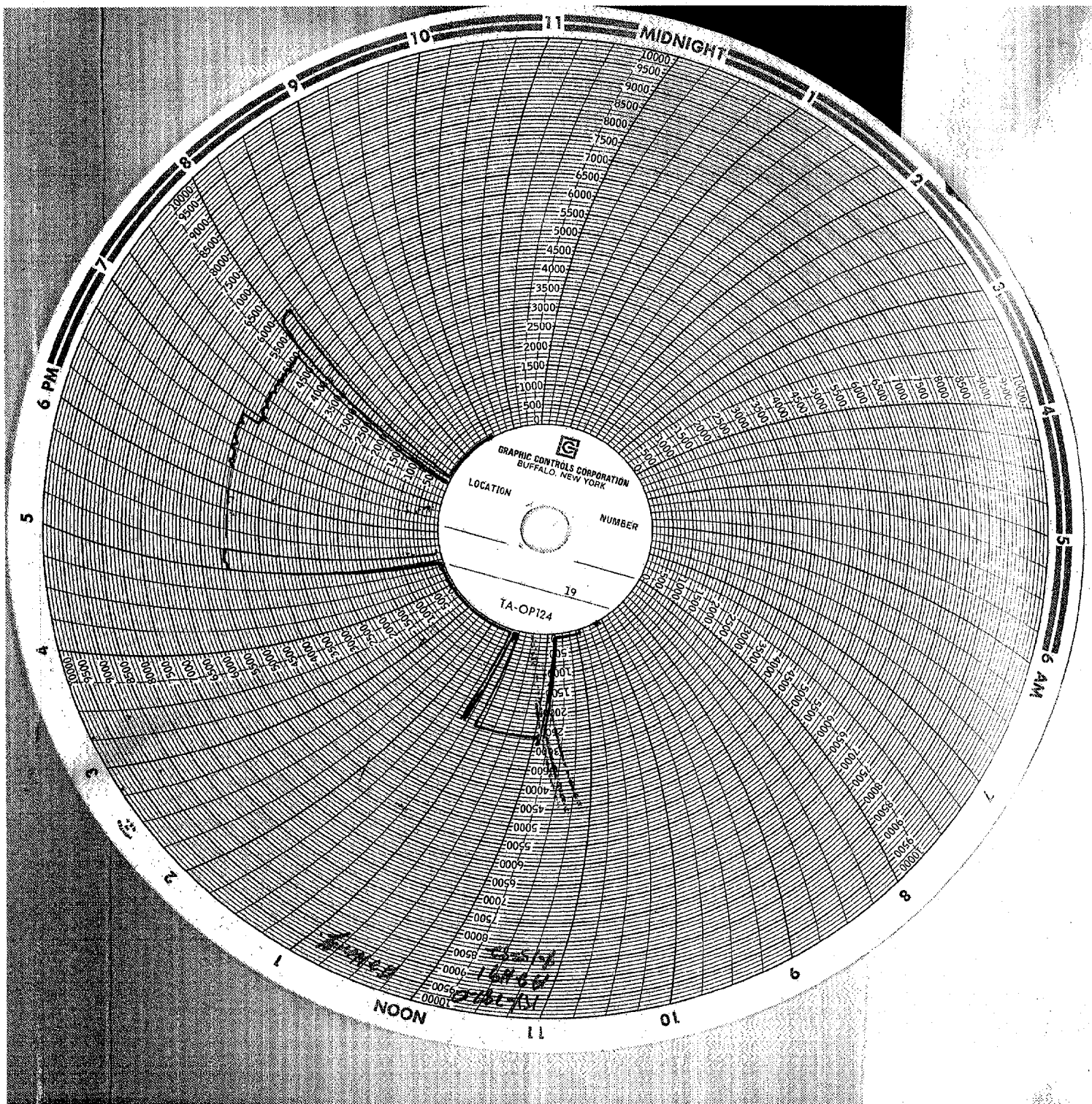
SV
&
SP
&
CO



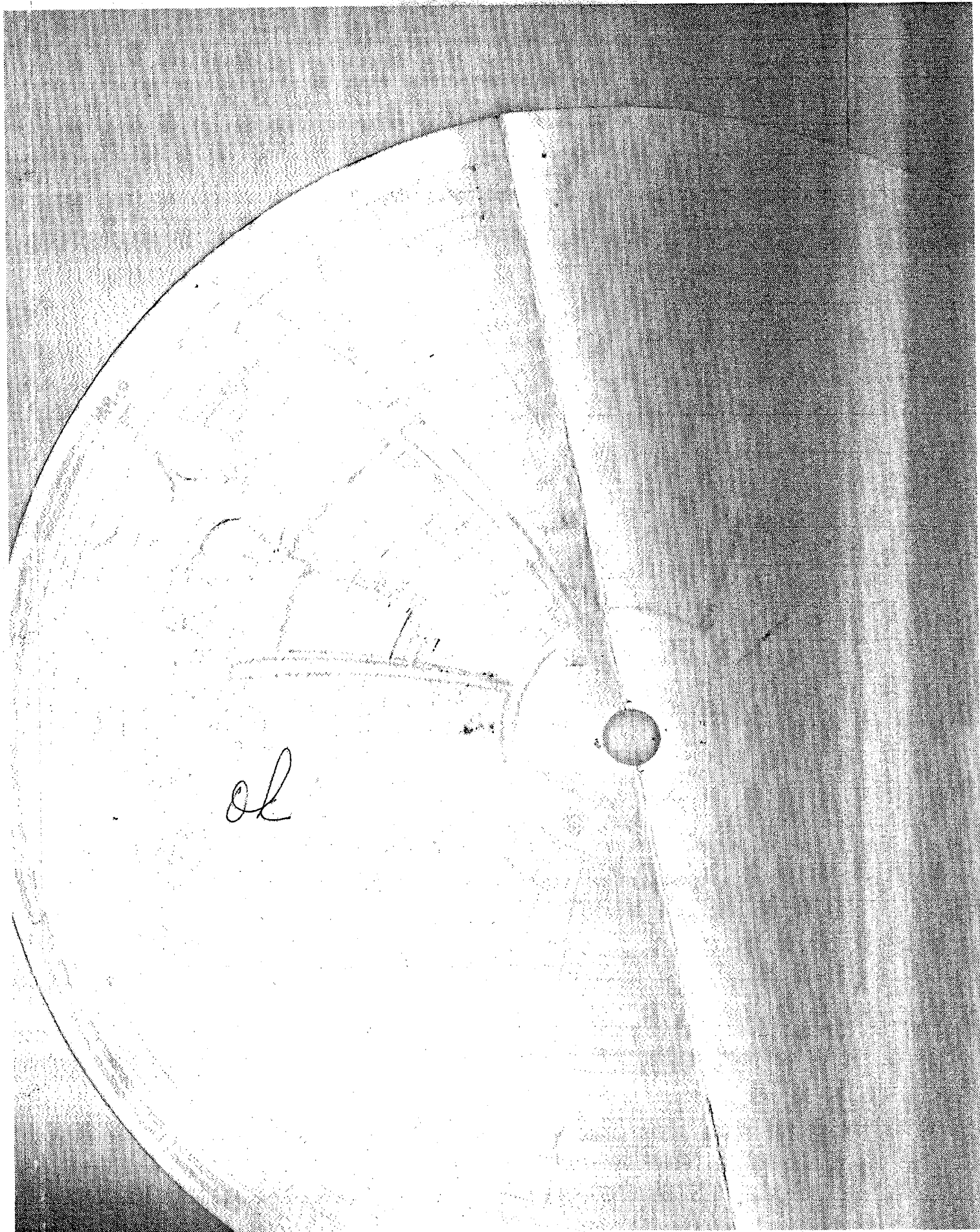




GRAPHIC CONTROLS CO.



DUP050110178



DUP050110179