

CG 03 CODE KY-787-D PKG
LOT

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 110 M

PROCESSES APPROVED BY
() KY-787-D (Q) FWP 9/23/80
() (XOB-17: 25%
() LESS N-32-D
() & 240 MIN
() STRIKE)

TYPED BY: FP 9/23/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13092	93	2400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 3332

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.			
263	2 WEIGH IN DRUM & POUR IN	240	32-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 4:30 A.M. 13092	2400		
	FIN 5:45 A.M.			
	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 61" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V- & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2632	RECORD: TIME START 2:30 TOTAL MINUTES 130			
	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 2 (V-243) OR POSITION 7 (V-244)			
	13 PRESS SV CAN 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 72% PRESET #1 80 GAL		15-A	160
	B. 13LG 37% PRESET #6 135 GAL		20-A	135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
	3FD20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.35			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		32-D	1376
	3FE20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	3FC20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.82			

N35023

EQUIP	PAGE 2	CG 03	KY-787-D	EST WGT 33324	USE LBS	N- CODE	USE LBS
V-243							
16	OPERATOR STEP PB	18					
320	17	RECORD LEVEL 2LG	18	% IF BELOW 35% FOLLOW SOL'N			
SV	18	MAKE-UP PROCEDURE FOR N-27-D					
SP	18	ADJUST SV TO 48" (2470 G)					
CP	19	RECORD PH 10.0	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 11.2	ASSUME 50%	70	7-D	10	
	20	OPERATOR STEP PB					
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5					
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:	645P				
		SP STEP					
		V-243/V-244	PH RANGE TIME				
		13/46 (30 MIN)	9.5 9.0-10.0 7:55P				
		14/47 (60 MIN)	9.5 9.0-10.0 7:45P				
		15/48 (2 HRS)	9.5 9.0-10.0 8:45P				
		16/49 (3 HRS)	9.5 9.0-10.0 9:45P				
		16/49 (4 HRS)	9.5 9.0-10.0 10:45P				
		17/50 (FINISH)	7.0 7.5-8.5 11:30P				
		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		
	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339					
	29	ADD IN 7-8 MIN		350	530-A	350	
339	30	ADJ TO 49" (382 G) AT 80-100°F					
6	31	STIR 5 MIN & RECORD: PH 10.0 (9.5-10.5)					
	32	STIR 15 MIN OR LONGER FOR SP STEP 26					
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 58.2 GAL					
	34	SET PRESET #8 TO 382-GAL 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 3.8 (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 9.5 (9.0-9.5). ADJ IF NECESSARY &					
		RECORD: PH	ASSUME 77%		27-D		
		(DILUTE 10 PARTS WATER TO 1 PART)	ASSUME 50%		7-D		
		(SIPHON N-7-D INTO SV)					
	42	OPERATOR STEP PB					
	43	SP STEP 29/58. RECORD: PH 9.5 & TIME 12:30 PM					
	44	OPERATOR STEP PB					
	45	SP STEP 60. BATCH COMPLETE.					
START FINISH OPTR							
TIME SP STEP		TIME SP STEP					
7:00 AM		3:00 PM		223-282			
3:00 P		11:00 P		259			
				237244			







