

V. 243, 244 C.V. D.V.

CG 03 CODE KY-788-D PKG PROCESSES APPROVED BY
 LOT () KY-788-D (J) FWP 5/14/80

JUN 25 36305 30125 1980
 EST'D WGT 960 LBS
 STANDARD HRS. 8.8 TIME 7P M

TYPED BY: FP 5/14/80.

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	

PUNCHED & CHECKED

HOMOG # 3 - 1ST + 2ND Pass

TOTAL EST'D WGT 3300 30 1980

NON-BLEEDING

QUIP	NAME : 'KROLOR' YELLOW-LIGHT	USE LBS	N- CODE	ACCT LBS
03	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
05	2 WEIGH IN DRUM & POUR IN	345	32-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START 2:00 AM	2000		
	FIN 3:35 AM	600		
	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 48" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
05	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 1:30 PM TOTAL MINUTES 110			
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 112	STEP 01 - SET FORMULA SELECTOR TO POSITION A			
A	3 (V-243) OR POSITION B (V-244)			
CP 113	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	114 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 4.8% PRESET #2 208 GAL		15-A	416
	B. 13LG 5.4% PRESET #6 135 GAL		20-A	135
115	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			
	3PR10 (N-27-D/WATER) RATIO 0.8			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM		32-D	1215
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	3PR20 (N-32-D WATER) IN REMOTE 1.1			

V-243

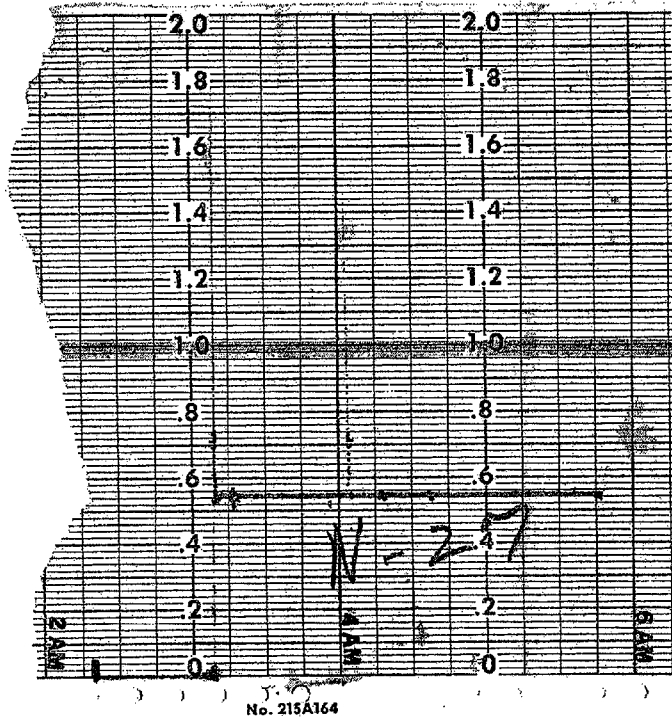
116	OPERATOR STEP PB			
320	RECORD LEVEL 2LG 58% IF <35% FOLLOW SOLUTION			
SV	MAKE-UP PROCEDURE FOR N-27-D			
SP	ADJUST SV TO 47" (2400 C)			
CP	RECORD PH 10.5. ADJ TO 11.0-11.2 WITH N-7-D AT			
	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	40	7-D	20
120	OPERATOR STEP PB			
121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.1			
SV	SWITCH 3FC20, BFC10, & BFC20 TO AUTO			
SP	OPERATOR STEP PB			
124	SP STEP 10/43. WHEN 3FC20, BFC10 & BFC20 FLOWS			
	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
	LIMITS, SWITCH 3FC20 TO REMOTE			
126	OPERATOR STEP PB			
127	DURING STRIKE RECORD:			
	SP STEP			
	V-243/V-244			
	13/46 (30 MIN)	9.9	9.3-10.0	5:05
	14/47 (60 MIN)	9.9	9.3-10.0	5:35
	15/48 (2 HRS)	9.9	9.3-10.0	6:35
	16/49 (2 HRS, 25 MIN)	9.9	9.3-10.0	7:00
	17/50 (FINAL 3 HRS)	8.2	7.5-8.5	7:35
	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	
128	WHILE STRIKING RUN 40" (234 G) WATER INTO V-339			
129	ADD IN 7-8 MIN			
339	ADJ TO 49" (382 G) AT 80-100°F	350	530-A	350
6	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)			
132	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
133	RECORD: VOL 50" & CALC 50" X 0.78 = 39.0 GAL			
134	SET PRESET #8 TO 39.0 GAL FROM S 33			
302	RUN 40" (440 G) WATER INTO V-302			
7	ADD & STIR 2 MIN FOR 40 ASSUME 50%	360	7-D	180
137	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
138	SIFT IN	100	128-A	100
SV	SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)			
SP	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
	MIN			
8	RECORD: PH 9.3 (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)			
142	OPERATOR STEP PB			
143	SP STEP 29. RECORD: PH 9.25 TIME 9:15 PM			
144	OPERATOR STEP PB			
145	SP STEP 60. BATCH COMPLETE.			

4:35 PM

START
TIME SP STEP
2:00 P
3:00 P

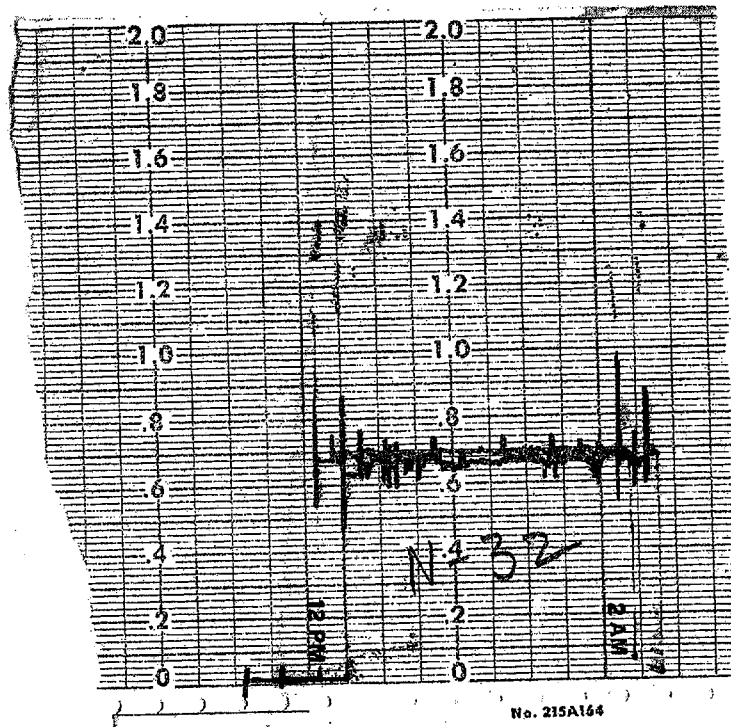
FINISH
TIME SP STEP
3:00 P
9:20 P

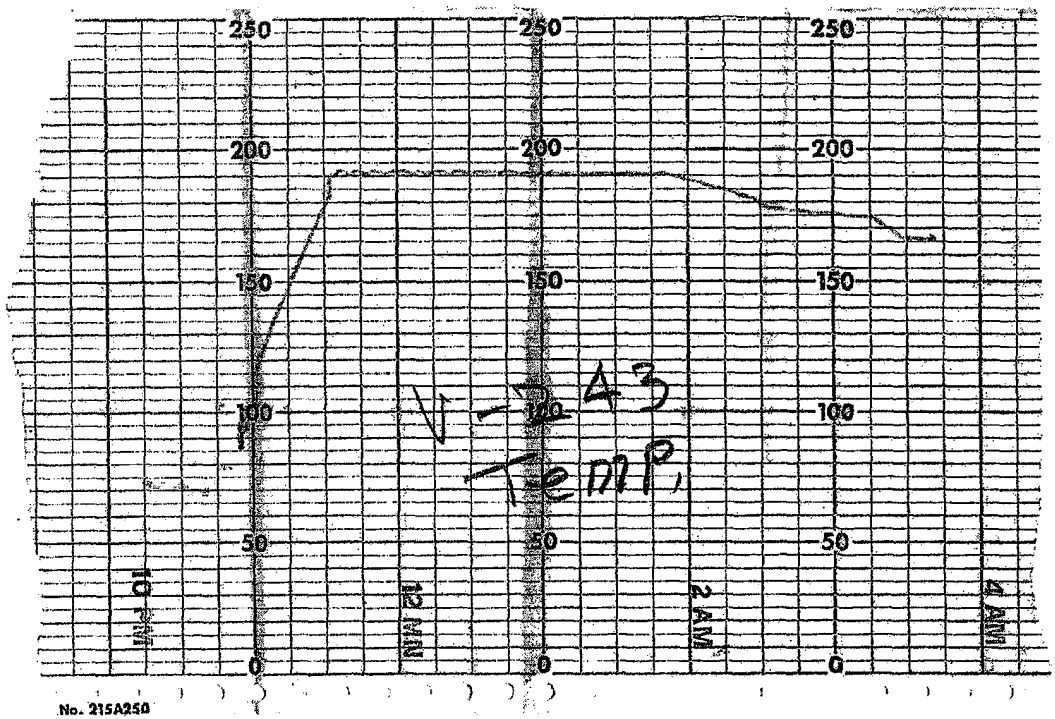
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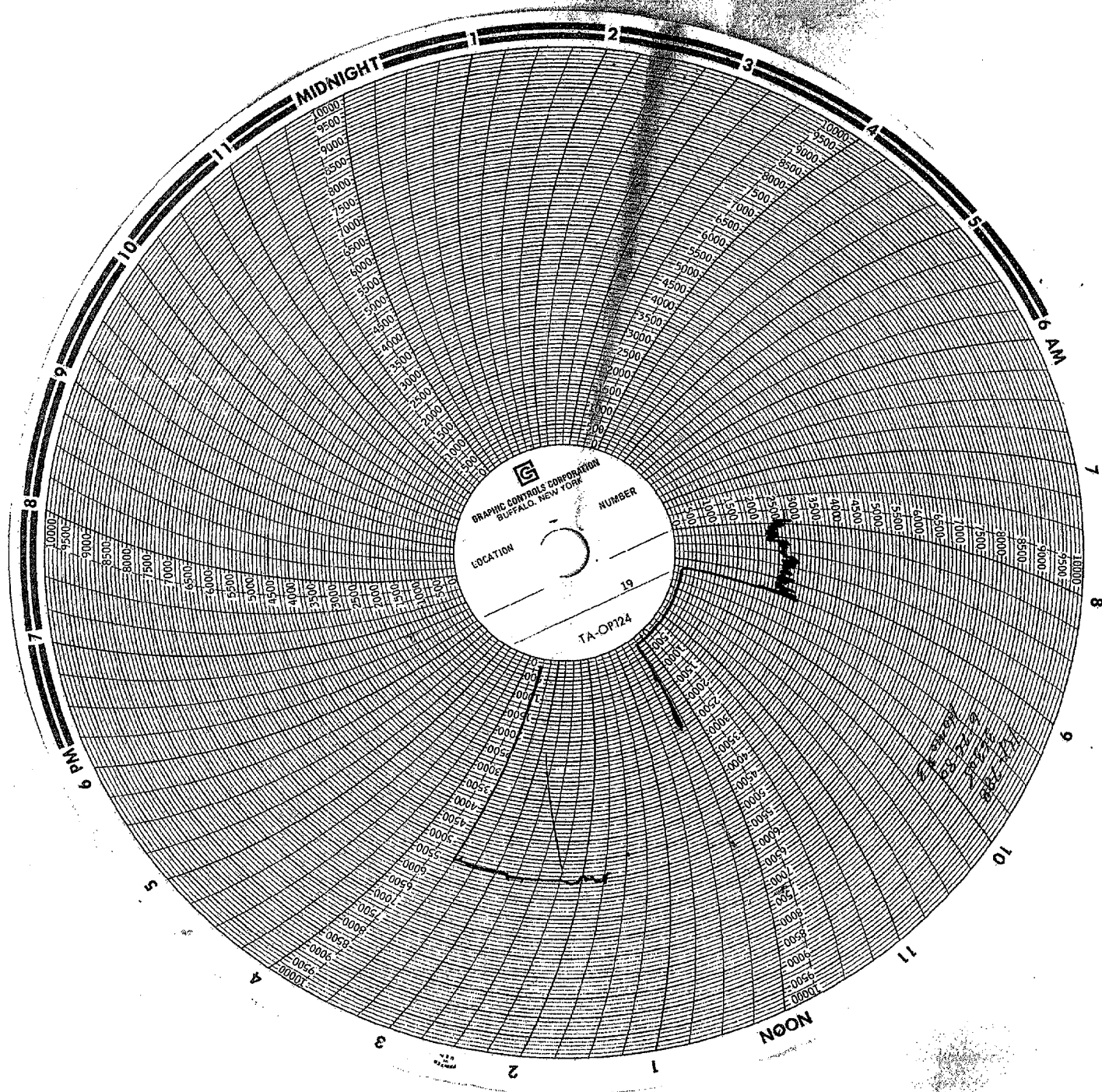
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DUP050457181





No. 215A250



N32230.02

DUP050457184

V-243