

CG 03 CODE KY-795-D PKG
LOT

OCT-23-80 37544

STANDARD HRS. 8.2 TIME 7A M

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

TYPED BY: FWP 10/17/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13182	93	100	14	YC002B		93	
14	YC002B	13178	93	2500	14	YC002B		93	
14	YC002B	13187	93	900	14	YC002B		93	

LEAVE ONE STUMP ONLY

**CLEAN UP
AS YOU GO ALONG**

TOTAL EST'D WGT 4380

ON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
	NAME : "KROLOR" YELLOW MEDIUM			
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 230 PM LOT 13182	100		
	FIN 4:14 PM 13178	2500		
		900		
	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 49" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-242 START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV			
	RECORD: TIME START 11:30 TOTAL MINUTES 16.5			
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)			
CP	12 PRESS SV CAM 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. TILG 44% PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM 3FR10 (N-27-D/WATER) RATIO 1.04 3FC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM 3FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM 3FC20 (N-32-D WATER) IN REMOTE 3FR10 (N-32-D/WATER) RATIO 1.59		27-D	296
			32-D	1885

F.N.

(Jke)

	116	OPERATOR STEP PB			
	117	RECORD LEVEL 2LG ____% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	118	ADJUST SV TO 58" (2980 G)			
CP	119	RECORD PH ____ 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 ____ ASSUME 50%		7-D	
	120	OPERATOR STEP PB			

	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH ____			
SV	122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	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:			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) ____ 9.0-10.0 ____			
		14/47 (60 MIN) ____ 9.0-10.0 ____			
		15/48 (2 HRS) ____ 9.0-10.0 ____			
		16/49 (3 HRS) ____ 9.0-10.0 ____			
		17/50 (FINISH) ____ 7.5-8.5 ____			
		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	128	WEIGH INTO 55 GAL DRUM ASSUME 50%	56	7-D	28
6	129	FILL WITH WATER & STIR 2 MIN			

	130	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	131	SP STEP 23/53 - RECORD: PH ____ (3.3-3.7)			
SP	132	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
&		RECORD: PH ____		15-A	
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.			
	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 ____ (4.0-4.2) & 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			
	136	OPERATOR STEP PB			
	137	SP STEP 24/54 - POUR IN & STIR 15 MIN	22	978-A	22
	138	OPERATOR STEP PB			
	139	SP STEP 60 - BATCH COMPLETE			
	140	OPERATOR STEP PB			

	START	FINISH	OPTR
	TIME SP STEP	TIME SP STEP	
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