

JAN 14 1982
DATE

A2J10
LOT NUMBER

() KY-907-D (D) FWP 12/17/81
()
()
()
COMTYP JOB NAME: 03KY907DMD

* STANDARD HRS. 8.9 TIME M

COMPONENT CONSUMPTION									
CG	CODE	LOT	PR	LBS	CG	CODE	LOT	PR	LBS
14	YC-2-B	13483	93	2.000	14	YC-2-B		93	
14	YC-2-B	14574	93	500	14	YC-2-B		93	
14	YC-2-B		93		14	YC-2-B		93	

DO NOT USE LOTS 13839 - 13855

12 PASS #4 homo.

TOTAL EST'D WGT 3381* LBS.

NON-BLEEDING

YC 2

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	250	32-D	250
	3 PUMP IN AND STIR 5 MIN	50X50	YC-2-B	2500
	RECORD: START 12.00 AM	2.000		
	FIN. 1.30 AM	500		
	ADJUST TO 75" (1275 G)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-203			
	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL " & ADJ TO 60" (2100 G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	1 RUN 10" (514 G) WATER INTO V-203 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 5.00 AM TOTAL MINUTES			
	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 2 (V-243) OR POSITION 7 (V-244)			
CP 13	PRESS SV-CAM RESET PB - SET 22 TC IN AUTO			
3	REMOTE (TEMP IS SET AT 190-194°F)			
14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11L5 100% PRESET #1 32 GAL		115-A	168
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	SPC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM		27-D	213
	SPC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM			
	SPR10 (N-27-D/WATER) RATIO 1.31			
	SPC10 (N-32-D CONTROLLER) IN MANUAL 1.84 GPM		32-D	1425
	SPC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
	SPC20 (N-32-D WATER) IN REMOTE			
	SPR10 (N-32-D/WATER) RATIO 1.76			

V-243

114	OPERATOR STEP PB			
320	RECORD LEVEL 2LG 70% IF BELOW 35% FOLLOW SOL'N			
SV	MAKE-UP PROCEDURE FOR N-27-D			
CP	ADJUST SV TO 48" (2470 G)			
119	RECORD PH 10.3. ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
9	SIPHON INTO SV. RECORD: PH 11.3. ASSUME 50%	40	7-D	20
120	OPERATOR STEP PB			

121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9.			
SV	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	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)	9.5	9.0-10.0	11:05A
	14/47 (60 MIN)	9.5	9.0-10.0	11:35A
	15/48 (2 HRS)	9.4	9.0-10.0	12:35Pm
	16/49 (2 HRS, 25 MIN)	9.4	9.0-10.0	1:1Pm
	17/50 (FINAL 3 HRS)	7.8	7.5-8.5	1:35Pm
	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	ADD 27" (208 G) WATER TO V-385			
6	ADD & STIR FOR 2 MIN FOR S 37	10	ASSUME 50%	60 7-D 30

131	DURING STRIKE CHECK LEVEL IN V-387.			
387	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7	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.			

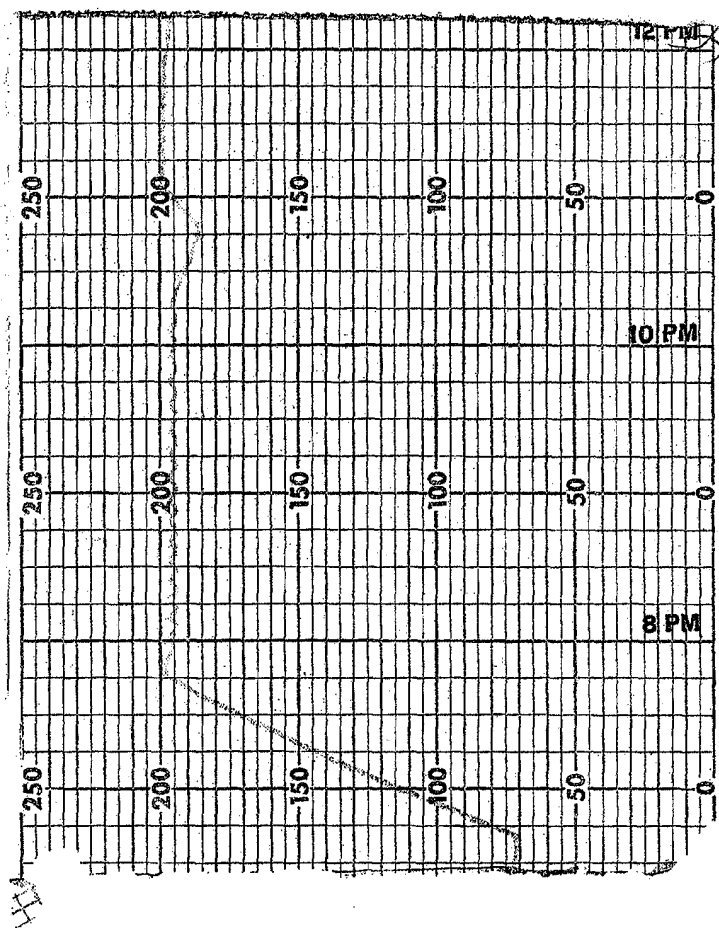
135	RUN IN 32" (317 GAL)			
388	TURN ON STEAM & AGITATOR			
8	ADJUST TO 42" (403 GAL) AT 178-182°F			
138	SET BADGER METER FOR 404#			
139	PUMP IN FROM V-387 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE	330	169-A	330
		37	155-A	37
		37	160-A	37
140	SHUT OFF PUMP			
141	STIR 30 MIN AT 178-182°F FOR S 48			
142	DO NOT SHUT OFF AGITATOR			

SV	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN			
SP	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
9	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			

EQWIP 1 COMTYP JOB NAME: 03KY907DMD USE N- IACCT
 MENT) 1 PAGE 03 CG 03 KY-907-D (D) EST WGT 3381# LBS CODE LBS

SV 147 WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG
 & DISCHARGE VALVE TO SV AND CLOSE VALVE TO
 SP 148 SEWER
 9. 148 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.
 149 WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE
 AT STEARATE PUMP ASAP
 150 WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT
 WATER FROM HOT WATER MIXER
 151 WHEN S50 COMPLETE TURN OFF HOMOG & STERATE PUMP
 152 STIR 5 MIN AT 198-200°F
 153 SHUT OFF STEAM
 154 WHEN S53 COMPLETE, OPERATOR PB
 155 SP STEP 23/53 RECORD PH 3.0 (3.3-3.7)
 156 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% 115-A
 157 RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN
 158 RECORD: PH_____. (4.2-4.4) & IF NECESSARY, ADJ
 TO PH 4.2-4.4 & RECORD: PH_____. ASSUME 50% 7-D
 (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78% 27-D
 SIPHON N-7-D INTO SV
 159 OPERATOR STEP PB
 160 OPERATOR STEP PB
 161 SP STEP 60 - BATCH COMPLETE

START		FINISH		OPERATOR
TIME	SP STEP	TIME	SP STEP	
5:45 A.		7: A.M.		54-301
5: A.M.		7: A.M.		54
7: A.M.		3: P.M.		223



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