

DEC 30 1981

A2H11

DATE

LOT NUMBER

STANDARD HRS. 8.8

TIME 11P M

JOB NAME' 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-3-B	14859	93	2000	14	YC-3-B		93	
14	YC-3-B	14877	93	600	14	YC-3-B		93	
14	YC-3-B		93		14	YC-3-B		93	

DO NOT USE YC-3-B LOTS 14001 THRU 14004

TOTAL EST'D WGT 3489* LBS.

NON-BLEEDING

EQUIP	NAME : "KROLOR" 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	345	32-D	345
3	DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
1	RECORD: START <u>12:30 PM</u> LOT <u>14859</u>	<u>2000</u>		
	FIN <u>2:40 PM</u> <u>14877</u>	<u>600</u>		
4	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			
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 <u>50</u> " & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START <u>6:00 PM</u> TOTAL MINUTES <u>180</u>			
	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	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)			
&	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
CP	REMOTE (TEMP IS SET AT 190-194°F)			
3	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG <u>60</u> % PRESET #2 78 GAL	115-A		416
	B. 13LG <u>12</u> % PRESET #6 135 GAL	20-A		135
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			
	8PD20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.1			

EQUIP MENT	PAGE 2 CG 03 KY-788-D COMTYP JOB NAME: 03KY788DMJ	USE LBS	N- CODE	ACCT LBS
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320	1	OPERATOR STEP PB			
SV	1	RECORD LEVEL 2LG 63% IF (35% FOLLOW SOLUTION			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 47" (2400 G)			
	19	RECORD PH 9.6. 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%	38	7-D	19
	20	OPERATOR STEP PB			

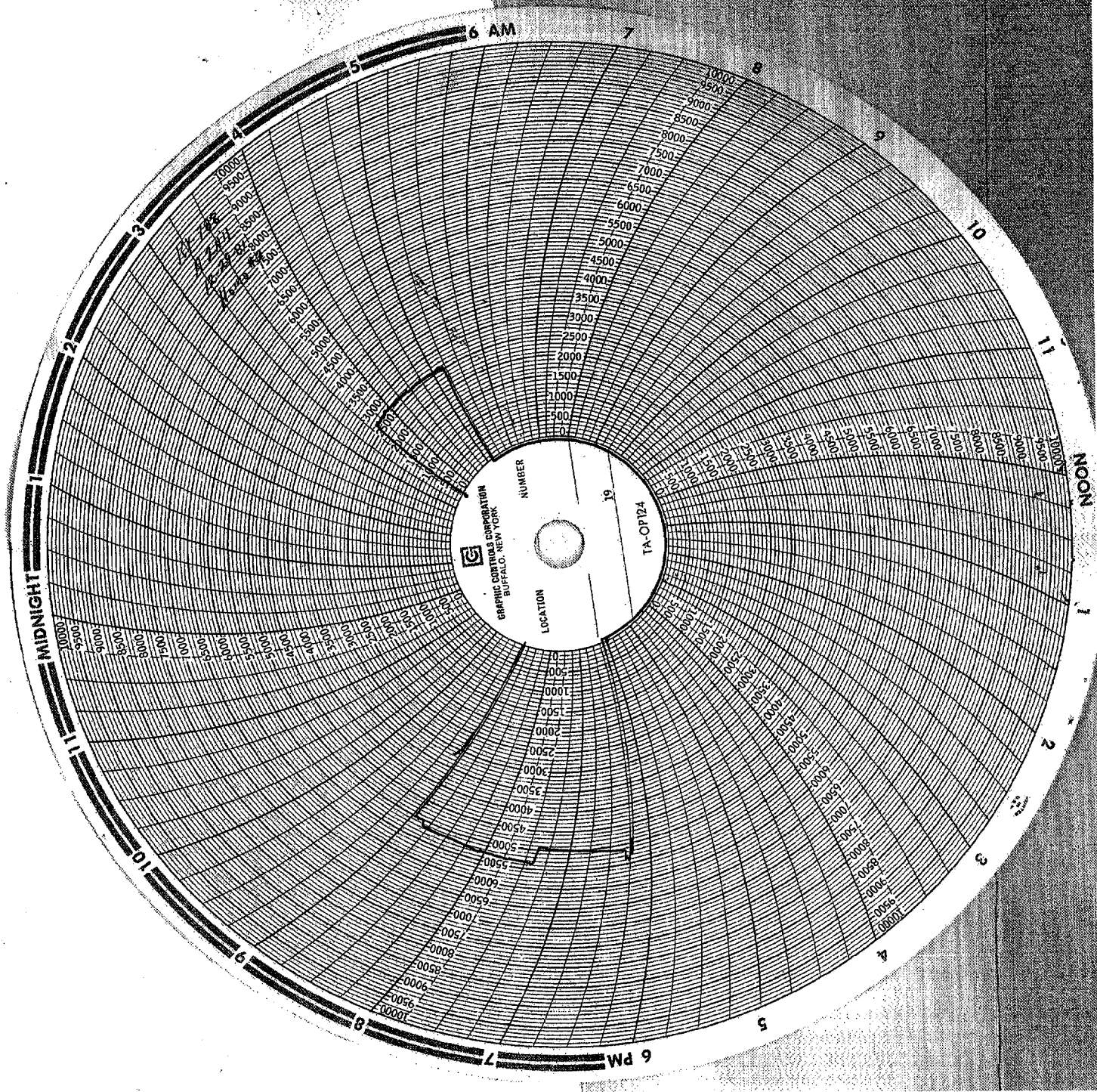
SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.1			
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	23	OPERATOR STEP PB			
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	25	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
		LIMITS, SWITCH 3FC20 TO REMOTE			
	26	OPERATOR STEP PB			
	27	DURING STRIKE. RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) 9.3 9.3-10.0 11.05			
		14/47 (60 MIN) 9.3 9.3-10.0 11.35 PM			
		15/48 (2 HRS) 9.3 9.3-10.0 12.35 AM			
		16/49 (2 HRS, 25 MIN) 9.3 9.3-10.0 1.00 AM			
		17/50 (FINAL 3 HRS) 7.7 7.5-8.5 1.35 AM			
		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 10.2 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
	33	RECORD: VOL 50" & CALC 50" X 0.78 = 39.0 GAL			
	34	SET PRESET #8 TO 39.0 GAL FROM S 33			

385	35	RUN 57" (440 G) WATER INTO V-385			
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180

	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 3.6 (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 9.1 (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. RECORD: PH 9.0 & TIME 2:00 PM			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

		START		FINISH		OPTR
		TIME SP STEP		TIME SP STEP		
		2:00 PM		7:00 PM		120-259
		1:00 PM		3:00 PM		248
		1:00 PM		3:00 PM		257-101



V-243

OK

DUP050110081



