

CG 03 CODE KY-781-D PKG
LOT A2H09

PROCESSES APPROVED BY
() KY-781-D (N) FWP 12/10/81

STANDARD HRS.

TIME 11 P M

JOB NAME: 03KY781DMN

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	-----

TOTAL EST'D WGT 4233* LBS.

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW LIGHT	USE LBS	N- CODE	ACCT LBS
203 & 205	✓ RUN 60" (990 G) WATER IN V-203 & ADD ASSUME 50% SET AGITATOR ON HIGH SPEED.	36	7-D	18
1	✓ WEIGH IN DRUM & POUR IN ✓ DUMP IN AND STIR 5 MIN RECORD: START 1145 PM FIN 230 AM	442 66X50 700 2600	32-D YC-3-B	442 3300
✓	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD. WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205 RECORD: V-205 VOL 40 " & ADJ TO 45" (1662 G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 SV	✓ RUN 10" (514 G) WATER INTO V-243 & START AGITATOR PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 0 A TOTAL MINUTES 130 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205 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 1 (V-243) OR POSITION 6 (V-244) 13 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. 11LG 75% PRESET #3 70 GAL 15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.90 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM 3FB10 (N-27-D/WATER) RATIO 0.7 BFC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM BFC20 (N-32-D WATER) IN REMOTE BER10 (N-32-D/WATER) RATIO 0.9		115-A 27-D 32-D	374 373 2527

EQUIP	PAGE 2 CG 03 KY-781-D	USE	N-	USE
	COMTYF JOB NAME: 03KY781DMN	LBS	CODE	LBS

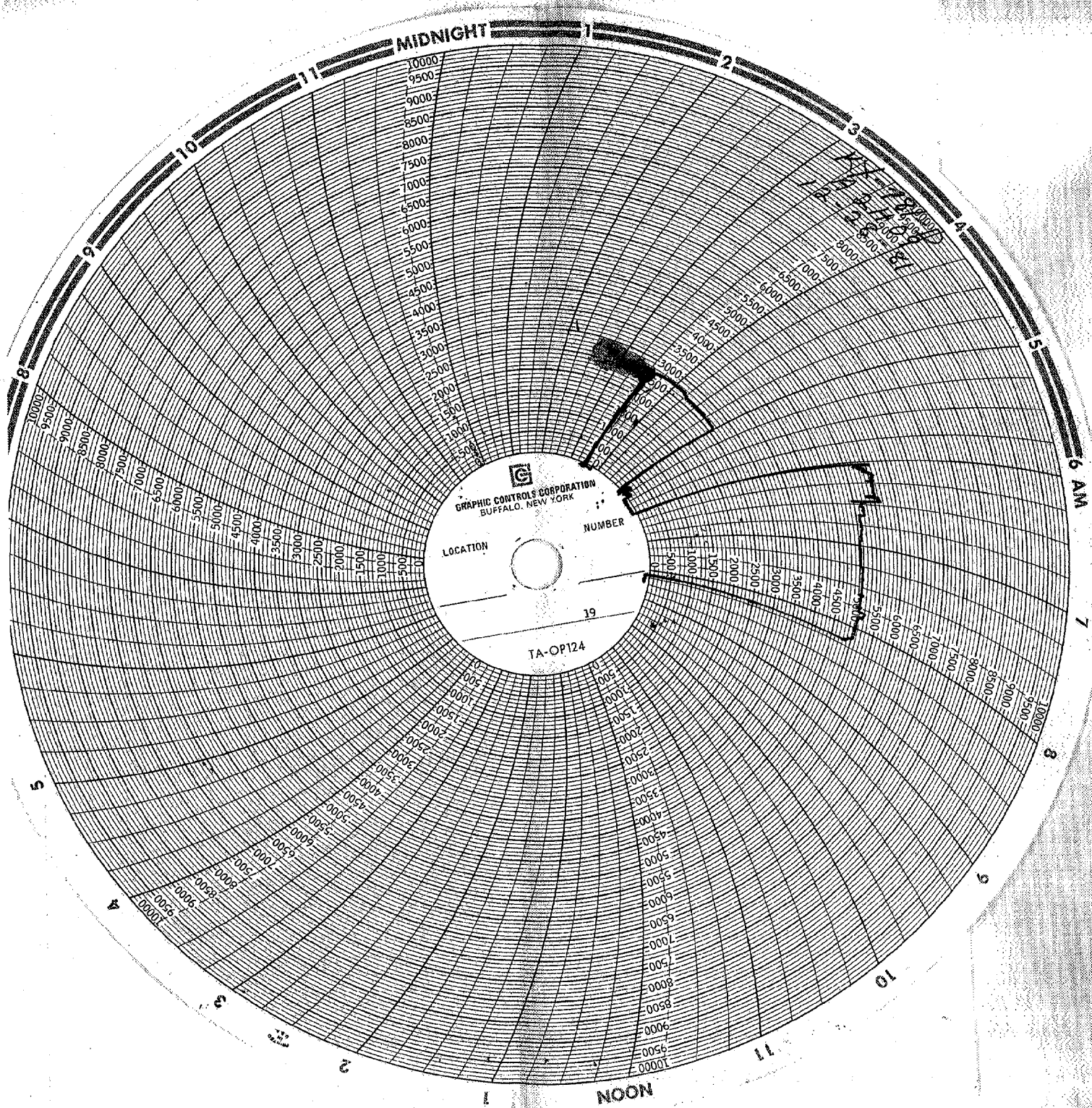
SV	16	OPERATOR STEP PB			
SP	17	RECORD LEVEL 2LG <u>62%</u> IF <35% FOLLOW SOLUTION			
CP	18	MAKE-UP PROCEDURE FOR N-27-D			
	19	ADJUST SV TO 54" (2800 G)			
4	20	RECORD PH <u>9.6</u> ADJ TO 11.4-11.6 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)	30	7-D	15
	21	SIPHON INTO SV. RECORD: PH <u>11.6</u> ASSUME 50%			
	22	OPERATOR STEP PB			

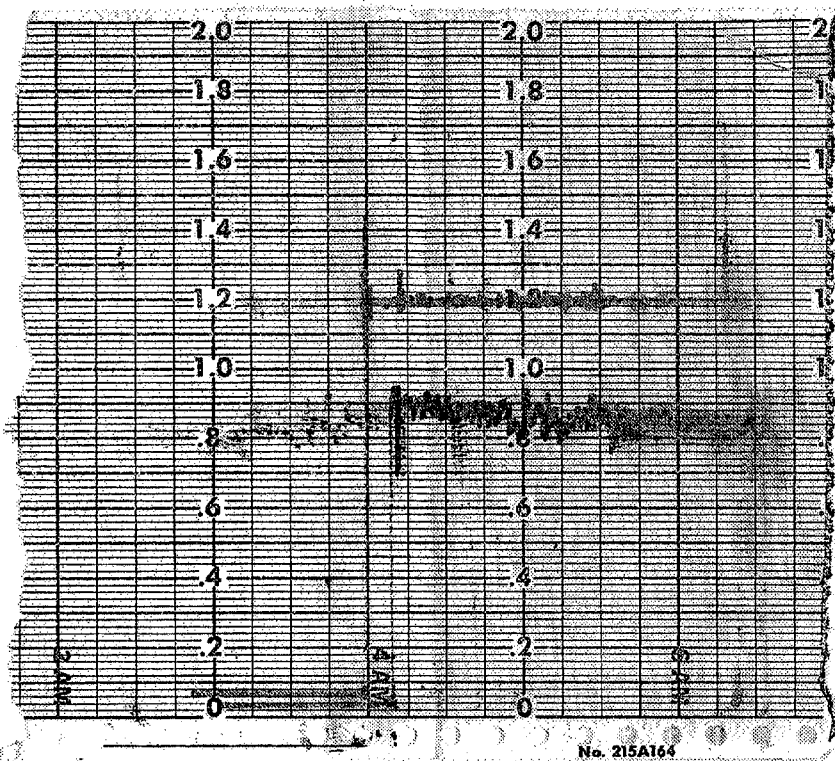
SV	23	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>10.0</u>			
SP	24	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	25	OPERATOR STEP PB			
5	26	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
	27	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	28	OPERATOR STEP PB			
	29	DURING STRIKE RECORD: SP STEP			
		V-23/V-244	PH	RANGE	TIME
		13/41 (30 MIN)	<u>9.9</u>	9.3-10.0	<u>9:35 AM</u>
		14/47 (60 MIN)	<u>9.9</u>	9.3-10.0	<u>10:05</u>
		15/48 (2 HRS)	<u>9.8</u>	9.3-10.0	<u>11:05</u>
		16/49 (3 HRS)	<u>9.8</u>	9.3-10.0	<u>12:05</u>
		17/50 (FINAL)	<u>7.8</u>	7.5-8.5	<u>12:50 PM</u>
		NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5. & RECORD: PH <u> </u> ASSUME 77%		27-D	

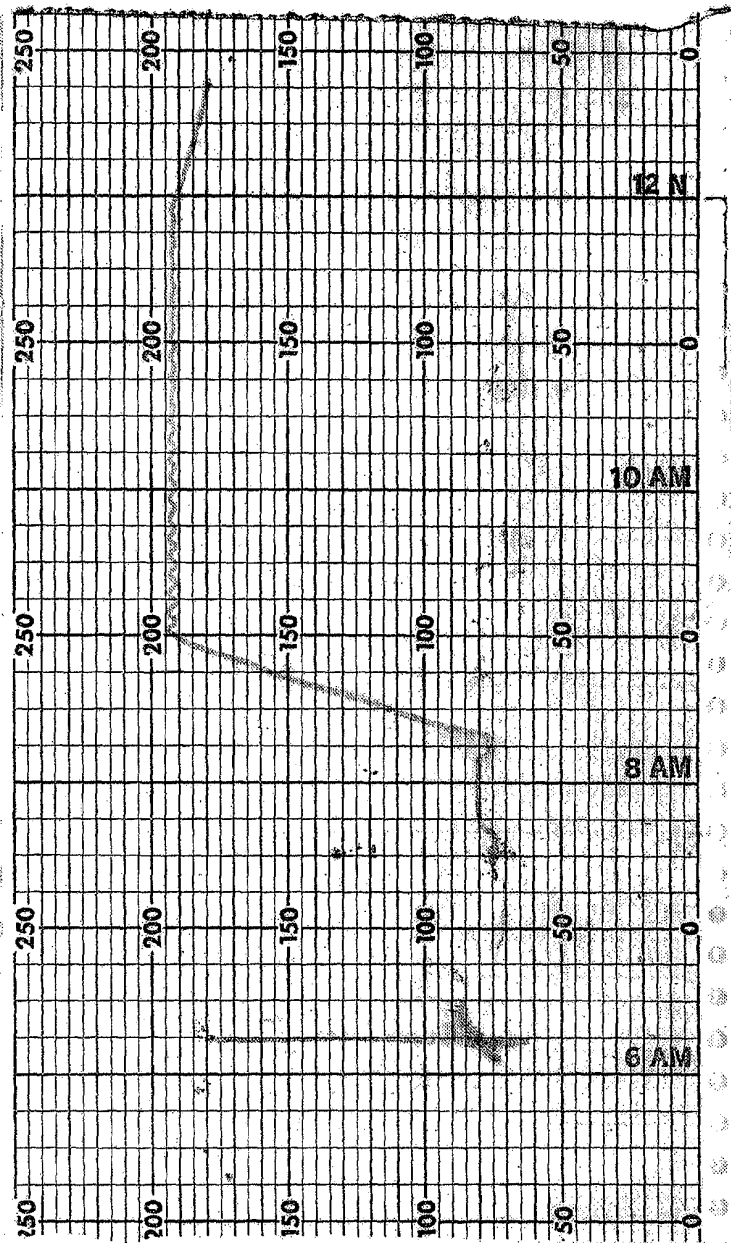
385	30	RUN 49" (379 G) WATER INTO V-385			
6	31	ADD & STIR 5 MIN ASSUME 50%	124	7-D	62

SV	32	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.	150 ✓	128-A	150
	33	SIFT IN			
	34	SP STEP 23/53.			
	35	RECORD: PH <u>3.3</u> (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH <u> </u>		15-A	
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%		115-A	
SP	36	RUN IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
7	37	RECORD: PH <u>4.4</u> (4.2-4.4). ADJ IF NECESSARY & RECORD: PH <u> </u> ASSUME 77%		27-D	
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%		7-D	
		(SIPHON N-7-D INTO SV)			
	38	OPERATOR STEP PB			
	39	SP STEP 24/54 - ADD & STIR 5 MIN	40 ✓	978-A	40
	40	OPERATOR STEP PB			
	41	SP STEP 60. BATCH COMPLETE.			

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
<u>3:30 AM</u>	<u> </u>	<u>7:00 AM</u>	<u> </u>	<u>120-54</u>
<u>1:22 AM</u>	<u> </u>	<u>2:22 AM</u>	<u> </u>	<u>237-348</u>
<u> </u>	<u> </u>	<u> </u>	<u> </u>	<u> </u>







DUP050110290

