

CG 03 CODE KY-787-D PKG

PROCESSES APPROVED BY  
( ) KY-787-D (T) FWP 03/22/82

JUN / 9 1982

F2K30

3394\*

COMTYP JOB NAME: 03KY787DMT

( DATE )

( LOT )

( EST WGT )

TYPED BY: JMW

| LOCATN | CG     | CODE | PQ    | LOT   | DRY WEIGHT | DRY CONT | NO. PKG | PKG WGT | TOTAL WEIGHT | ACTUAL USE LBS |
|--------|--------|------|-------|-------|------------|----------|---------|---------|--------------|----------------|
| 14     | YC002B | 93   | 01402 |       |            | XX.XX    |         |         |              |                |
|        | YC002B |      |       | D2E01 | 2000       | XX.XX    |         |         |              |                |
|        | YC002B |      |       | D2E02 | 500        | XX.XX    |         |         |              |                |
|        |        |      |       |       |            | XX.XX    |         |         |              |                |
|        |        |      |       |       |            | XX.XX    |         |         |              |                |

NON-BLEEDING

| EQUIP | NAME : "KROLOR" YELLOW-MEDIUM                                                                 | USE LBS | N-CODE | ACCT LBS |
|-------|-----------------------------------------------------------------------------------------------|---------|--------|----------|
| 203   | 1 BEFORE USING SV, MAKE SURE THAT N-26-D LINE IS ANY IS BLANKED OFF.                          |         |        |          |
| 205   | 2 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.                                 | 250     | 32-D   | 250      |
| 263   | 3 WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN                                              | 50X50   | YC-2-B | 2500     |
| 1     | RECORD: START 1100 PM D2E01<br>FIN 1230 PM D2E02                                              | 2000    |        | 500      |
| 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 54" & ADJ TO 60" (2100 G)                                                   |         |        |          |
| 8     | INSPECT HOMOG STRAINER & CLEAN IF NECESSARY                                                   |         |        |          |
| 205   | 9 RUN 10" (514 G) WATER INTO V-243. START AGITATOR                                            |         |        |          |
| SV    | 10 PUMP V-205 THRU HOMOG AT 4000-5200 PSI INTO SV. RECORD: TIME START 7115P TOTAL MINUTES 150 |         |        |          |
| 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             |         |        |          |

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|    |    |                                                                               |       |      |
|----|----|-------------------------------------------------------------------------------|-------|------|
| 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 TO IN AUTO REMOTE (TEMP IS SET AT 190-194°F)   |       |      |
| 3  | 14 | RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:                                |       |      |
|    |    | 11LG 38% PRESET #1 32 GAL                                                     | 115-D | 168  |
|    |    | 13LG 39% PRESET #6 141 GAL                                                    | 20-A  | 141  |
|    | 15 | SET STRIKE FLOW CONTROLLERS AS FOLLOWS:                                       |       |      |
|    |    | 7C10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM                                   | 27-D  | 213  |
|    |    | 3EC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM                                 |       |      |
|    |    | 3ER10 (N-27-D WATER) RATIO 1.31                                               |       |      |
|    |    | 8FC10 (N-32-D CONTROLLER) IN MANUAL .84 GPM                                   | 32-D  | 1425 |
|    |    | 8ER20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM                                 |       |      |
|    |    | 8ER20 (N-32-D WATER) IN REMOTE                                                |       |      |
|    |    | 8FR10 (N-32-D/WATER) RATIO 1.76                                               |       |      |

N38023

EQUIP PAGE 2 LG 02 KY-787-D  
COMTYP JOB NAME: 03KY787DMT

USE N- USE  
LBS CODE LBS

116 OPERATOR STEP PB  
320 17 RECORD LEVEL 2LG 9.2 IF BELOW 35% FOLLOW SOL 'N  
SV MAKE-UP PROCEDURE FOR N-27-D  
SP 18 ADJUST SV TO 48" (2470 G)  
CP 19 RECORD PH 9.8 ADJ TO 11.1-11.3 WITH N-7-D AT  
5% (10 PARTS WATER TO 1 PART N-7-D)  
4 20 SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50% 36 7-D 18  
25 OPERATOR STEP PB

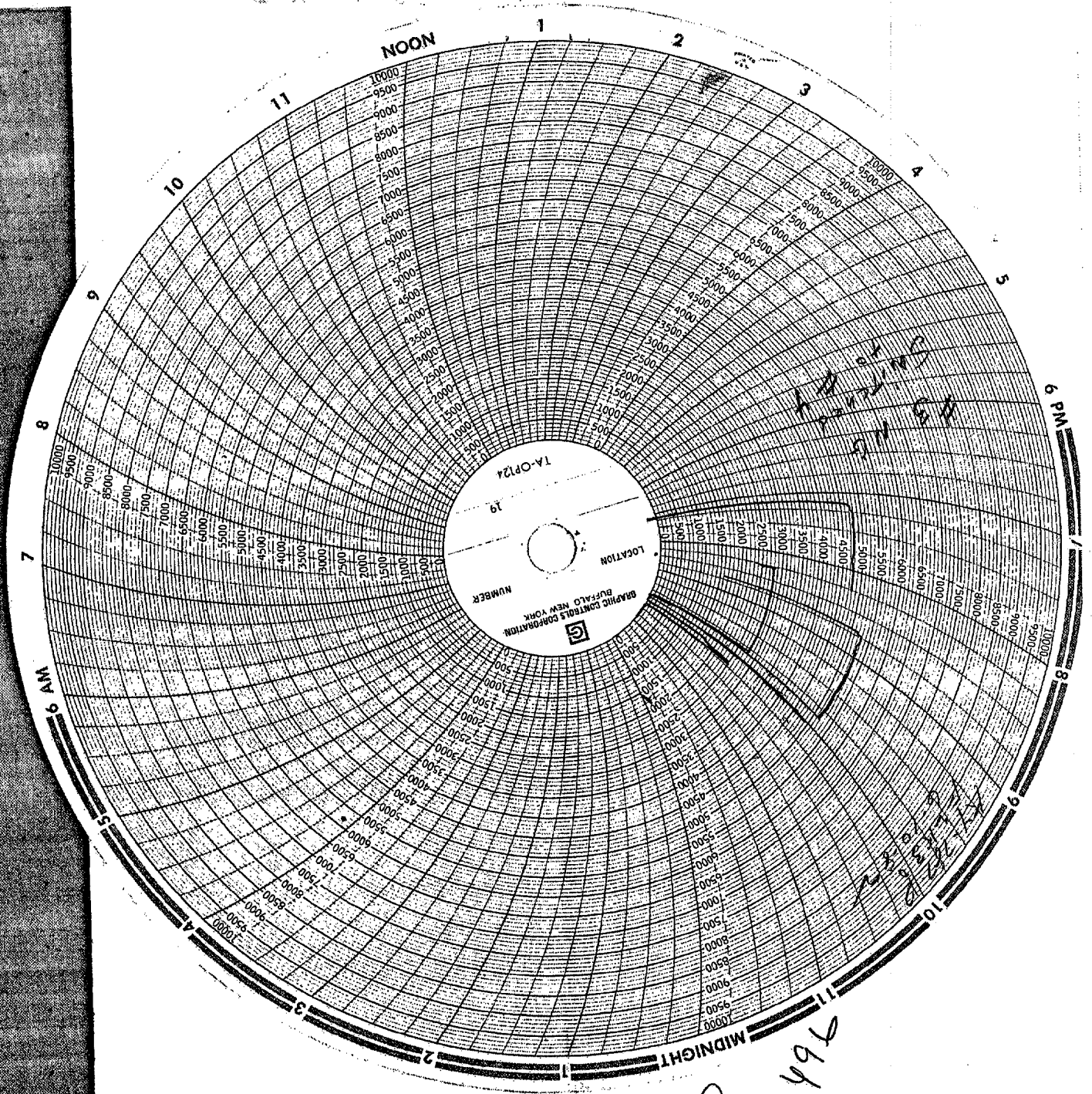
21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0  
SV 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO  
SP 23 OPERATOR STEP PB  
24 SP STEP 10/43. WHEN 3FC20, 8FC10, & 8FC20 FLOWS  
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB  
5 25 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN  
LIMITS, SWITCH 3FC20 TO REMOTE  
26 OPERATOR STEP PB  
27 DURING STRIKE RECORD:  
SP STEP  
V-243/V-244  
PH RANGE TIME  
13/46 (30 MIN) 9.9 9.0-10.0 1140  
14/47 (60 MIN) 9.9 9.0-10.0 1210  
15/48 (2 HRS) 9.8 9.0-10.0 110  
16/49 (2 HRS, 25 MIN) 9.8 9.0-10.0 133  
17/50 (FINAL 3 HRS) 8.1 7.5-8.5 210  
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%  
11:10

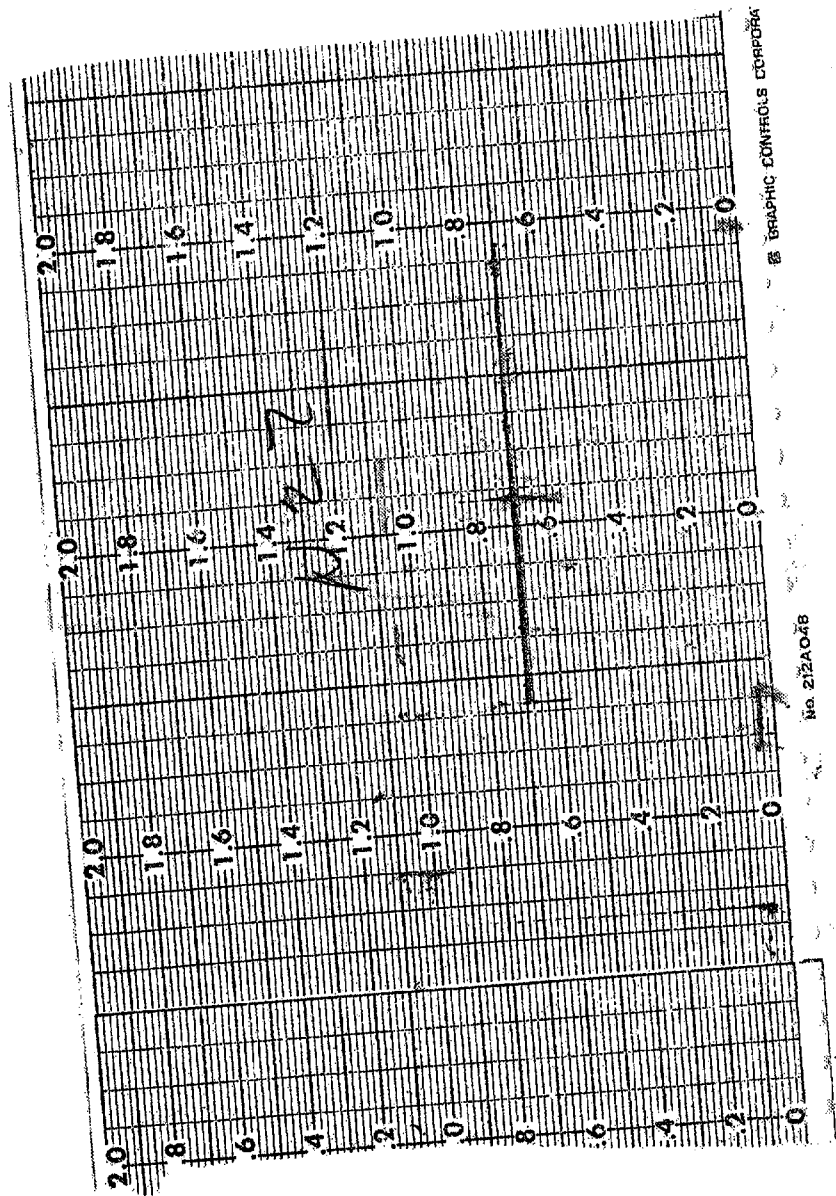
128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339  
129 ADD IN 7-8 MIN. CHECK FOR DRAFT IN VENT STACK 365 530-A 365  
BEFORE DUMPING.  
339 130 ADJ TO 49" (382 G) AT 80-100°F  
6 131 STIR 5 MIN & RECORD: PH 9.2 (9.5-10.5)  
132 STIR 15 MIN OR LONGER FOR SP STEP 26  
133 RECORD: VOL 51 & CALC 51 X 0.78 39.8 GAL  
134 SET PRESET #8 TO 39.8 GAL FROM S 33

305 135 RUN 47" (360 G) WATER INTO V-385  
7 136 ADD & STIR 2 MIN FOR S 40 2 ASSUME 50% 160 7-D 80

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.  
138 SIFT IN 100 128-A 100  
SV 139 SP STEP 23/53. RECORD: PH 4.0 (3.7-4.2)  
SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5  
MIN  
8 141 RECORD: PH 9.5 (9.0-9.5). ADJ IF NECESSARY &  
RECORD: PH \_\_\_\_ ASSUME 77%  
(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%  
(SIPHON N-7-D INTO SV)  
142 OPERATOR STEP PB  
143 SP STEP 29/58. RECORD: PH 9.3 & TIME 3:15  
144 OPERATOR STEP PB  
145 SP STEP 60. BATCH COMPLETE.

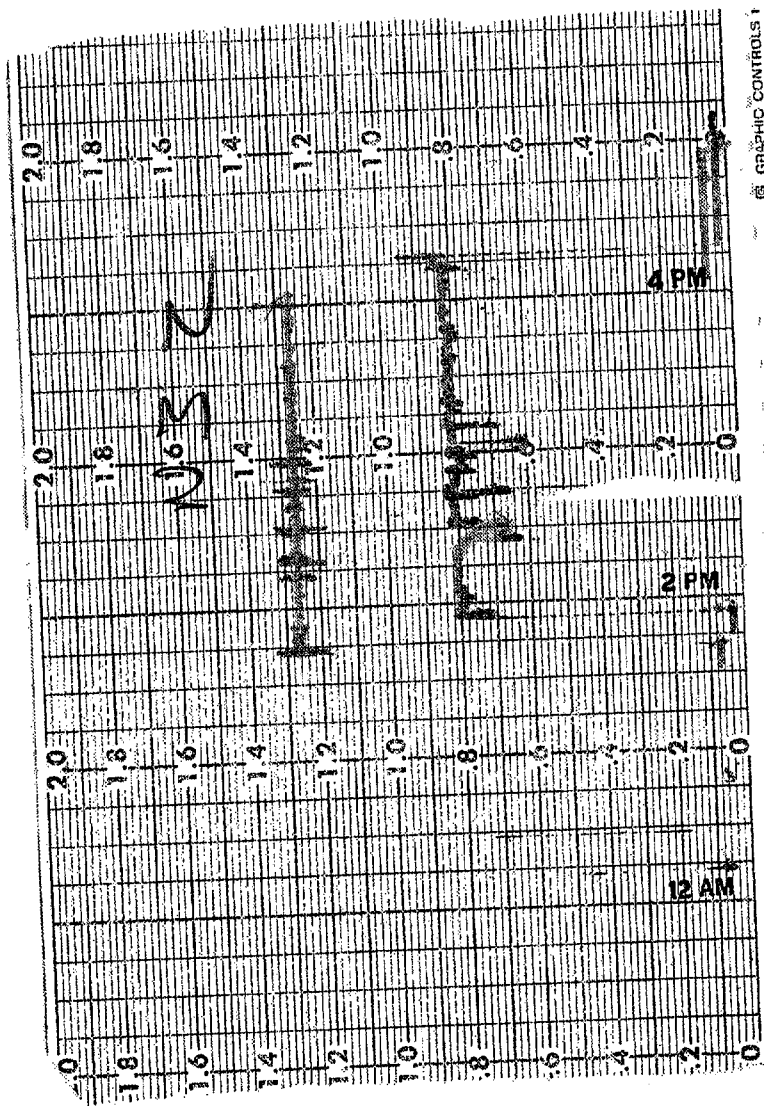
| START           | FINISH          | OPTR               |
|-----------------|-----------------|--------------------|
| TIME SP STEP    | TIME SP STEP    |                    |
| <u>11:20 AM</u> | <u>3:00 PM</u>  | <u>320-342-209</u> |
| <u>8:45 PM</u>  | <u>11:00 PM</u> | <u>126-301</u>     |
| <u>11:00 PM</u> | <u>11:00 PM</u> | <u>320-342</u>     |
| <u>7:15 P</u>   | <u>11:00 PM</u> | <u>126-301</u>     |





GRAPHIC CONTROLS CORPORATION

No. 212A048



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