

CG 03 CODE KY-788-D PKG

LOT MAY -0.81-31390

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME _____ M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 5/14/80

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JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	13626	93	2600	14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	

03 Rg 781D

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

DELAY-STEP 10 - Impact Valve Replaced 5:15 AM

TOTAL EST'D WGT 3560 3610 Homog #4 - 222 Pcs NON-BLEEDING

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	345	32-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
1	RECORD: START 4:30 PM LOT 13626	2600		
	FIN 5:30 PM	1X50	Rg 781D	50
	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 41" & 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 4800-5200 PSI INTO SV.			
	RECORD: TIME START 5:15 A TOTAL MINUTES 170			
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 3 (V-243) OR POSITION B (V-244)			
CP 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 46% PRESET #2 208 GAL	15-A		416
	B. 13LG 26% 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			
	BFC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM	32-D		1215
	BFC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	BFC20 (N-32-D WATER) IN REMOTE			
	BFR10 (N-32-D/WATER) RATIO 1.1			

V-243

320 ~~116~~ OPERATOR STEP PB
 SV ~~117~~ RECORD LEVEL 2LG 54% IF <35% FOLLOW SOLUTION
 SP ~~118~~ MAKE-UP PROCEDURE FOR N-27-D
 CP ~~119~~ ADJUST SV TO 47" (2400 G)
 4 ~~120~~ RECORD PH 9.2. ADJ TO 11.0-11.2 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 SIPHON INTO SV. RECORD: PH 4.1. ASSUME 50% 40 7-D 20
~~120~~ OPERATOR STEP PB

SV ~~121~~ SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5
 SP ~~122~~ 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 ~~125~~ SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
~~126~~ OPERATOR STEP PB
~~127~~ DURING STRIKE RECORD: 9:15 AM
 SP STEP
 V-243/V-244
 PH RANGE TIME
 13/46 (30 MIN) 9.4 9.3-10.0 9:45 AM
 14/47 (60 MIN) 9.6 9.3-10.0 10:15 AM
 15/48 (2 HRS) 9.6 9.3-10.0 11:15 AM
 16/49 (2 HRS, 25 MIN) 9.6 9.3-10.0 11:40 AM
 17/50 (FINAL 3 HRS) 9.3 7.5-8.5 12:15 PM
 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 ____

~~128~~ WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
~~129~~ ADD IN 7-8 MIN 350 530-A 350
 339 ~~130~~ ADJ TO 49" (382 G) AT 80-100°F
 6 ~~131~~ STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)
~~132~~ STIR 15 MIN OR LONGER FOR SP STEP 26/56
~~133~~ RECORD: VOL 49 " & CALC 49 " X 0.78 = 38.7 GAL
~~134~~ SET PRESET #8 TO 38.7 GAL FROM S 33

302 ~~135~~ RUN 40" (440 G) WATER INTO V-302
 7 ~~136~~ ADD & STIR 2 MIN FOR S 40 ASSUME 50% 360 7-D 180

~~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) ____ 27-D ____
~~142~~ OPERATOR STEP PB
~~143~~ SP STEP 29. RECORD: PH 9.2 & TIME 1:15 PM
~~144~~ OPERATOR STEP PB
~~145~~ SP STEP 60. BATCH COMPLETE.

START
 TIME SP STEP
5:15 PM
11:00 P
1:00 AM

FINISH
 TIME SP STEP
11 PM
2:10 PM
1:25 PM

OPTR
54-301
235-244
381.223

PUMPED TO VAT 240