S.V. ~~243~~ 244 (AUTOMATED) 3/22/82 QRR

CG 03 CODE KY-781-D PKG
LOT F2J27 MAY 28 1982

PROCESSES APPROVED BY
( ) KY-781-D (N) FWP 03/19/82
( )
( )
( )

STANDARD HRS. TIME _____ M

JOB NAME: 03KY781DMN

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC003B	D2J30	93	1300
14	YC003B	14274	93	2000
14	YC003B	_____	93	_____

CG	CODE	LOT	PQ	LBS
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
		"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
203 & 205	1	RUN 60"(990 G) WATER IN V-203 & ADD ASSUME 50% SET AGITATOR ON HIGH SPEED.	36	7-D	18
	2	WEIGH IN DRUM & POUR IN	442	32-D	442
	3	DUMP IN AND STIR 5 MIN LOT	66X50	YC-3-B	3300
		RECORD: START 3:30 P.M. D2J30	1300		
1		FIN 4:30 P.M. 14274	2000		
			_____		
	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 46" & ADJ TO 45" (1662 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 3:15 P.M. TOTAL MINUTES 240			
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 & CF	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 1 (V-243) OR POSITION 6 (V-244)	JUN 3 1982		
	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 30 % PRESET #3 70 GAL		115-A	374
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		8FC10 (N-27-D CONTROLLER) IN MANUAL .0.90 GPM		27-D	373
		8FC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM			
		8FR10 (N-27-D/WATER) RATIO 0.7			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM		32-D	2507
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 0.2			

EQUIP		PAGE 2 OF 3 KY-781-D	USE LBS	N CODE	USE LBS
		COMTYP JOB NAME: 03KY781DMN			
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 52% IF (35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 54" (2800 G)			
CP	19	RECORD PH 9.6. ADJ TO 11.4-11.6 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.4 ASSUME 50%	100	7-D	50
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.7			
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 8:45			
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD:			
		SP STEP V-243/V-244 — PH — RANGE — TIME			
		13/41 (30 MIN) — 9.7 — 9.3-10.0 — 9:15			
		14/47 (60 MIN) — 9.7 — 9.3-10.0 — 9:45			
		15/48 (2 HRS) — 9.7 — 9.3-10.0 — 10:45			
		16/49 (3 HRS) — 9.65 — 9.3-10.0 — 11:45			
		17/50 (FINAL) — 8.1 — 7.5-8.5 — 12:30			
		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	____
385	28	RUN 49" (379 G) WATER INTO V-385			
6	29	ADD & STIR 5 MIN ASSUME 50%	124	7-D	62
	30	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	31	SIFT IN	150	126-A	150
SV	32	SP STEP 23/53.			
	33	RECORD: PH 3.4 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH ___	_____	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	34	RUN IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
7	35	RECORD: PH 4.25 (4.2-4.4). 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)			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - ADD & STIR 5 MIN	40	978-A	40
	38	OPERATOR STEP PB			
	39	SP STEP 60. BATCH COMPLETE.			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
4:00 PM	_____	7:00 PM	_____	3720
7A	_____	130	_____	120-140
____	_____	____	_____	____

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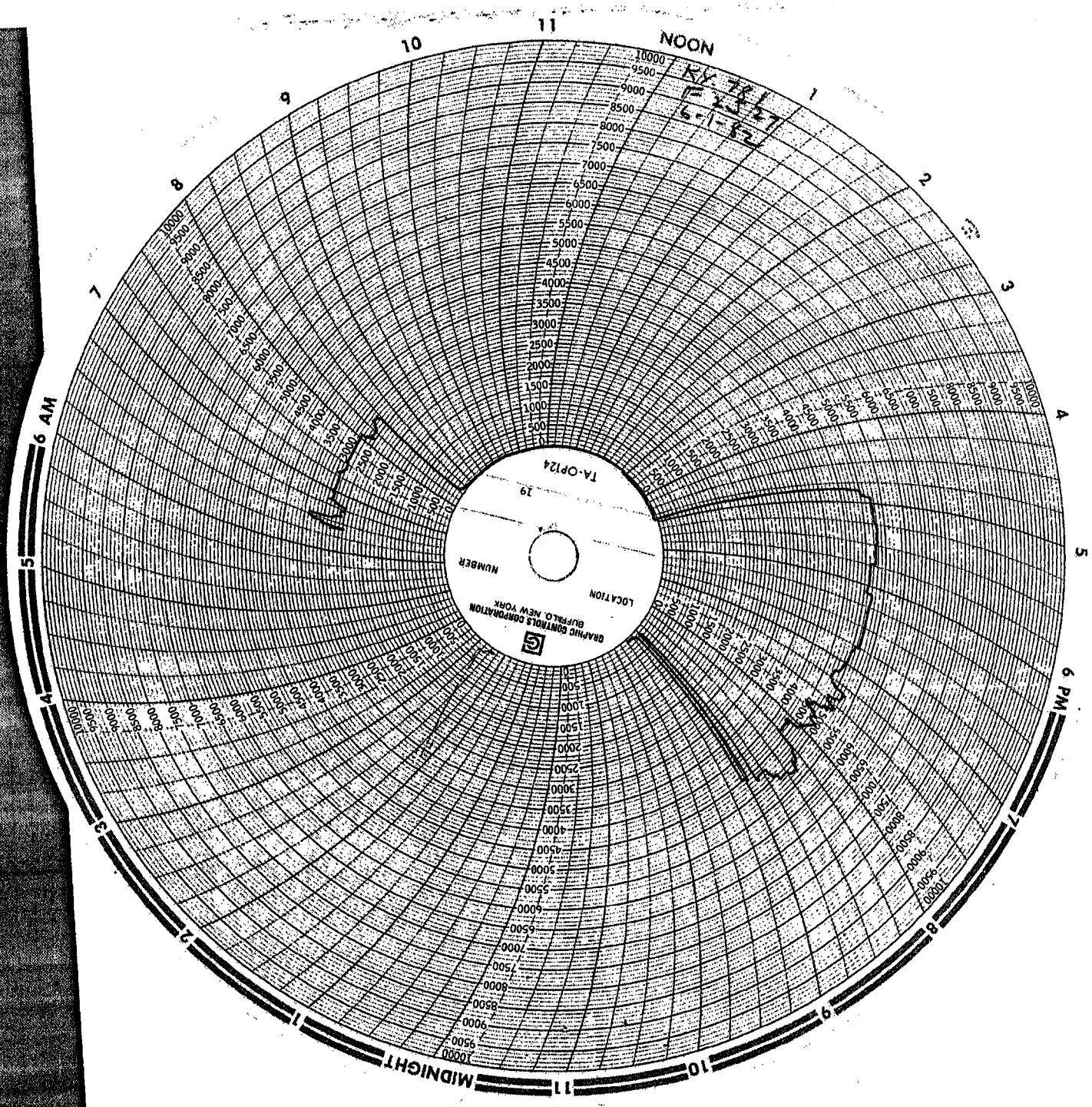

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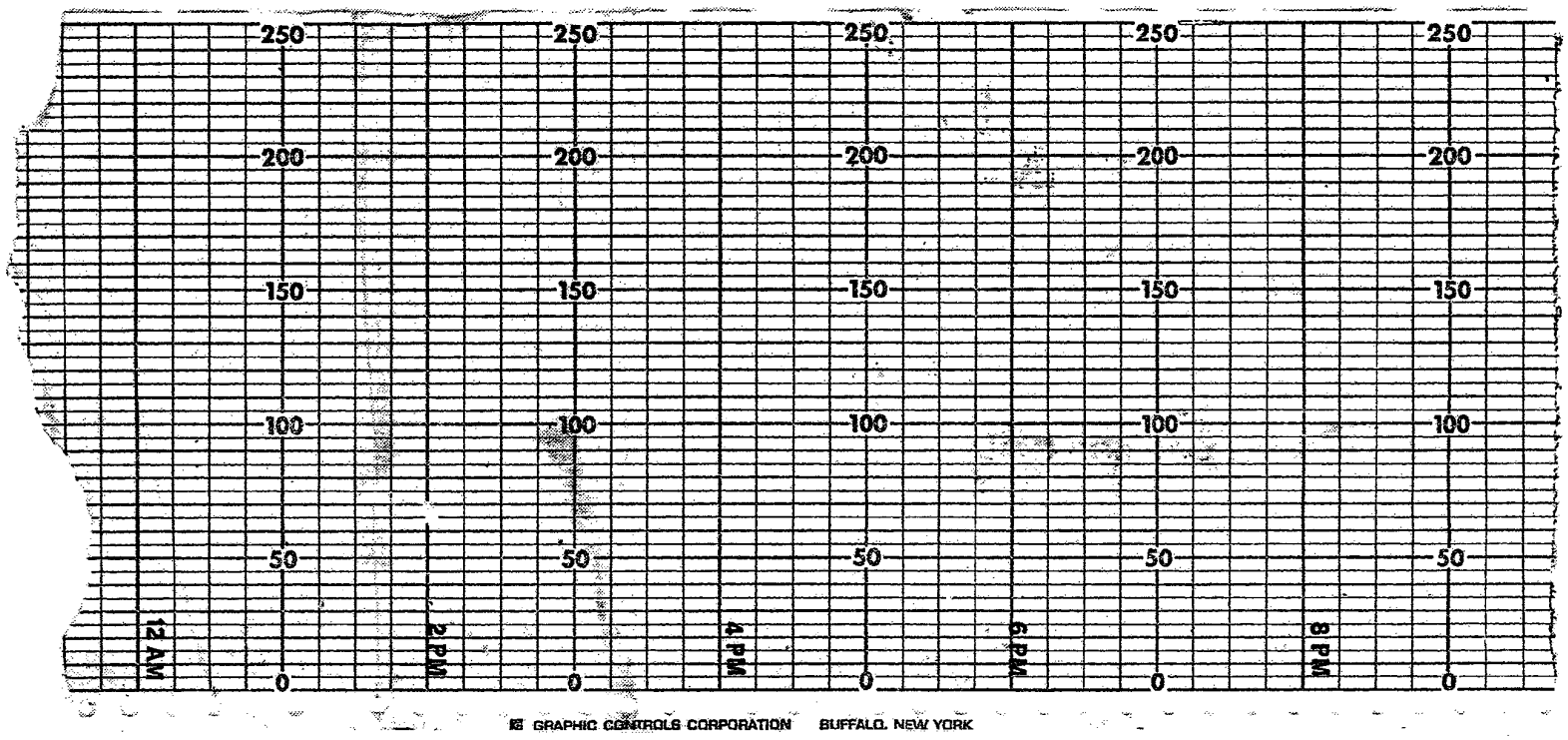

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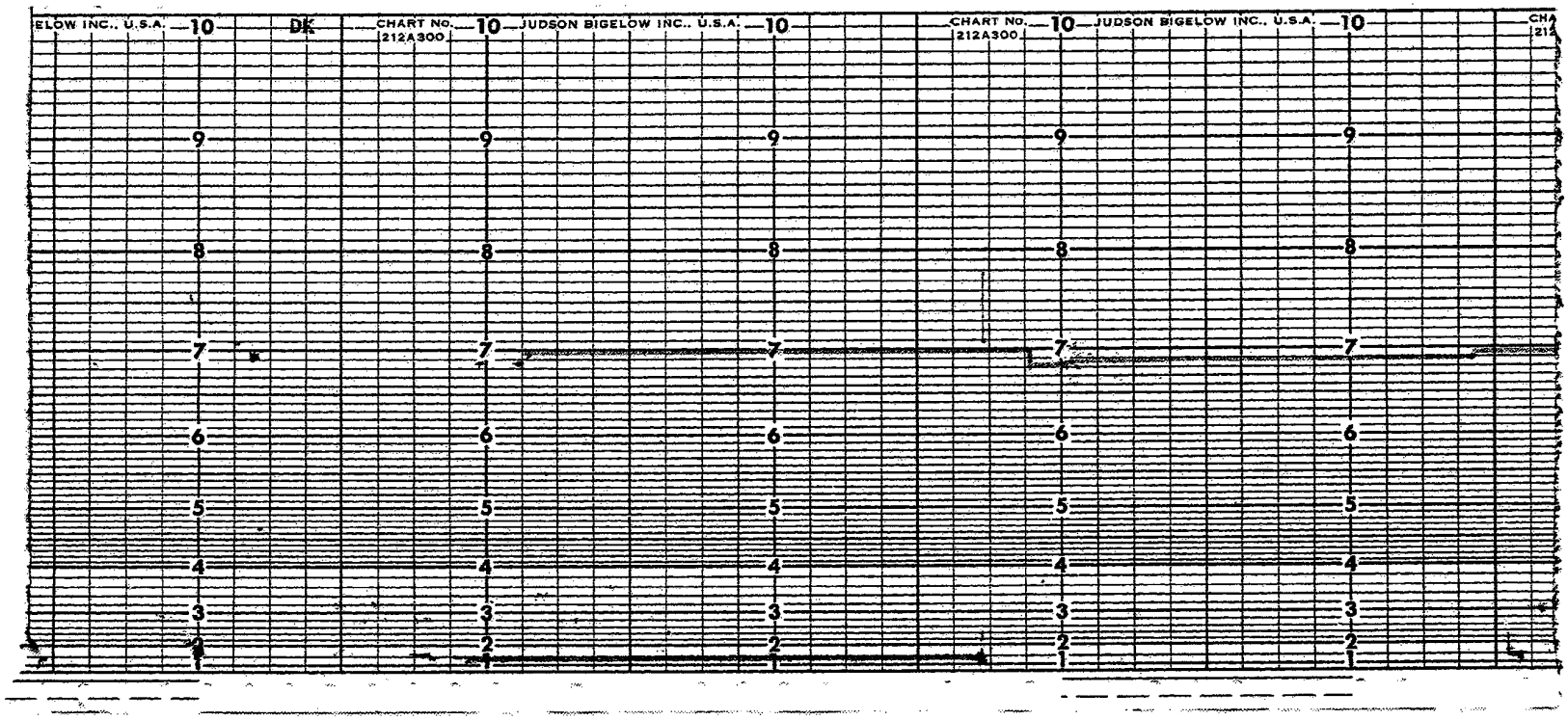

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