

JUN 8 1982

F2H94

M dr

() KY-795-D (H) FWP 03/23/82

DATE

LOT NUMBER

TIME

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COMTYP JOB NAME = 03KY795DMH

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	22E 05	93	3700	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 4548* LBS.

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NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
	NAME : "KROLOR" YELLOW MEDIUM			
203 & 205	1. BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF.			
	2. RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	3. WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	500	32-D	500
	RECORD: START 11:15 PM FIN 12:30 AM	74X50	YC-2-B	3700
	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 51" & ADJ TO 60" (2100 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 11:25 AM TOTAL MINUTES 9.5			
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 & CP	12. SP STEP 01 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (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 22% PRESET #1 41 GAL		115-A	220
	15. SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.75 GPM		27-D	313
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 7.35 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.98			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.96 GPM		32-D	2022
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 7.20 GPM			
	3FR10 (N-32-D WATER) IN REMOTE 1.50			

6/7

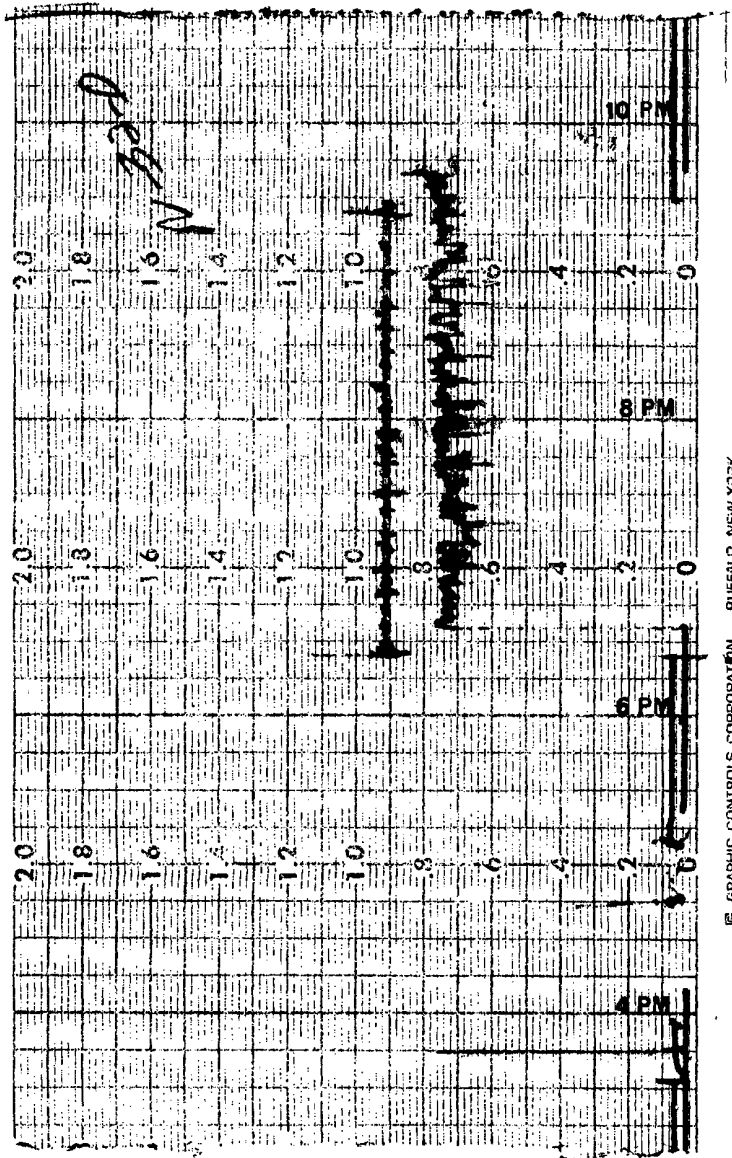
110	OPERATOR STEP PB				
112	RECORD LEVEL 2LG 52% IF (35% FOLLOW SOLUTION				
SV	MAKE-UP PROCEDURE FOR N-27-D				
SP	ADJUST SV TO 58" (2980 G)				
CP	RECORD PH 10.2 ADJ TO 11.1-11.3 WITH N-7-D AT				
	5% (10 PARTS WATER TO 1 PART N-7-D)				
4	SIPHON INTO SV. RECORD: PH	ASSUME 50%		7-D	
120	OPERATOR STEP PB				

121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 16.0				
SV	122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
SP	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	2:50			
	127 DURING STRIKE RECORD:				
	SP STEP				
	V-243/V-244				
	13/46 (30 MIN)	PH 9.8	RANGE 9.0-10.0	TIME 3:20	
	14/47 (60 MIN)	9.8	9.0-10.0	3:50	
	15/48 (2 HRS)	9.4	9.0-10.0	4:50	
	16/49 (3 HRS)	9.4	9.0-10.0	5:50	
	17/50 (FINISH)	7.6	7.5-8.5	6:35 A	
	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	

DRUM	128 WEIGH INTO 55 GAL DRUM	ASSUME 50%	60	7-D	30
6	129 FILL WITH WATER & STIR 2 MIN				

130	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.				
SV	131 SP STEP 23/53 - RECORD: PH 3.2 (3.3-3.7)				
SP	132 IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7				
&	RECORD: PH				
CP	NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA				
7	BADGER METER. STIR 5 MIN AFTER EACH ADDITION.	ASSUME 50%			
	133 SIFT IN			115-A	
	134 SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR			128-A	
	5 MIN				
	135 RECORD: PH 3.5 (4.0-4.2) & IF NECESSARY ADJ TO				
	PH 4.0-4.2 & RECORD: PH 4.2	ASSUME 77%		27-D	
	(DILUTE 10 TO 1 WITH WATER)	ASSUME 50%	60	7-D	30
	SIPHON N-7-D INTO SV				
	136 OPERATOR STEP PB				
	137 SP STEP 24/54 - POUR IN & STIR 15 MIN		45	978-A	45
	138 OPERATOR STEP PB				
	139 SP STEP 60 - BATCH COMPLETE				
	140 OPERATOR STEP PB				

START TIME SP STEP	FINISH TIME SP STEP	OPTR
3:20 PM	8:20 P.M.	34-126



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

