

CG 03 CODE KY-788-D PKG

LOT MAY -0-81-21391

PROCESSES

APPROVED BY

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

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME _____ M

JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	14016	93	2600	14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	
03	Ky 781 D	82946-1	98	50					

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

TOTAL EST'D WGT 3560

3610

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	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 10:30 AM FIN 11:12 AM	2600		
	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 25" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 2:30 P TOTAL MINUTES 120			
	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 8 (V-244)			
CP 13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
3	REMOTE (TEMP IS SET AT 190-194°F)			
	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 30% PRESET #2 208 GAL	15-A		416
	B. 13LG 20% PRESET #6 135 GAL	20-A		135
	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			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM	32-D		1215
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
	8FR20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.1			

243

320	117	OPERATOR STEP PB			
SV	118	RECORD LEVEL 2LG 8.6% IF (35% FOLLOW SOLUTION			
SP	119	MAKE-UP PROCEDURE FOR N-27-D			
CP	120	ADJUST SV TO 42" (2400 G)			
	121	RECORD PH 9.5 ADJ TO 11.0-11.2 WITH N-7-D AT			
	122	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	123	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	50	7-D	25
	124	OPERATOR STEP PB			

SV	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 7.9			
SP	122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	123	OPERATOR STEP PB			
	124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
	125	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	126	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
	127	LIMITS, SWITCH 3FC20 TO REMOTE			
	128	OPERATOR STEP PB			
	129	DURING STRIKE RECORD:			
	130	SP STEP			
	131	V-243/V-244			
	132	PH RANGE TIME			
	133	13/46 (30 MIN) 9.6 9.3-10.0 1.30			
	134	14/47 (60 MIN) 9.55 9.3-10.0 2.00			
	135	15/48 (2 HRS) 9.5 9.3-10.0 3.00			
	136	16/49 (2 HRS, 25 MIN) 9.5 9.3-10.0 3.25			
	137	17/50 (FINAL 3 HRS) 8.0 7.5-8.5 4.00			
	138	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE			
	139	IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.			
	140	& RECORD: PH ASSUME 77%		27-D	

1:00/AM

339	128	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
	129	ADD IN 7-8 MIN	350	530-A	350
6	130	ADJ TO 49" (382 G) AT 80-100*F			
	131	STIR 5 MIN & RECORD: PH 10.0 (9.5-10.5)			
	132	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
	133	RECORD: VOL 49" & CALC ---" X 0.78 = 38.2 GAL			
	134	SET PRESET #8 TO --- 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

SV	137	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	138	SIFT IN	100	128-A	100
SP	139	SP STEP 23/53. RECORD: PH 3.2 (3.7-4.2)			
	140	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
	141	MIN			
8	142	RECORD: PH 9.3 (9.0-9.5). ADJ IF NECESSARY &			
	143	RECORD: PH ASSUME 77%		27-D	
	144	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%		7-D	
	145	(SIPHON N-7-D INTO SV)			
	146	OPERATOR STEP PB			
	147	SP STEP 29. RECORD: PH 9.3 & TIME 5:15/AM			
	148	OPERATOR STEP PB			
	149	SP STEP 60. BATCH COMPLETE.			

PUMP V-243 TO V-240

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
5:00 P	11:00	301-126
11:00 P		232-244