

MAY -0.81-21559
DATE LOT NUMBER

0129 () KY-907-D (D) FWP 05/14/81
KP () () () ()

STANDARD HRS. 8.9 TIME M

COMTYP JOB NAME: 03KY907DBD

COMPONENT CONSUMPTION

CG	CODE	LOT	PR	LBS	CG	CODE	LOT	PR	LBS
14	YC002B	13359	93	2000	14	YC002B		93	
14	YC002B	13367	93	500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

DO NOT USE LOTS 13839 - 13855

Homog 3-12TP 8.9
10 3-2ND

TOTAL EST'D WGT 3451

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
203	2 WEIGH IN DRUM & POUR IN	250	32-D	250
1	3 DUMP IN AND STIR 5 MIN. RECORD: START 8:25 AM FIN 9:00 AM	50X50 2000 500	YC-2-B	2500
263	4 ADJUST TO 75" (1275 G)			
263	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
263	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
263	7 RECORD: V-203 VOL & ADJ TO 60" (2100 G)			
263	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. RECORD: TIME START 6:45P TOTAL MINUTES 110			
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 2 (V-243) OR POSITION 7 (V-244)			
3	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 44% PRESET #1 84 GAL		15-A	168
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	0FC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM		27-D	213
	0FC20 (N-27-D WATER) IN MANUAL LOCAL 8.36 GPM			
	0FR10 (N-27-D/WATER) RATIO 1.31			
	0FC10 (N-32-D CONTROLLER) IN MANUAL .84 GPM		32-D	1425
	0FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
	0FC20 (N-32-D WATER) IN REMOTE			
	0FR10 (N-32-D/WATER) RATIO 1.76			

THA

V-243

320	15	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 69% IF BELOW 35% FOLLOW SOL 'N'			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 48" (2470 G)			
	20	RECORD PH 9.5. 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 11.1. ASSUME 50%	40	7-D	20
	20	OPERATOR STEP PB			

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5			
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	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) 9.3 9.0-10.0 10:45 P.M.			
		14/47 (60 MIN) 9.5 9.0-10.0 11:15 P.M.			
		15/48 (2 HRS) 9.2 9.0-10.0 12:15 P.M.			
		16/49 (2 HRS, 25 MIN) 9.7 9.0-10.0 12:40 P.M.			
		17/50 (FINAL 3 HRS) 7.5 7.5-8.5 1:15 P.M.			
		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%			
	28	SIFT IN	50	128-A	50

302	29	ADD 17" (208 G) WATER TO V-302			
6	30	ADD & STIR FOR 2 MIN FOR S 57 D ASSUME 50%	60	7-D	30

PT	31	DURING STRIKE PUMP INTO PT	330	169-A	330
	32	PUMP IN	37	155-A	37
7	33	PUMP IN	37	160-A	37
	34	STIR 10 MIN WITH LIGHTENING MIXER FOR S 38			

	35	DURING STRIKE RUN 14" (244 G) WATER INTO V-356			
	36	TURN ON STEAM			
356	37	ADJ TO 18" (317 G) AT 81-82°C			
9	38	PUMP PT MIXTURE FROM S 34 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE			
	39	RINSE PT WITH HOT WATER FROM HOT WATER MIXER & PUMP IN			
	40	SHUT OFF PUMP			
	41	STIR 30 MIN AT 81-82°C FOR S 48			
	42	DO NOT SHUT OFF AGITATOR			

USE
LBSN-
CODEUSE
LBS

SV 43 WHEN S 27 COMPLETE, HEAT SV TO 198-200°F IN
5-10 MIN

44 CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE
PUMP

45 OPEN V-356 DISCHARGE VALVES TO STEARATE PUMP
INLET

46 OPEN WATER VALVE AT STEARATE PUMP & RUN WATER
THRU HOMOG AT 2900-3100 PSI TO SEWER

47 WHILE HOMOG WATER, OPEN HOMOG DISCHARGE VALVE
TO SV & CLOSE VALVE TO SEWER

48 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
TURN ON PUMP & HOMOG V-356 TO SV AT 2900-3100
PSI. MAINTAIN SV AT 198-200°F.

49 WHILE HOMOG V-356 TO SV, SHUT OFF WATER VALVE
AT STEARATE PUMP ASAP

50 WHEN HOMOG COMPLETE, RINSE IN V-356 WITH HOT
WATER FROM HOT WATER MIXER

51 TURN OFF HOMOG & STEARATE PUMP

52 STIR 5 MIN AT 198-200°F

53 SHUT OFF STEAM

54 OPERATOR PB

55 SP STEP 23/53. RECORD: PH 3.7 (3.3-3.7)

56 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)
& RECORD: PH ____.

NOTE: DISSOLVE EXTRA N-15-A IN WATER AT
110-120°F IN DRUM. USE 30 GAL WATER TO 50#
N-15-A. STIR SV 5 MIN AFTER EACH ADDITION.

57 RUN IN N-7-D FROM S 30IN 4-6 MIN & STIR 5 MIN

58 RECORD PH 4.4 (4.2-4.4) & IF NECESSARY ADJUST
TO PH 4.2-4.4 & RECORD PH ____ ASSUME 78%
(DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 50%

SIPHON N-7-D INTO SV

59 OPERATOR STEP PB

60 OPERATOR STEP PB

61 SP STEP. BATCH COMPLETE.

15-A

27-D

7-D

START - FINISH - OPER

9:00/ - 3:00PM - 235-244

3:00PM - 11:40PM - 381.201

11:00P - 4:25AM - 301-126