

AUTOMATED
V. (243) 244

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

WRT 4/12 MP

CG 03 CODE KY-790-D PKG
LOT APR 14 35346

EST'D WGT 3747 LBS

STANDARD HRS. TIME 10 PM

PROCESSES APPROVED BY

() KY-790-D (C) EWK11/03/77
() () MTW11/05/77
() () DCG 9/30/76
() () FWP01/12/79
() ()

TYPED BY: WT 4/10/80

COMPONENT CONSUMPTION
CG CODE LOT PQ LBS

CG CODE LOT PQ LBS

PUNCHED & CHECKED

APR 17 1980

Homog # 3 - 2nd Pass

12145 1980

TOTAL EST'D WGT 3747

NON-BLEEDING

QUIR	NAME : "KROLOR" YELLOW-PRIMROSE	USE LBS	N- CODE	ACCT LBS
203 & 205	1 RUN 60" (992 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 POUR IN	475	32-D	475
	3 DUMP IN			
1	RECORD: START 9:30 PM LOT 9136 FIN 10:50 PM 75" 12756	59X50	104-B	2950
	4 ADJUST TO 80" (1360 G) & RECORD: PH 9.8 (7.0-9.0)			
	5 PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205. SET V-203 AGITATOR ON LOW SPEED.			
U-203	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 1800-2200 PSI. DO S'S 7, 8, 9, 10 ASAP			
	7 RECORD: V-205 VOL " & ADJ TO 55" (2016 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 12" (617 G) WATER INTO V-243 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:30 AM TOTAL MINUTES 157			
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. RINSE WITH HOT WATER.			
SP 142	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 4 (V-243) OR POSITION 9 (V-244)			
CP 143	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 4.7% PRESET #3 59 GAL		15-A	112
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: A 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.80 GPM B 3EC20 (N-27-D WATER) MANUAL LOCAL 7.20 GPM C 3ER10 (N-27-D/WATER) RATIO 0.9 D 8FC10 (N-32-D CONTROLLER) IN MANUAL 1.03 GPM E 8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.67 GPM F 8FC20 (N-32-D WATER) IN REMOTE G 8FR10 (N-32-D/WATER) RATIO 1.1		27-D 32-D	333 2175

N32308

0102050457500

V-243

JIP PAGE 2 CG 03 KY-790-D EST WGT 3747#

USE N- USE
LBS CODE LBS

SV 116 OPERATOR STEP PB 5
 SP 117 RECORD LEVEL 2LG 72% IF <35% FOLLOW SOLUTION
 MAKE-UP PROCEDURE FOR N-27-D
 CP 118 ADJUST SV TO 63" (3238 G)
 RECORD PH 9.5 (7.0-9.0)
 4 119 OPERATOR STEP PB

SV 120 SP STEP 06/39- AFTER HEAT-UP, RECORD: PH 8.8 (9.0-9.5)
 SP 121 ADJUST PH TO 9.0-9.5 (UP ONLY) ASSUME 50% 20 7-D 10
 8 DILUTE TO 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 SIPHON INTO SV. RECORD: PH 9.35
 SV 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 123 OPERATOR STEP PB
 124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 IN LIMITS SWITCH 3FC10 TO AUTO. OPERATOR STEP PB.
 125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOW IN LIMITS,
 SWITCH 3FC20 TO REMOTE. OPERATOR STEP PB

126 DURING STRIKE RECORD PH & TIME AS FOLLOWS:
 SP STEP
 V-243/V-244

	PH	RANGE	TIME
13/46 (30 MIN)	9.15	9.0- 9.8	11:00
14/47 (60 MIN)	9.15	9.0- 9.8	11:30
15/48 (2 HRS)	9.3	9.0- 9.8	12:30
16/49 (3 HRS)	9.4	9.0- 9.8	1:30
17/50 (FINAL)	7.4	7.5-8.5	2:15

NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE
 IN LOG. IF FINAL PH IS ABOVE 8.5, ADJUST TO
 PH 7.5-8.5 & RECORD : PH 7.5-8.5 ASSUME 78% 27-D

10:30 AM
 Note
 Shut N-27
 Off 10 min Early
 2:05 PM

127 SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB
 129 SP STEP 23/53 - RECORD: PH 3.7 (3.3-3.7)
 130 IF NECESSARY, ADJUST PH TO 3.3-3.7 (DOWN ONLY)
 RECORD: PH 15-A

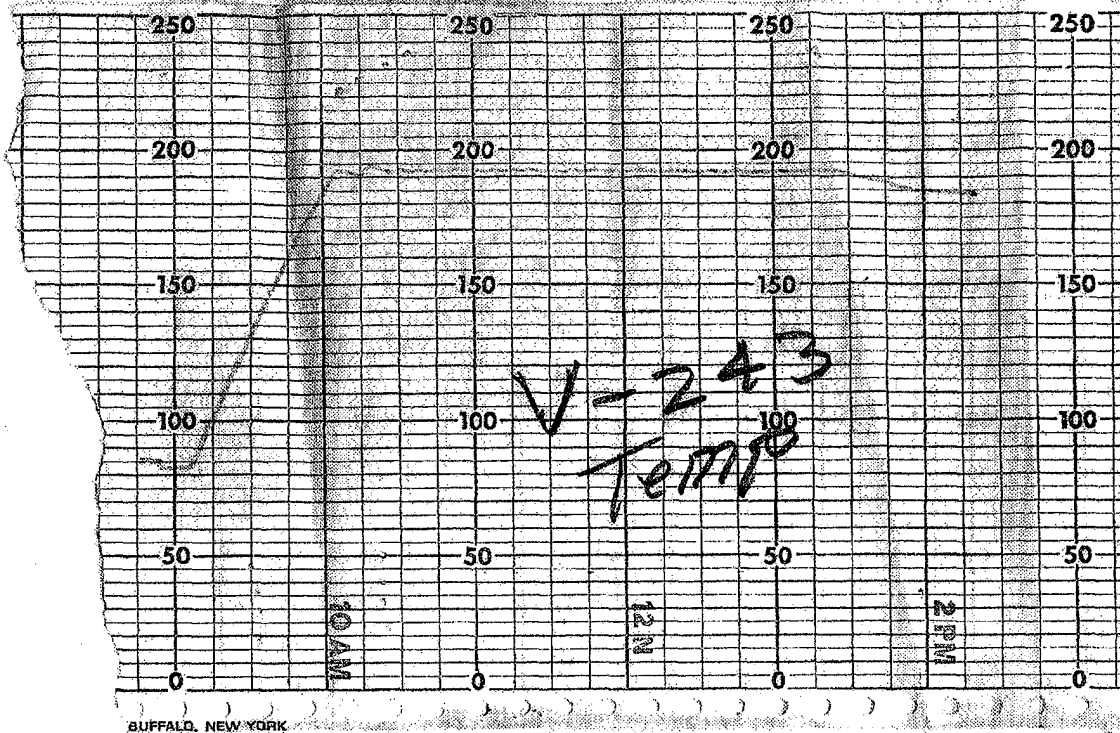
NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 110 -
 120* IN DRUM. USE +/-30 G OF WATER TO 50# N-15-A.
 STIR SV 5 MINS AFTER EACH ADDITION

131 ADJ PH TO 4.0-4.4 WITH DILUTE N-7-D (10 PARTS
 WATER TO 1 PART N-7-D)
 SIPHON N-7-D INTO SV & RECORD: PH 4.3 ASSUME 50% 10 7-D 5
 132 OPERATOR STEP PB
 133 SP STEP 60 - BATCH COMPLETE

START
 TIME SP STEP
 12:00 PM
 2:20 PM

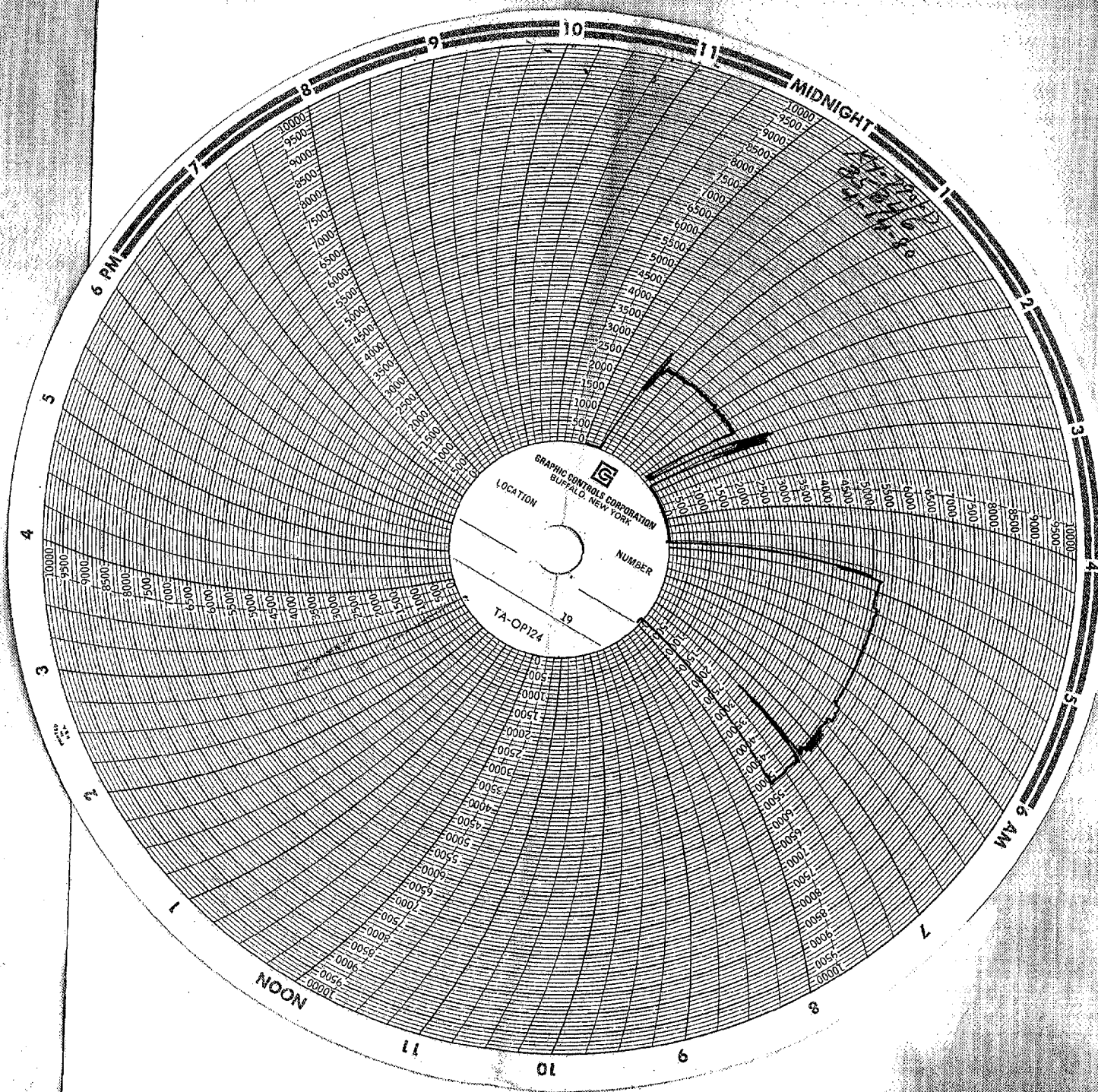
FINISH
 TIME SP STEP
 2:00 PM
 2:30 PM, 2:35-144

OPTR
 126-249



N32308.01

DUP050457511



N32308.02

DUP050457512

V-243