LOT

OCT 23 80 37582

STANDARD HRS. 8.2 TIME 110 M

( ) KY-795-D (H) FWP 10/17/80
( ) ( ) (XOB-17: 3/4
( ) ( ) N-32-D & 240
( ) ( ) MIN STRIKE)
( ) ( )
TYPED BY: FWP 10/17/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	13188	93	1500
14	YC002B	13177	93	2000
14	YC002B		93	

CG	CODE	LOT	PQ	LBS
14	YC002B		93	
14	YC002B		93	
14	YC002B		93	

CLEAN UP AS YOU GO ALONG

TOTAL EST'D WGT 4380

NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW MEDIUM	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	475	32-D	475
	3	DUMP IN AND STIR 5 MIN LOT 13188 #1500	70X50	YC-2-B	3500
1		RECORD: START 8:30 PM 13177 #2000 FIN 10 PM			
	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 ____" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 7:45A TOTAL MINUTES 140			
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 04 - 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 52 % PRESET #1 104 GAL		15-A	208
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		SFC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM		27-D	296
		SFC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
		SFR10 (N-27-D/WATER) RATIO 1.04			
		SFC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM		32-D	1885
		SFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		SFC20 (N-32-D WATER) IN REMOTE			
		SFR10 (N-32-D/WATER) RATIO 190 1.59			

F.N.

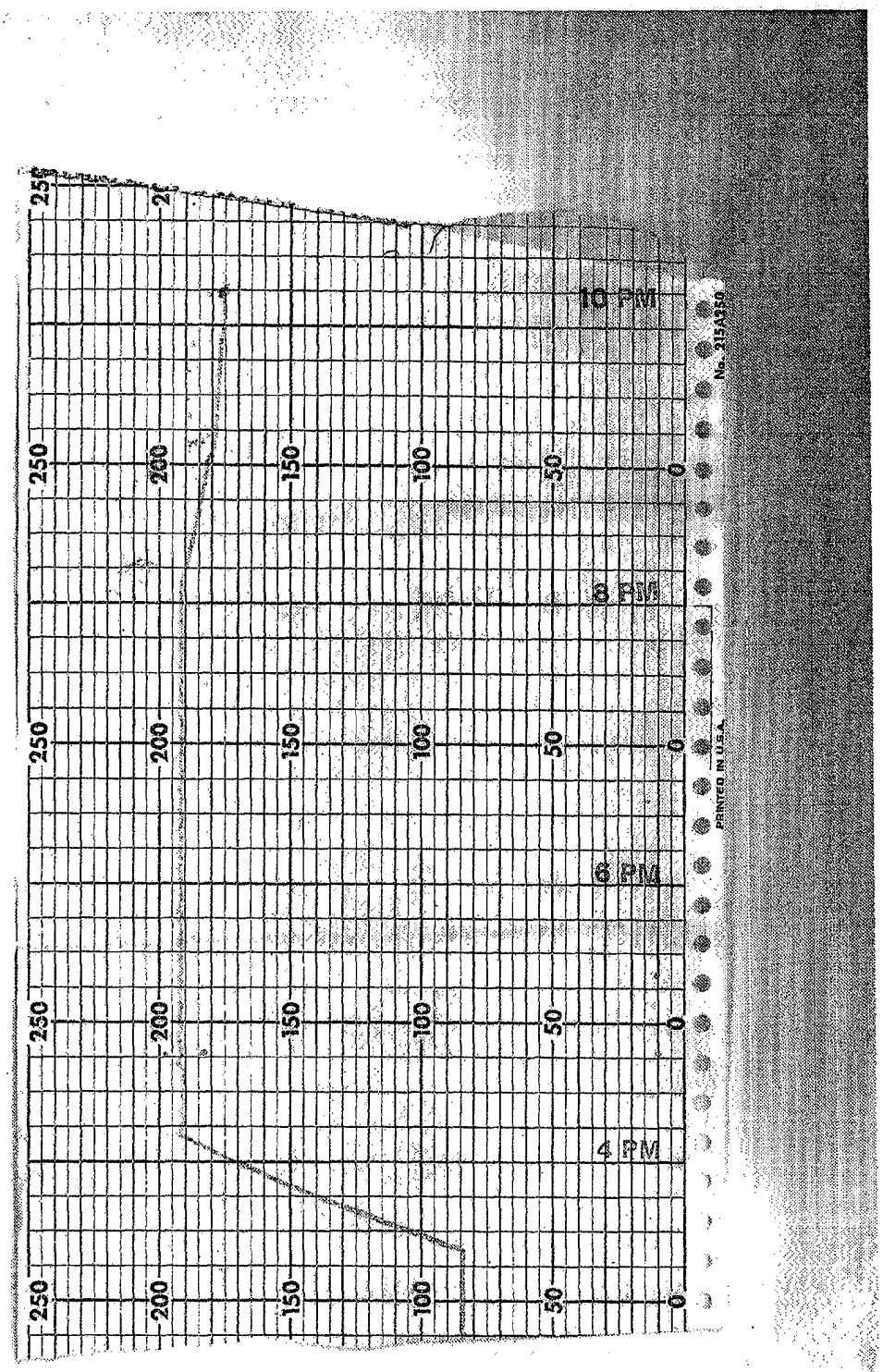
EQUIP		PAGE 2 CG 03 KY-795-D EST WGT 4380# V-243	USE LBS	N-CODE	USE LBS
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 76 % IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 58" (2980 G)			
CP	19	RECORD PH 10.3. ADJ TO 11.1-11.3 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.3. ASSUME 50%	24	721-D	24
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8.			
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			
	26	OPERATOR STEP PB			
	27	DURING STRIKE RECORD: 1250P			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.6 9.0-10.0 120P			
		14/47 (60 MIN) 9.45 9.0-10.0 150P			
		15/48 (2 HRS) 9.35 9.0-10.0 250P			
		16/49 (3 HRS) 9.2 9.0-10.0 350P			
		16/49 (4 HRS) 9.2 9.0-10.0 450P			
		17/50 (FINISH) 6.0 7.5-8.5 535P			
		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	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	28	721-D	28
6	29	FILL WITH WATER & STIR 2 MIN			
	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	31	SP STEP 23/53 - RECORD: PH ____ (3.3-3.7)			
SP	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
&		RECORD: PH 3.0	____	15-A	____
CP		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7		*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			
	33	SIFT IN	150	128-A	150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR			
		5 MIN			
	35	RECORD: PH 3.7 (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%	20	~~7-D~~ 721	20
		SIPHON N-7-D INTO SV			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN &STIR 15 MIN	22	978-A	22
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	40	OPERATOR STEP PB			
	41	PUMP TO V-240			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
700A		300P		259-301
3:00AM		7:30AM		37-244

DUP050106338

DUP050106339

2 AM
12 PM
10 PM
8 PM
6 PM
No. 215A164
BUFFALO, NEW YORK



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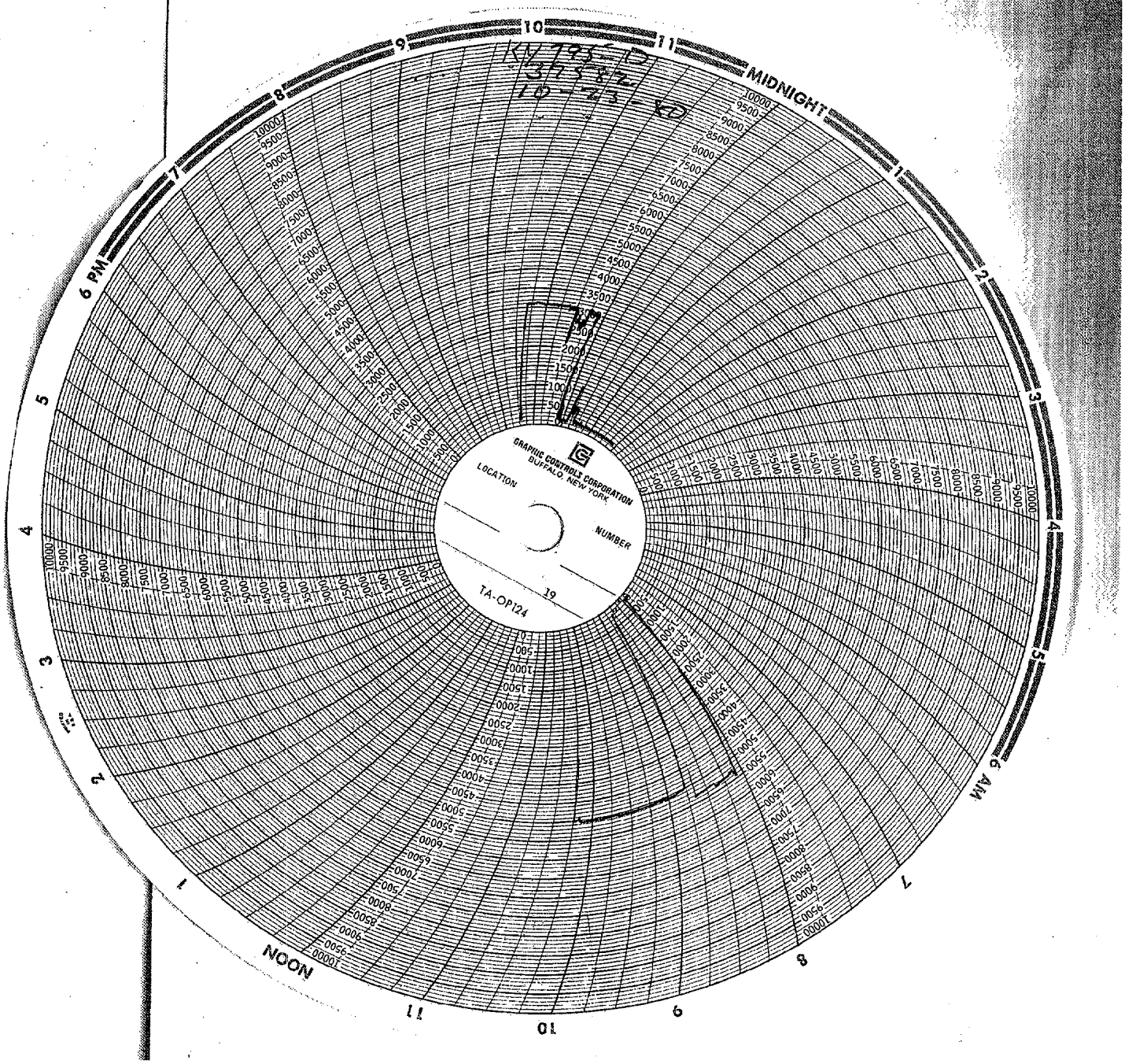

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