

(AUTOMATED)

S.V. 2243

C.V.

MAKING INSTRUCTIONS BATCH 001
D.V.

CG 03 CODE KY-788-D PKG

LOT DEC -1 80 38072

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME 3 P M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 11/3/80
 () () 4 HOUR STRIKE
 () () AS FOR XOB-17
 () ()
 () ()

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC003B	24721	93	2000
14	YC003B	13066	93	600
14	YC003B		93	

CG	CODE	LOT	PQ	LBS
14	YC003B		93	
14	YC003B		93	
14	YC003B		93	

Homog # 3 - 121 Pass
 " 04 3 - 204 "

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ADCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.	350		350
	2 WEIGH IN DRUM & POUR IN	345	983-D	345
	3 DUMP IN AND STIR 5 MIN. LOT 24721	52X50	YC-3-B	2600
	RECORD: START 4:20 PM	2000		
	FIN 5:35 PM	600		
	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 46" & 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 3:45 PM TOTAL MINUTES 120			
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 3 (V-243) OR POSITION B (V-244)			
	13 PRESS SV CAM RESET PB - SET 22 TO IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	11LG 66% PRESET #2 208 GAL		15-A	416
	13LG 42% PRESET #6 135 GAL		20-A	135
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM		27-D	160
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 0.8			
	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM		983-D	4245
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM			1240
	3FC20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.1			

24

EQUIP	PAGE 2	CG-03	KY-788-D	EST WGT	3540#	USE	N-	USE
						LBS	CODE	LBS

16	OPERATOR STEP PB			
320	RECORD LEVEL 2LC 66% IF (35% FOLLOW SOLUTION			
SV	MAKE-UP PROCEDURE FOR N-27-D			
SP	ADJUST SV TO 47" (2400 G)			
CP	RECORD PH 10.2 ADJ TO 11.0-11.2 WITH N-7-D AT			
	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	28	7-D	14
120	OPERATOR STEP PB			

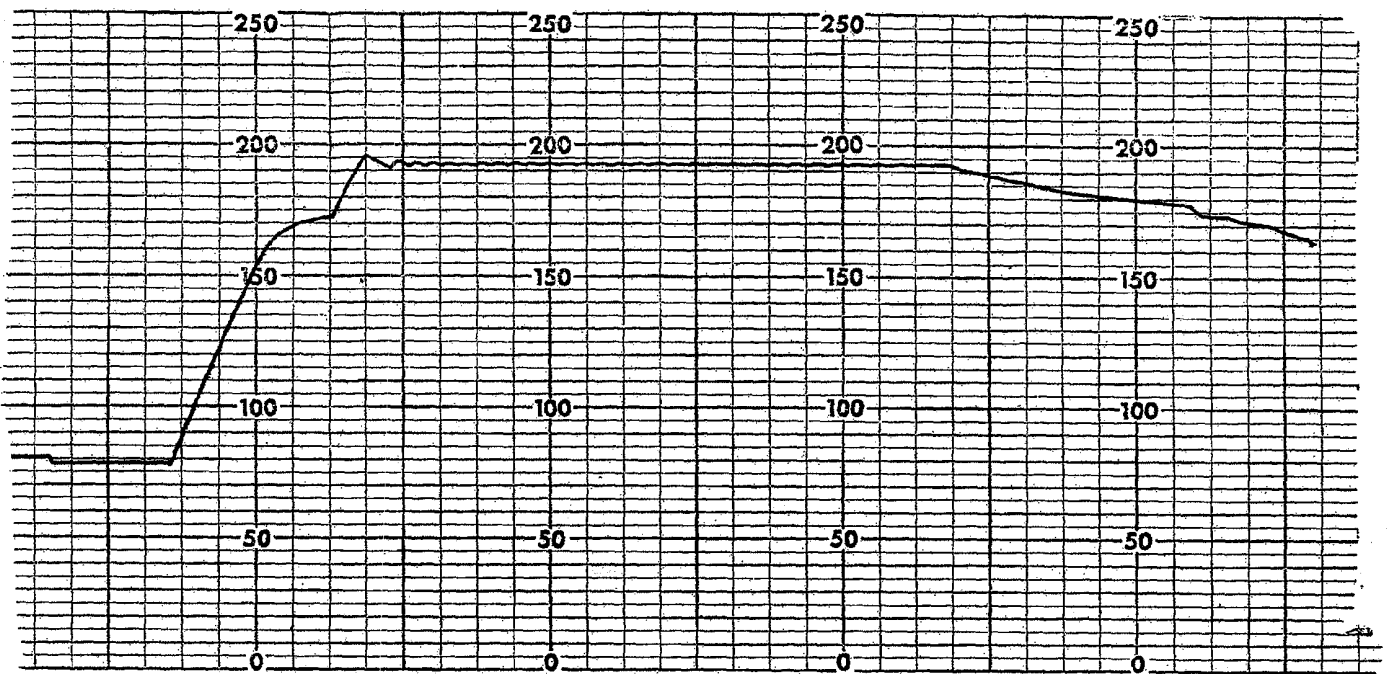
SV	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.1			
SP	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	OPERATOR STEP PB			
	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
	LIMITS, SWITCH 3FC20 TO REMOTE			
	OPERATOR STEP PB			
	DURING STRIKE RECORD:			
	SP STEP			
	V-243/V-244			
	13/46 (30 MIN) N-27 PH 9.5 RANGE 9.3-10.0 TIME 9:40			
	14/47 (60 MIN) 15 min PH 9.5 RANGE 9.3-10.0 TIME 10:10 PM			
	15/48 (2 HRS) PH 8.9 RANGE 9.3-10.0 TIME 11:10 PM			
	16/49 (3 HRS) PH 8.5 RANGE 9.3-10.0 TIME 12:10 AM			
	16/49 (4 HRS) PH 8.2 RANGE 9.3-10.0 TIME 1:10 AM			
	17/50 (FINISH) PH 7.5 RANGE 7.5-8.5 TIME 1:50 AM			
	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	

128	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
129	ADD IN 7-8 MIN	350	530-A	350
339	ADJ TO 49" (382 G) AT 80-100°F			
6	STIR 5 MIN & RECORD: PH (9.5-10.5)			
132	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
133	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
134	SET PRESET #8 TO 38.2 GAL FROM S 33			

302	RUN 40" (440 G) WATER INTO V-302			
7	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180

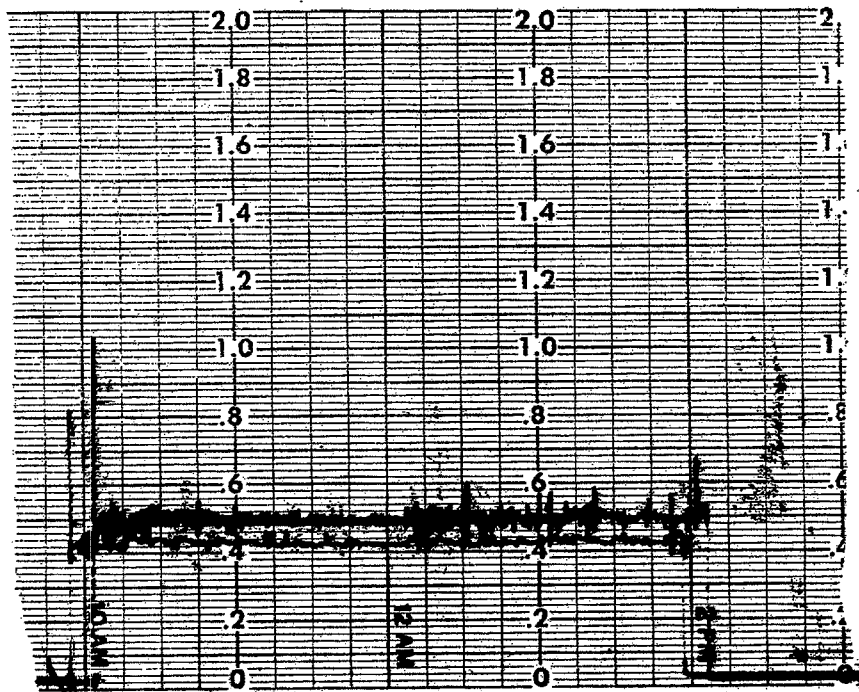
137	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
138	SIFT IN	100	128-A	100
SV	SP STEP 23/53. RECORD: PH 3.4 (3.7-4.2)			
SP	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
	MIN			
8	RECORD: PH 9.0 (9.0-9.5). ADJ IF NECESSARY &			
	RECORD: PH ASSUME 77%		27-D	
	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%		7-D	
	(SIPHON N-7-D INTO SV)			
42	OPERATOR STEP PB			
47	SP STEP 29. RECORD: PH 9.0 & TIME 3:30 AM			
44	OPERATOR STEP PB			
45	SP STEP 60. BATCH COMPLETE.			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
7:00 AM	3:00 PM	237-285
1:00 PM	3:30 AM	736



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

DUP050104100



MADE IN U.S.A.

