

LOT 19 80 37937

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 11P M

() KY-787-D (Q) FWP 11/3/80
 () () (XDB-17: 25%
 () () LESS N-32-D
 () & 240 MIN
 () () STRIKE)

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	37191	93	2220	14	YC002B	-----	93	-----
14	YC002B	37185	93	400	14	YC002B	-----	93	-----
14	YC002B	-----	93	-----	14	YC002B	-----	93	-----

TOTAL EST'D WGT 3332

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	240	983-D	240
	3 DUMP IN AND STIR 5 MIN LOT	48X50	YC-2-B	2400
	RECORD: START	-----	-----	-----
	FIN	-----	-----	-----
	44 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			
	7 OF HOT WATER AT 2400-2600 PSI INTO V-205			
	8 RECORD: V-205 VOL 55 " & ADJ TO 60" (2100 G)			
	9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
SV	10 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
	11 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 8:10 PM TOTAL MINUTES 128			
	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)			
	13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
	3 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 46% PRESET #1 80 GAL	15-A		160
	B. 13LG 12% PRESET #4 135 GAL	20-A		135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM	27-D		206
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.35			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM	983-D		1376
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.82			

use FWP
capitic

V-243

320 16 OPERATOR STEP PB
 SV 17 RECORD LEVEL 2LG 68% IF BELOW 35% FOLLOW SOL'N
 SP 18 MAKE-UP PROCEDURE FOR N-27-D
 CP 19 ADJUST SV TO 48" (2470 G)
 120 RECORD PH 10.7 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% 12 7-D 12
 120 OPERATOR STEP PB

SV 21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0.
 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) 9.7 9.0-10.0 1:25 Am
 14/47 (60 MIN) 9.7 9.0-10.0 1:55 Am
 15/48 (2 HRS) 9.5 9.0-10.0 2:55 Am
 16/49 (3 HRS) 9.3 9.0-10.0 3:55 Am
 16/49 (4 HRS) 9.0 9.0-10.0 4:55 Am
 17/50 (FINISH) 7.0 7.5-8.5 5:40 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

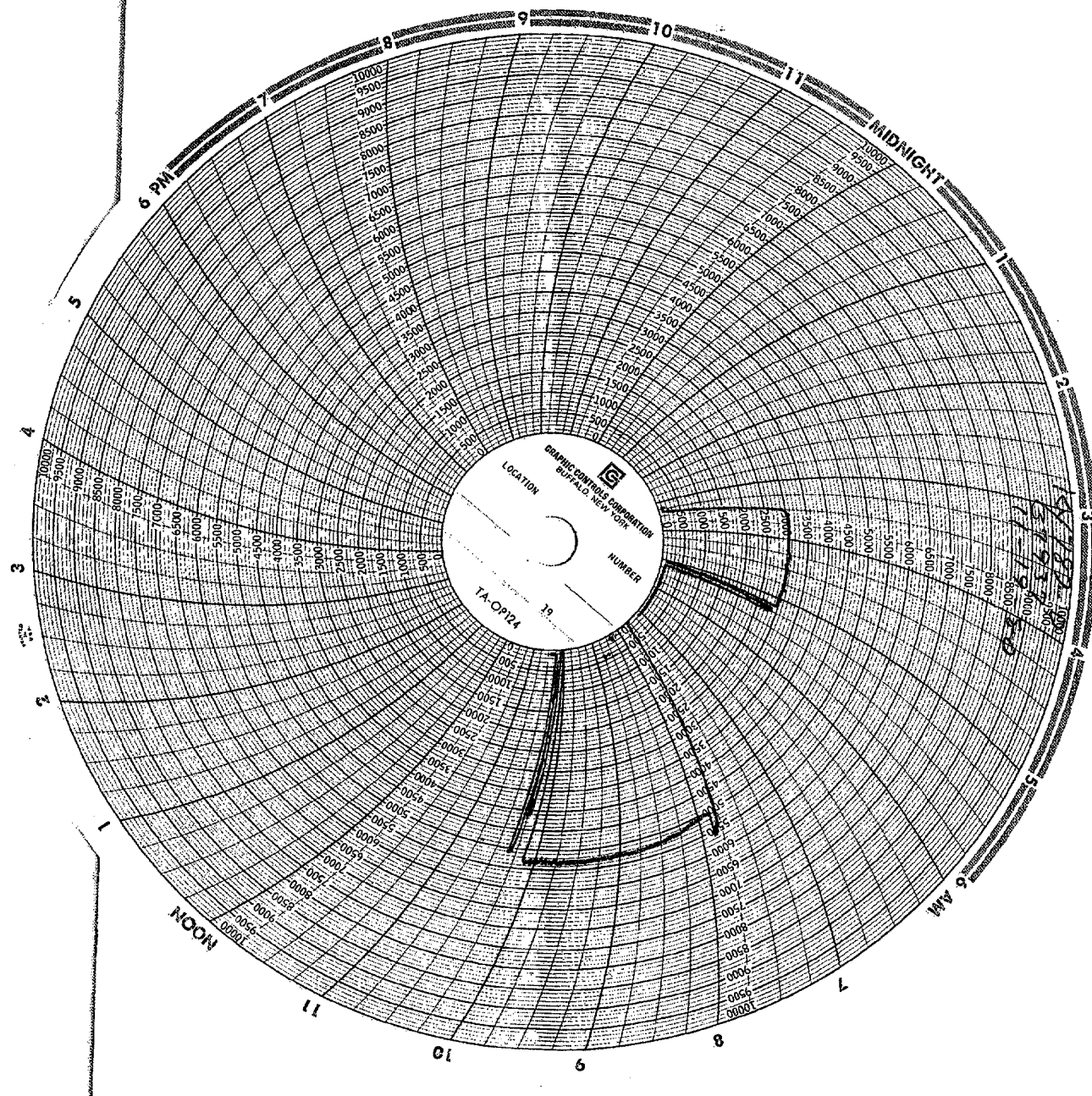
28 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 29 ADD IN 7-8 MIN 350 530-A 350
 339 30 ADJ TO 49" (382 G) AT 80-100%
 6 31 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
 32 STIR 15 MIN OR LONGER FOR SP STEP 26
 33 RECORD: VOL 49" & CALC 49" X 0.78 = 382 GAL
 34 SET PRESET #8 TO 382 GAL FROM S 33

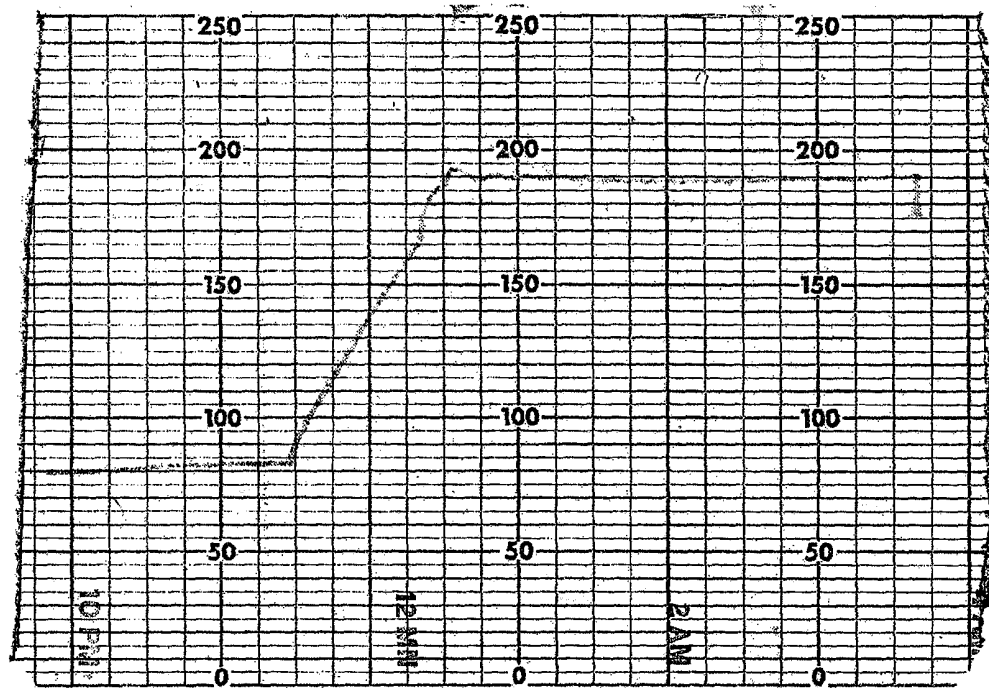
302 35 RUN 30" (360 G) WATER INTO V-302
 7 36 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 20 127-D 80

37 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 38 SIFT IN 100 128-A 100
 SV 39 SP STEP 23/53. RECORD: PH 3.1 (3.7-4.2)
 SP 40 RUN IN N-7-D FROM S 34 IN 10-12 MIN & STIR 5
 MIN
 8 41 RECORD: PH 8.1 (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH 9.1 ASSUME 77%
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 22 27-D 22
 (SIPHON N-7-D INTO SV)
 42 OPERATOR STEP PB
 43 SP STEP 29/58. RECORD: PH 9.5 & TIME 6:20 Am
 44 OPERATOR STEP PB
 45 SP STEP 60. BATCH COMPLETE.

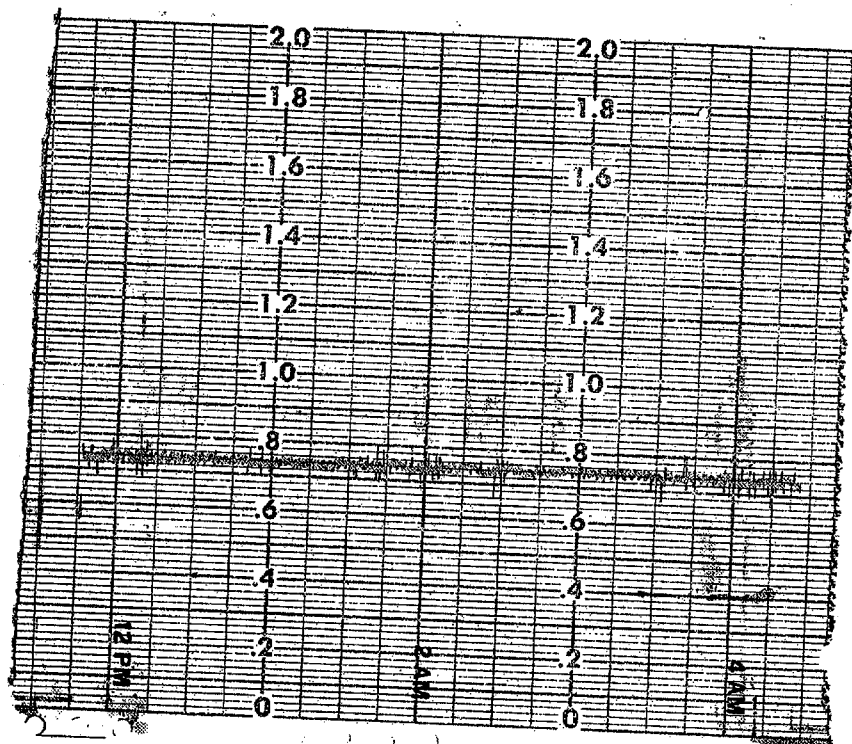
START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
3 AM	7 AM	282
11:00	6:30	20143%

Pump to V-240

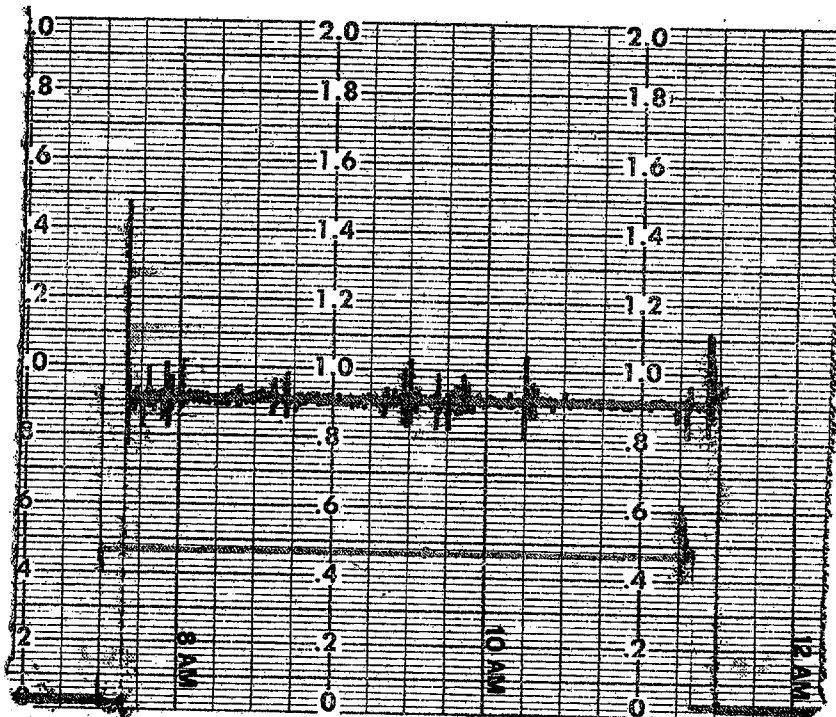




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