S.V. 243 244 PUNCHED & CHECKED D.V.

CG 03 CODE KY-787-D PKG NOV 12 1980
LOT NOV 12 80 37828

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 3PM M

PROCESSES
( ) KY-787-D
( )
( )
( )
( )

APPROVED BY
(Q) FWP 11/3/80
( ) (XOB-17: 25%
( ) LESS N-32-D
( ) & 240 MIN
( ) STRIKE)

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	13193	93	2400
14	YC002B		93	
14	YC002B		93	

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

RJM
CLEAN UP AS YOU GO ALONG

Rec'd @ VAT-243 3:00 AM

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	48X50	YC-2-B	2400
		RECORD: START 5:30AM LOT 13193	2400		
1		FIN 6:AM			
	4	ADJUST TO 75" (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-~~205~~ 262			
	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-205 VOL SS " & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
~~205~~ 263 SV 2	9	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR 263			
	10	PUMP V-~~205~~ THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 3:30 A TOTAL MINUTES 240			
		NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	11	WHEN V-~~205~~ 263 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP & CP 3	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)			
	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
		A. 11LG 84.0% PRESET #1 80 GAL		15-A	160
		B. 13LG 30 % PRESET #6 135 GAL		20-A	135
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		~~SFC10~~ (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
		~~SFC20~~ (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
		~~SFR10~~ (N-27-D/WATER) RATIO 1.35			
		~~SFC10~~ (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		983-D	1376
		~~SFC20~~ (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
		~~SFC20~~ (N-32-D WATER) IN REMOTE			
		~~SFR10~~ (N-32-D/WATER) RATIO 1.82			

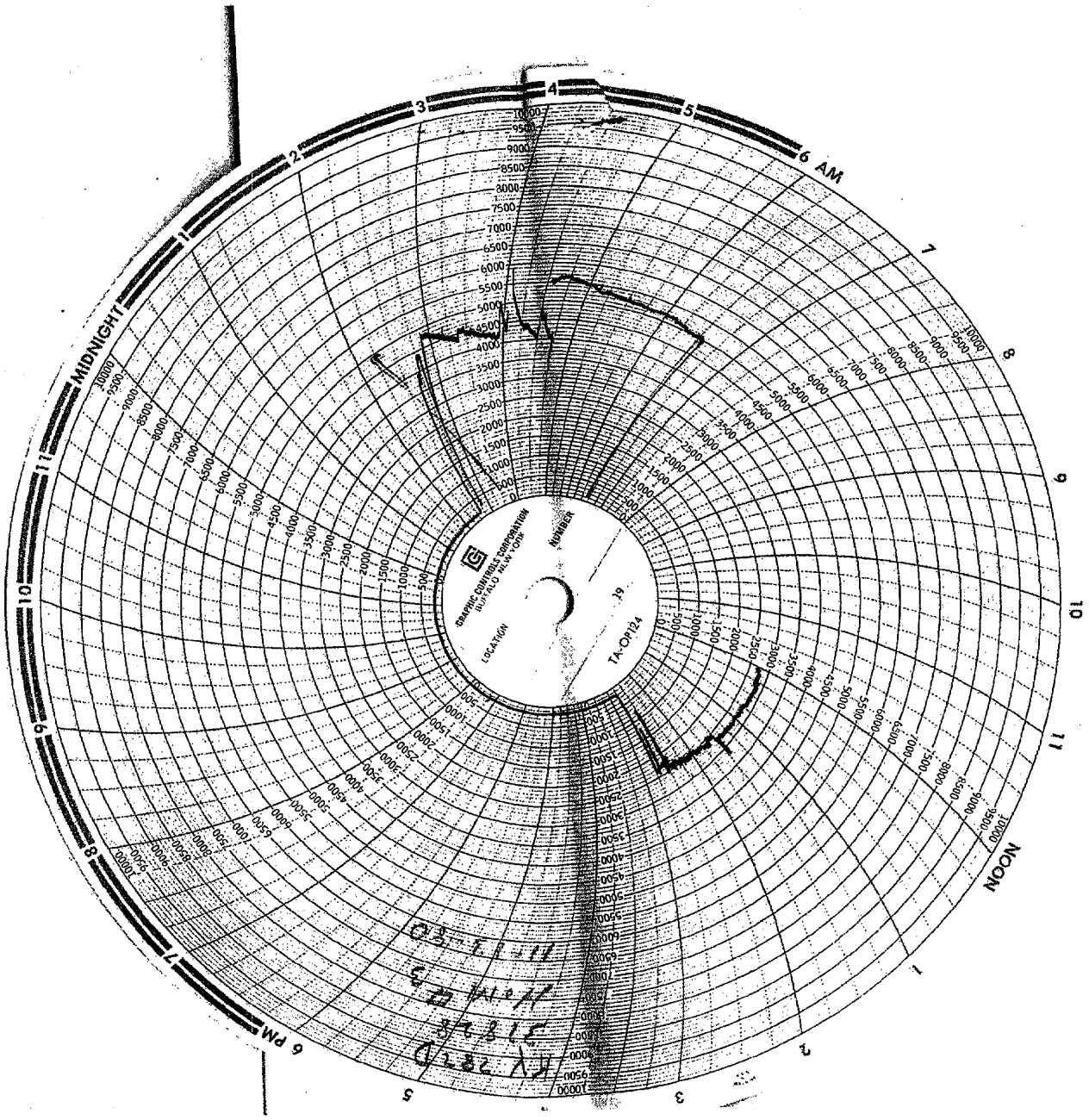
EQUIP		PAGE 2 CG 03 KY-787-D EST WGT 3332#	USE LBS	N-CODE	USE LBS
	16	OPERATOR STEP PB			
320	17	RECORD LEVEL 2LG 25 % IF BELOW 35% FOLLOW SOL'N			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 48" (2470 G)			
CP	19	RECORD PH 9.7. ADJ TO 11.1-11.3 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.3 ASSUME 50%	15	721D ~~7-D~~	15
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9.			
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:			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/46 (30 MIN) 9.5 9.0-10.0 9:35AM			
		14/47 (60 MIN) 9.4 9.0-10.0 10:06AM			
		15/48 (2 HRS) 9.4 9.0-10.0 11:05AM			
		16/49 (3 HRS) 9.3 9.0-10.0 12:05PM			
		16/49 (4 HRS) 9.3 9.0-10.0 1:05PM			
		17/50 (FINISH) 7.5 7.5-8.5 1:50PM			
		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*F			
6	31	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26 38.2			
	33	RECORD: VOL 49 " & CALC 49 " X 0.78 = ___ GAL			
	34	SET PRESET #8 TO 38.2 GAL FROM S 33			
302	35	RUN 30" (360 G) WATER INTO V-302	80	721D	
7	36	ADD & STIR 2 MIN FOR S 40 ASSUNE 50%	~~160~~	~~7-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 3.6 (3.7-4.2)			
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
		MIN			
8	41	RECORD: PH 10.1 (9.0-9.5). ADJ IF NECESSARY &			
		RECORD: PH 9.4 ASSUME 77%	8	27-D	6
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	___	7-D	___
		(SIPHON N-7-D INTO SV)			
	42	OPERATOR STEP PB			
	43	SP STEP 29/58. RECORD: PH 9.4 & TIME 3:20 PM.			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
7:00A	___	3:00P	___	322-22
3:00P	___	7:00A	___	126-120
7:00AM	___	3:00PM	___	144
3:00P.M		3:40 P.M		201.381

PUMP TO VAT 240

EC

DUP050105183



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