

CG 03 CODE KY-788-D PKG

LOT NOV 25 80 38031

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME 111 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	24227	93	2000
14	YC003B	13066	93	500
14	YC003B	24690	93	100

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

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ACCT 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	52X50	YC-3-B	2600
	RECORD: START 9:10 PM 24227 2000			
	FIN 10:10 PM 13066 500			
	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 56" & 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 1:45 TOTAL MINUTES 100			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP 112 & CP 113	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)			
	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 32% PRESET #2 208 GAL 15-A 416			
	B 13LG 22% PRESET #6 135 GAL 20-A 135			
	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FD10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM 27-D 180			
	3FD20 (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 4215			
	3FD20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM 1240			
	3FR20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.1			

EQUIP

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USE

N-

USE

LBS

CODE

LBS

320 16 OPERATOR STEP PB
 SV 17 RECORD LEVEL 2LG 45 IF <35% FOLLOW SOLUTION
 SP 18 MAKE-UP PROCEDURE FOR N-27-D
 CP 19 ADJUST SV TO 47" (2400 G)
 19 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 11.1. ASSUME 50% 18 72-D 18
 20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7
 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
9.4 9.3-10.0 9:15
9.4 9.3-10.0 9:45
9.4 9.3-10.0 10:15
9.3 9.3-10.0 10:45
9.3 9.3-10.0 11:15
6.2 7.5-8.5 11:30 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%

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 48" (382 G) AT 80-100*F
 6 31 STIR 5 MIN & RECORD: PH 9.8 (9.5-10.5)
 32 STIR 15 MIN OR LONGER FOR SP STEP 26/56
 33 RECORD: VOL 51 * & CALC 51 * X 0.78 = 39.8 GAL
 34 SET PRESET #8 TO 39.8 GAL FROM S 33

302 35 RUN 40" (440 G) WATER INTO V-302
 7 36 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 180 72-D 180

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 3.0 (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 9.4 (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH ____ ASSUME 77%
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%
 (SIPHON N-7-D INTO SV)
 42 OPERATOR STEP PB
 43 SP STEP 29. RECORD: PH 9.2 & TIME 3:45 AM
 44 OPERATOR STEP PB
 45 SP STEP 60. BATCH COMPLETE.

START
 TIME SP STEP

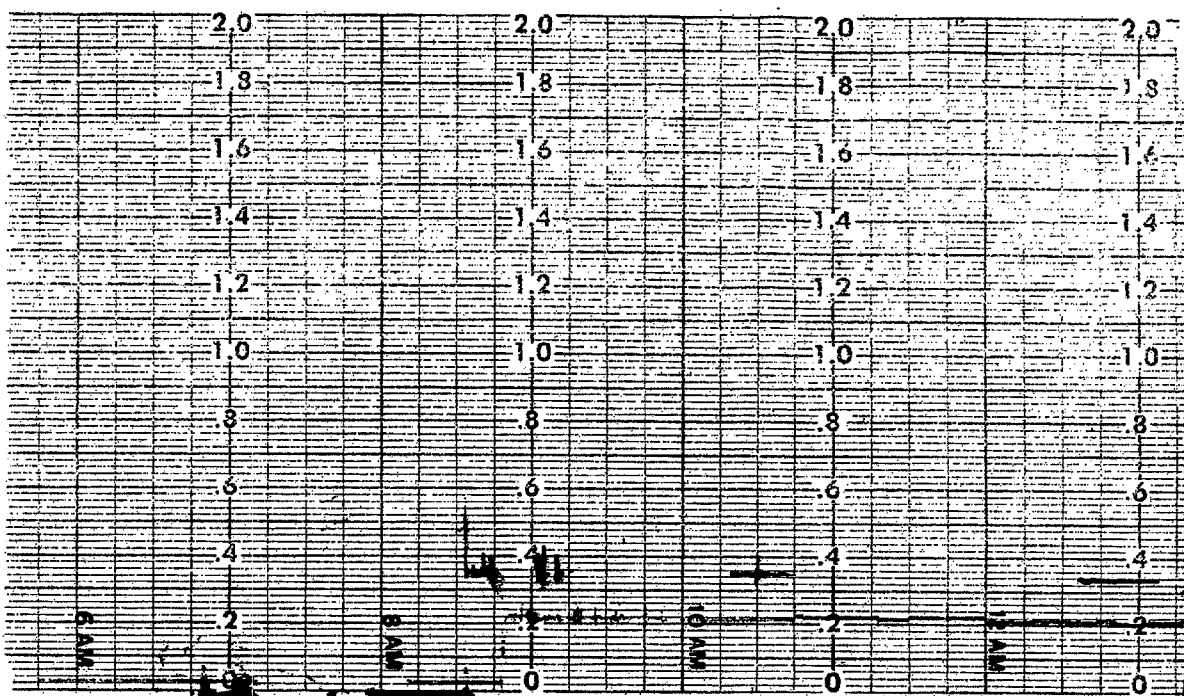
FINISH
 TIME SP STEP

OPTR

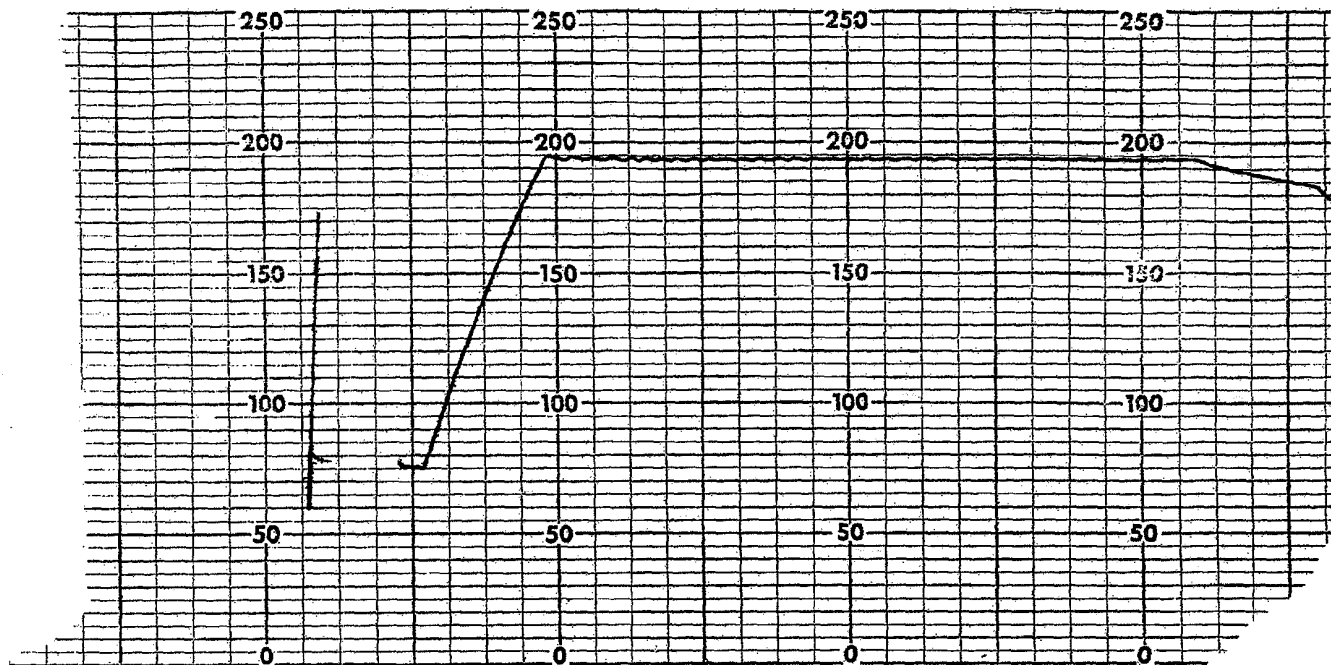
3:10 PM
11:00 AM

11:00 PM
3:50 AM

54
326



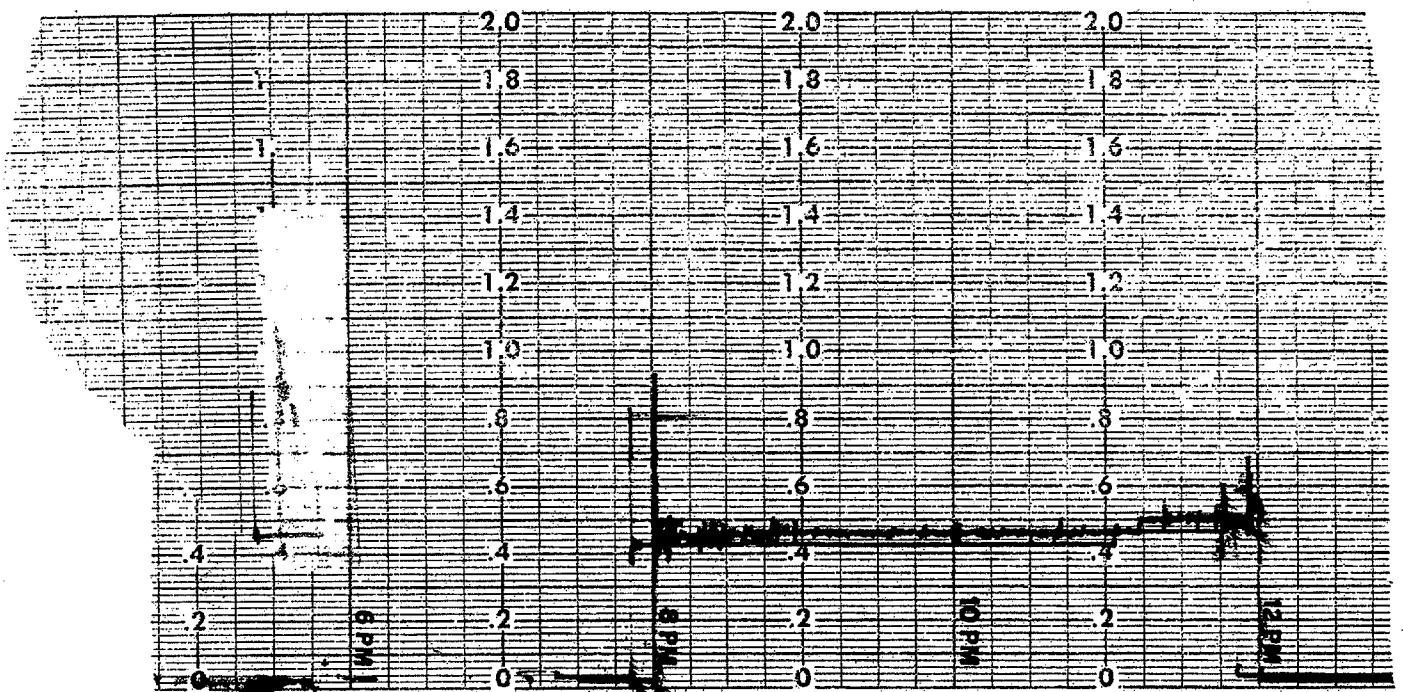
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