

CG 03 CODE KY-78B-D PKG
 LOT NOV 25 80 38008
 EST'D WGT 960 LBS
 STANDARD HRS. B.B TIME M
 PROCESSES APPROVED BY
 KY-78B-D FWP 11/3/80
 HOUR STRIKE
 AS FOR XOB-17
 TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	13066	93	2600	14	YC003B		93	
14	YC003B		93		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	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.	350		350
205	2 WEIGH IN DRUM & POUR IN	345	983-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START 10:30 AM	2600		2600
	FIN 11:30 AM			
243	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 24" & 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 9:00 AM TOTAL MINUTES 180			
	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	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
	3 (V-243) OR POSITION B (V-244)			
CP	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 60% PRESET #2 208 GAL	15-A		416
	B. 13LG 32% PRESET #6 135 GAL	20-A		135
115	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	SEC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM	27-D		180
	SEC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM			
	SEC10 (N-27-D/WATER) RATIO 0.8			
	SEC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM	983-D		1245
	SEC20 (N-32-D WATER) IN MANUAL LOCAL 2.3 GPM			1240
	SEC20 (N-32-D WATER) IN REMOTE			
	SEC10 (N-32-D/WATER) RATIO			

EQUIP	PAGE 2	CG. 03	KY-788-D	EST WGT 3560#	USE LBS	N- CODE	USE LBS
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V-243

16	OPERATOR STEP PB			
320	17 RECORD LEVEL 21.6% IF (35% FOLLOW SOLUTION			
SV	18 MAKE-UP PROCEDURE FOR N-27-D			
SP	19 ADJUST SV TO 47" (2400 G)			
CP	20 RECORD PH 9.2 ADJ TO 11.0-11.2 WITH N-7-D AT			
	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	21 SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	25	701-D	25
	22 OPERATOR STEP PB			

SV	23 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8			
SP	24 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	25 OPERATOR STEP PB			
	26 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	27 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
	LIMITS, SWITCH 3FC20 TO REMOTE			
	28 OPERATOR STEP PB			
	29 DURING STRIKE RECORD:			

SP STEP
V-243/V-244

	PH	RANGE	TIME
13/46 (30 MIN)	9.7	9.3-10.0	2:15 PM
14/47 (60 MIN)	9.65	9.3-10.0	3:15 PM
15/48 (2 HRS)	9.7	9.3-10.0	3:55 PM
16/49 (3 HRS)	9.7	9.3-10.0	4:55 PM
16/49 (4 HRS)	9.7	9.3-10.0	5:45 PM
17/50 (FINISH)	8.1	7.5-8.5	6:00 PM

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	130 ADJ TO 49" (382 G) AT 80-100°F			
6	131 STIR 5 MIN & RECORD: PH 10.0 (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	135 RUN 40" (440 G) WATER INTO V-302	180	701-D	
7	136 ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	701-D	180

SV	137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
SP	138 SIFT IN	100	128-A	100
	139 SP STEP 23/53. RECORD: PH 3.3 (3.7-4.2)			
8	140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5			
	MIN			
	141 RECORD: PH 9.4 (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)			
	142 OPERATOR STEP PB			
	143 SP STEP 29. RECORD: PH 9.4 & TIME 7:35 PM			
	144 OPERATOR STEP PB			
	145 SP STEP 40. BATCH COMPLETE. Pumped To V-243			

START TIME SP STEP	FINISH TIME SP STEP	OPTR
4:00 PM 7-4	11:00 PM 3-40	54126 32244 201

