

(AUTOMATED)
S.V. 243, 244

C.V. 243, 244

MAKING INSTRUCTIONS BATCH UNIT
D.V.

CG 03 CODE KY-788-D PKG
LOT DEC -2 80 38095
EST'D WGT 960 LBS

PROCESSES APPROVED BY
() KY-788-D (J) FWP 11/3/80
() 4 HOUR STRIKE
() AS FOR XDB-17
()
()
()

STANDARD HRS. 8.8 TIME M

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION
CG CODE LOT PQ LBS
14 YC003B 13071 93 2000
14 YC003B 13066 93 600
14 YC003B 93

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

**CLEAN UP
AS YOU GO ALONG**

Homog #4-151
" 8-4-212 "

TOTAL EST'D WGT 3560

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ACCT LBS
203 & 205	RUN 60" (990 G) WATER IN V-203 ON HIGH SPEED. WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN RECORD: START 7:15 PM 13071 FIN 9:00 PM 13066	350 345 52X50 2000 600	983-D YC-3-B	350 345 2600
1	ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205 RECORD: V-205 VOL 34" & ADJ TO 60" (2100 G) INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV 110	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START 7:40 AM TOTAL MINUTES 1.55			
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 & CP 112	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION B (V-244)			
113	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
3 114	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 41% PRESET #2 208 GAL B. 13LG 16% PRESET #6 135 GAL		15-A 20-A	416 135
115	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM 3FR10 (N-27-D/WATER) RATIO 0.8 8FC10 (N-32-D CONTROLLER) IN MANUAL 0.45 GPM 8FC20 (N-32-D WATER) IN MANUAL LOCAL 2.5 GPM 8FC20 (N-32-D WATER) IN REMOTE BFR10 (N-32-D/WATER) RATIO 1.1		27-D 983-D	180 4245 1240

TH

V-244

116 OPERATOR STEP PB
 320 117 RECORD LEVEL 2LG 60% IF <35% FOLLOW SOLUTION
 SV 118 MAKE-UP PROCEDURE FOR N-27-D
 SP 119 ADJUST SV TO 47" (2400 G)
 CP 120 RECORD PH 10.0 ADJ TO 11.0-11.2 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 121 SIPHON INTO SV. RECORD: PH 11.1 ASSUME 50% 34 7-D 17
 120 OPERATOR STEP PB

121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.6
 SV 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 123 OPERATOR STEP PB
 124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
 126 OPERATOR STEP PB
 127 DURING STRIKE RECORD:
 SP STEP

V-243/V-244

PH	RANGE	TIME
9.4	9.3-10.0	2:40
9.4	9.3-10.0	3:10
9.5	9.3-10.0	4:10
9.4	9.3-10.0	5:10
9.3	9.3-10.0	6:10
6.8	7.5-8.5	6:55

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%

2:10/PM

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 10.1 (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
 7 136 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 139 SP STEP 23/53. RECORD: PH 3.8 (3.7-4.2)
 SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
 MIN
 8 141 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)
 142 OPERATOR STEP PB
 143 SP STEP 29. RECORD: PH ____ & TIME ____
 144 OPERATOR STEP PB
 145 SP STEP 60. BATCH COMPLETE.

START
 TIME SP STEP

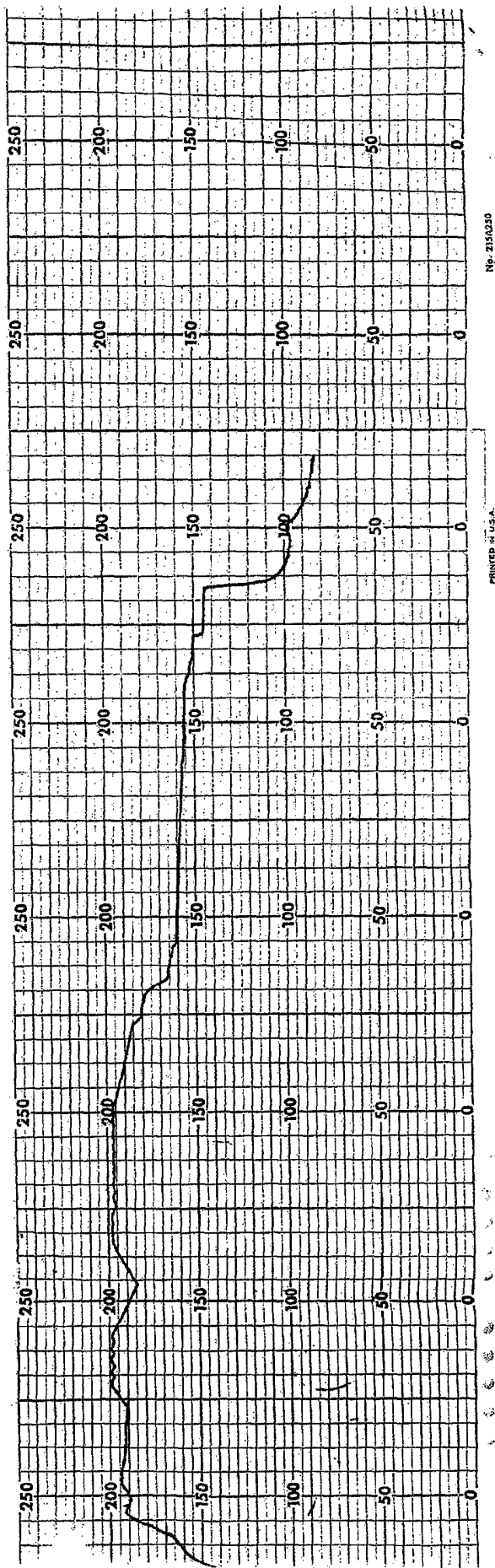
FINISH
 TIME SP STEP

OPTR

2:00 PM
 3 PM

3:00 PM
 8 PM

370.735
 282-342

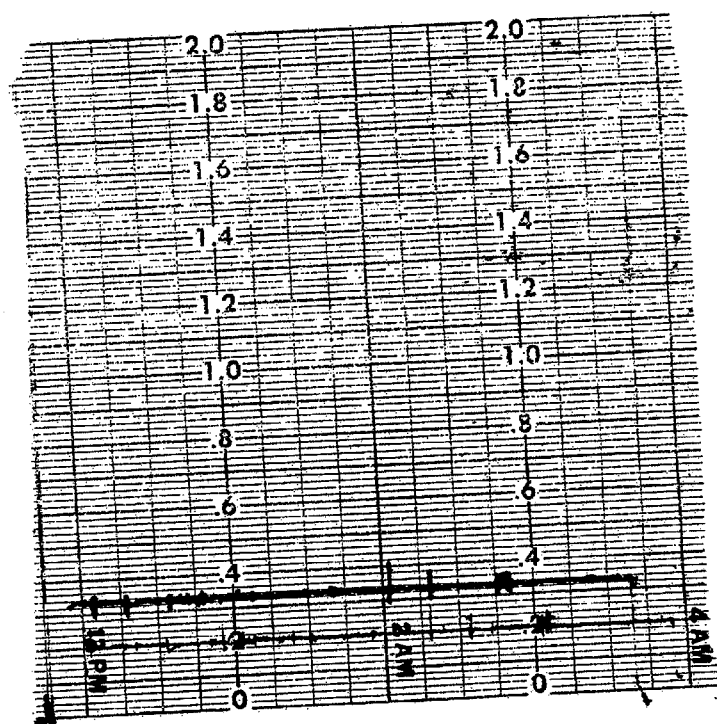


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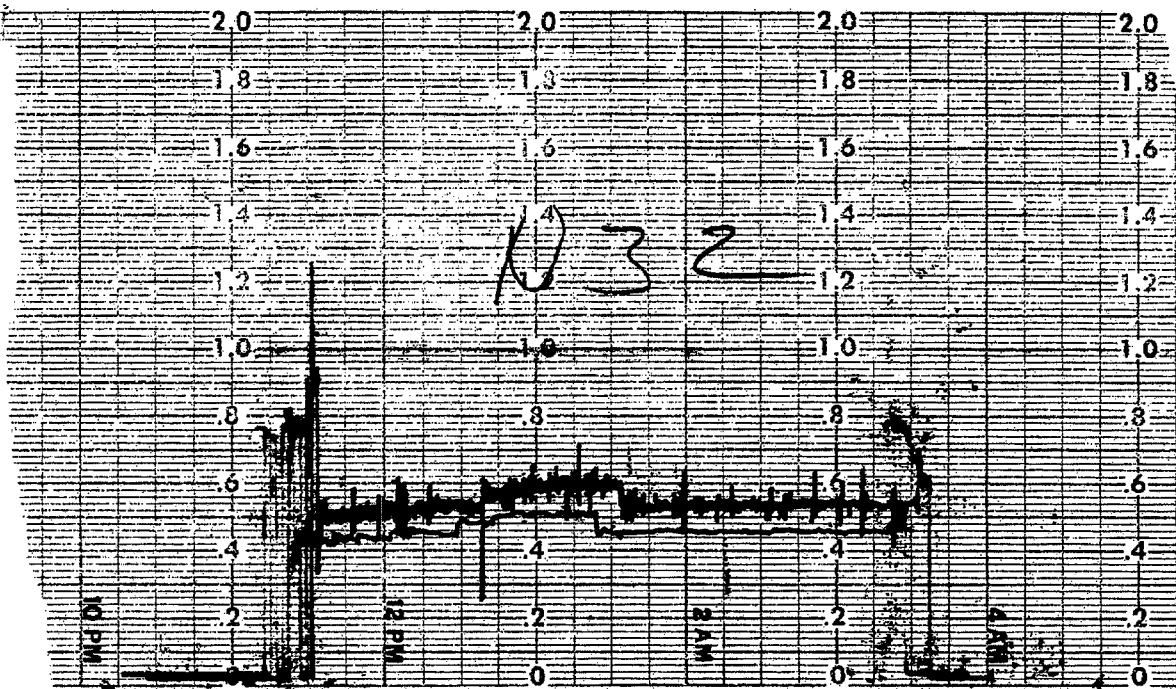
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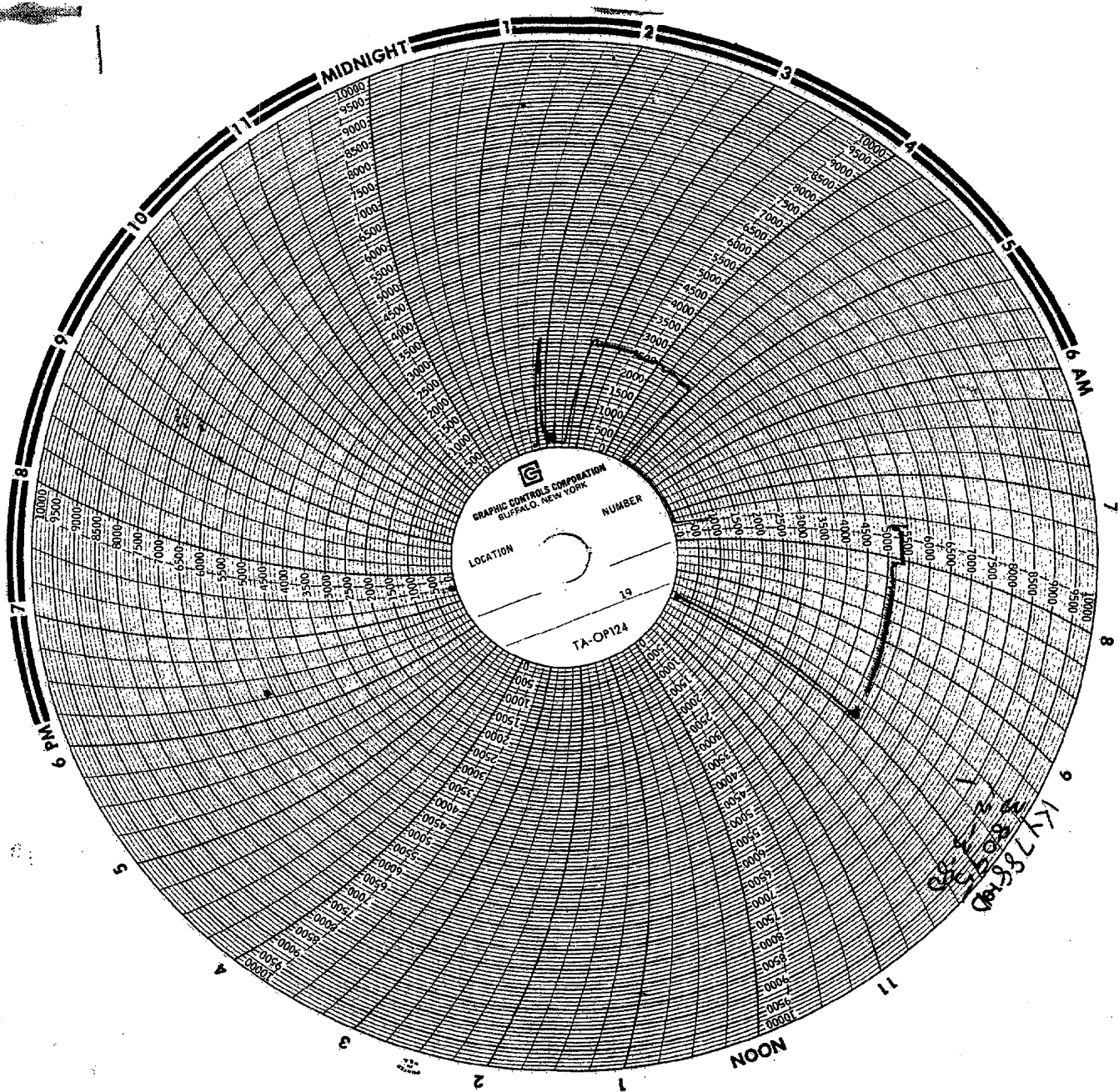
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V-244