

S.V. 243, 244 C.V. MAY 17 1981 D.V.

CG 03 CODE KY-788-D PKG
 LOT MAY -0-81-21376

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME _____ M

PROCESSES () KY-788-D (J) FWP 5/14/80

APPROVED BY

JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	14031	93	251	14	YC003B		93	
14	YC003B	14012	93	1850	14	YC003B		93	
14	YC003B		93		14	YC003B		93	

03 KY 781D 82946-1 98 50

DO NOT USE YC-3-B LOTS 14001 THRU 14004

TOTAL EST'D WGT 3560 3610

Homog #3 - 1st Pass NON-BLEEDING

" #4 - 2nd Pass

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.			
	2 WEIGH IN DRUM & POUR IN	345	32-D	345
	3 DUMP IN AND STIR 5 MIN. RECORD: START 4:30 PM LOT 14031 14012 82946-1	52X50	YC-3-B	2600
		750		
		1850		
		1 X 50		
	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 42" & 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 2:35 TOTAL MINUTES 150			
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	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
&		3 (V-243) OR POSITION 8 (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 52% PRESET #2 208 GAL	15-A	416	
		B. 13LG 46% PRESET #6 135 GAL	20-A	135	
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3PCT0 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM	27-D	180	
		3PCT0 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM			
		3PR10 (N-27-D/WATER) RATIO 0.8			
		8PCT0 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM	32-D	1215	
		8PCT0 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM			
		8PCT0 (N-32-D WATER) IN REMOTE			
		8PR10 (N-32-D/WATER) RATIO 1.1			

V-243

USE	N-	USE
LBS	CODE	LBS

320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 54% IF <35% FOLLOW SOLUTION			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 47" (2400 G)			
	20	RECORD PH 9.6. 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%	46	7-D	23
	21	OPERATOR STEP PB			

SV	22	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7			
SP	23	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO.			
	24	OPERATOR STEP PB			
	25	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	26	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	27	OPERATOR STEP PB			
	28	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) 9.5 9.3-10.0 7:25			
		14/47 (60 MIN) 9.5 9.3-10.0 7:35			
		15/48 (2 HRS) 9.3 9.3-10.0 8:35			
		16/49 (2 HRS, 25 MIN) 9.3 9.3-10.0 9:00			
		17/50 (FINAL 3 HRS) 7.7 7.5-8.5 9:35			
		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 10.1 (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 9.5 (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 9.3 & TIME 10:30A			
	144	OPERATOR STEP PB			
	145	SP STEP 60. BATCH COMPLETE.			

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
9:00 PM		11:00 PM		54409
11:00 PM		7:00 AM		235-294
7:00 AM		10:30 A		232-342