CG 03 CODE KY-781-D PKG

OCT 20 1982 (DATE) K2L10 (LOT) 4248* (EST WGT)

PROCESSES ( ) KY-781-D (N) FWF 06/25/82
COMTYP JOB NAME: 03KY781DMN
TYPED BY:
STANDARD HRS. TIME ____M

APPROVED BY

LOCATN	CG	CODE	PQ	LOT	DRY* WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL USE LBS
	14	YC-3	93	G2L28	3300					
	14	YC-3	93							
	14	YC-3	93							

NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW LIGHT	USE LBS	N-CODE	ACCT LBS
		"BEFORE USING SV, MAKE SURE THAT N-28-D LINE IF ANY IS BLANKED OFF."			
203 & 205	1	RUN 60"(990 G) WATER IN V-203 & ADD ASSUME 50% SET AGITATOR ON HIGH SPEED.	36	7-D	18
	2	WEIGH IN DRUM & POUR IN	442	32-D	442
	3	DUMP IN AND STIR 5 MIN LOT G2L28	66X50	YC-3-B	3300
1		RECORD: START 1:30 P.M. FIN 1:42	3300		
	4	ADJUST TO 75" (1275 G) *NOTE: VOLUMES HIGHER THAN 75" MAY CAUSE DUSTING IN EXHAUST HOOD.			
	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 45" (1662 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205* SV 2	9	RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START 4:25P TOTAL MINUTES 15			
		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 & CP 3	12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 1 (V-243) OR POSITION 6 (V-244)			
	13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194*F)	OCT 25 1982		
	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 45 % PRESET #3 70 GAL.		115-D	374
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		SFC10 (N-27-D CONTROLLER) IN MANUAL 0.90 GPM		27-D	373
		SFC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM			
		SFR10 (N-27-D/WATER) RATIO 0.7			
		SFC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM		32-D	2527
		SFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		SFC20 (N-32-D WATER) IN REMOTE			
		SFR10 (N-32-D/WATER) RATIO 0.9			

LOT= _____ COMTYP JOB NAME = 03KY781DMN PAGE 02 DATE PRINTED: 6/25/82

EQUIPMENT		PAGE 2 CG 03 KY-781-D V-244	USE LBS	N-CODE	ACCT LBS
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 61% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 54" (2800 G)			
OP	19	RECORD PH 10.6. ADJ TO 11.4-11.6 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH 11.4. ASSUME 50%	50	7-D	25
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
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 10:05			
	27	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244 PH RANGE TIME			
		13/41 (30 MIN) 9.8 9.3-10.0 10:35			
		14/47 (60 MIN) 9.8 9.3-10.0 11:05			
		15/48 (2 HRS) 9.5 9.3-10.0 12:05			
		16/49 (3 HRS) 9.6 9.3-10.0 1:05			
		17/50 (FINAL) 6.4 7.5-8.5 1:50AM			
		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	____
385	28	RUN 49" (379 G) WATER INTO V-385			
6	29	ADD & STIR 5 MIN ASSUME 50%	124	7-D	62
	30	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	31	SIFT IN	165	128-A	163
SV	32	SP STEP 23/53			
	33	RECORD: PH 3.3 (3.3-3.7) & IF NECESSARY ADJ			
		(DOWN ONLY) TO 3.3-3.7 & RECORD: PH ___			
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA			
		BADGER METER. STIR 5 MIN AFTER EACH			
		ADDITION. ASSUME 50%	_____	115-D	_____
SP	34	RUN IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5			
		MIN			
7	35	RECORD: PH 3.6 (4.2-4.4). ADJ IF NECESSARY &			
		RECORD: PH 4.25 ASSUME 77%		27-D	____
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	34	7-D	17
		(SIPHON N-7-D INTO SV)			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - ADD & STIR 5 MIN	40	978-A	40
	38	OPERATOR STEP PB			
	39	SP STEP 66. BATCH COMPLETE.			

	START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
	11 Pm	_____	3 Am	_____	120
	____	_____	____	_____	____
	____	_____	____	_____	____

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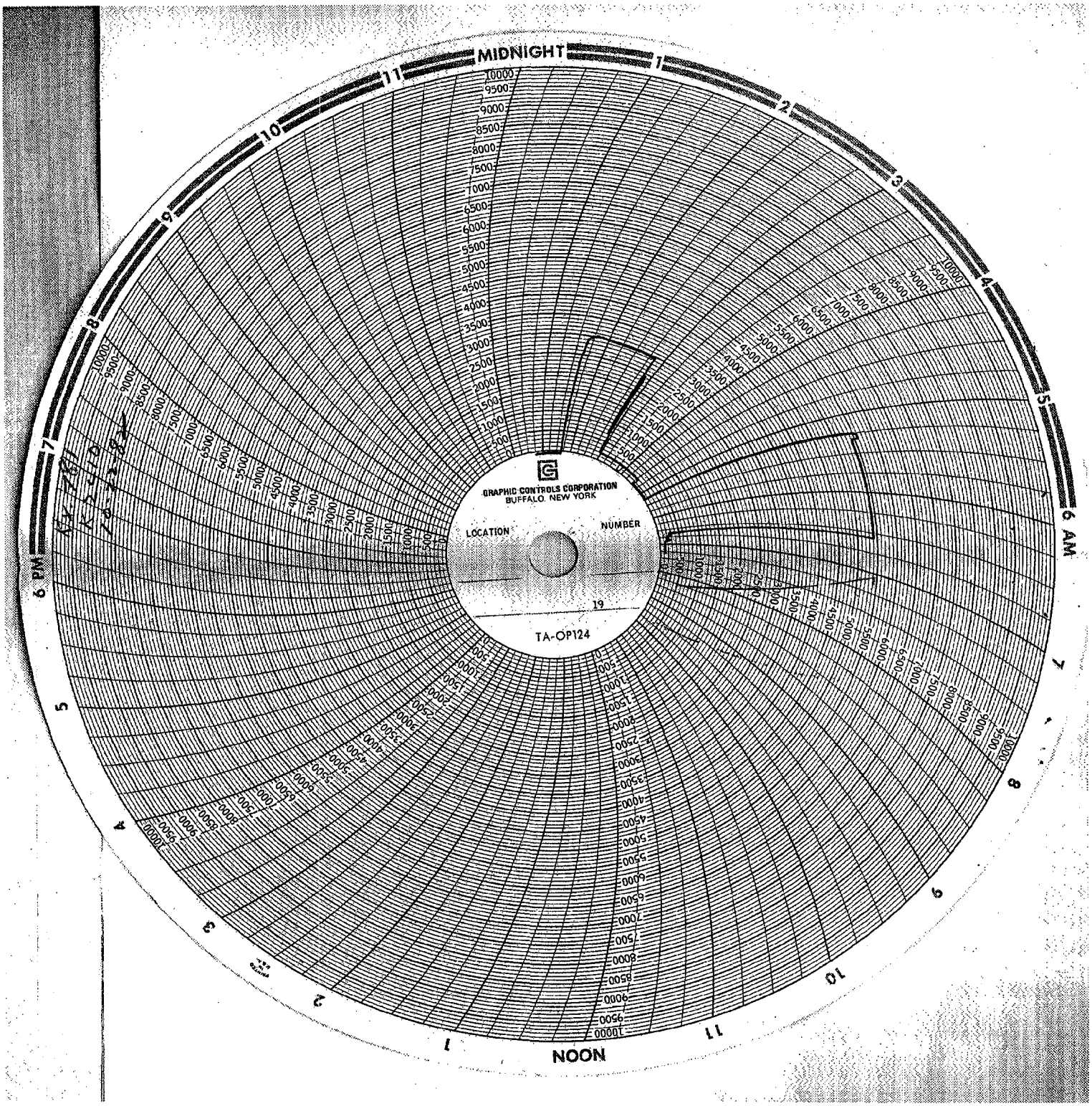

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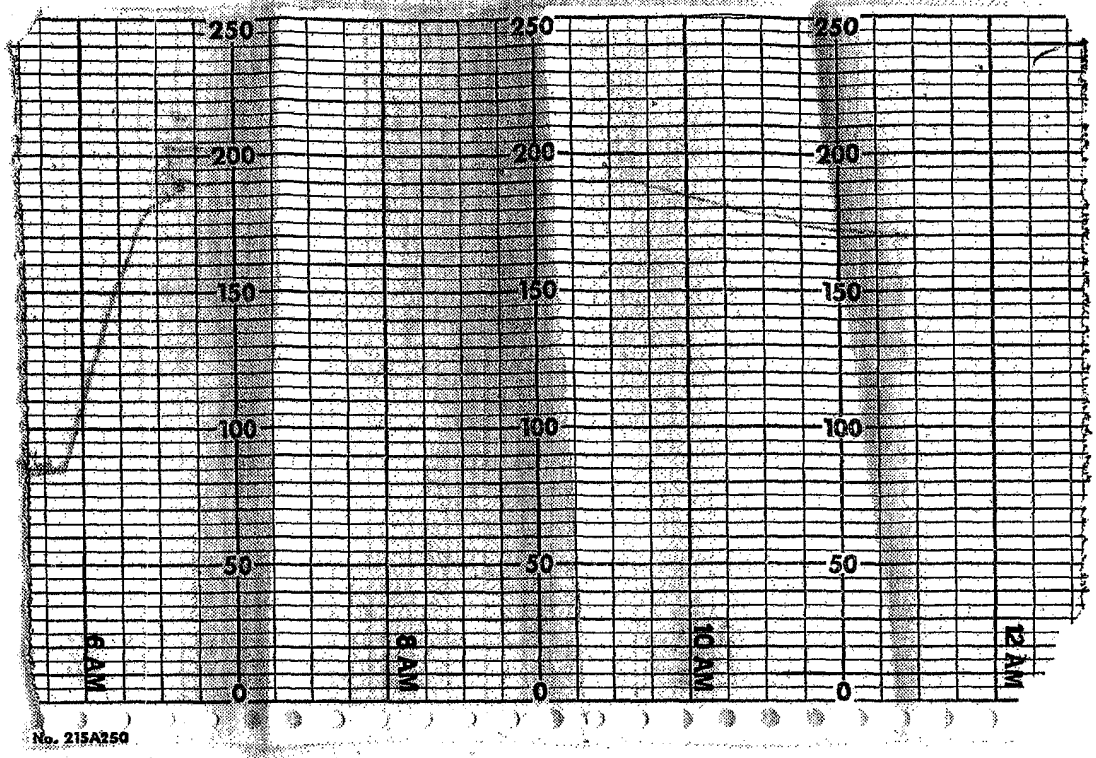

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6 AM
8 AM
10 AM
12 AM
2 PM
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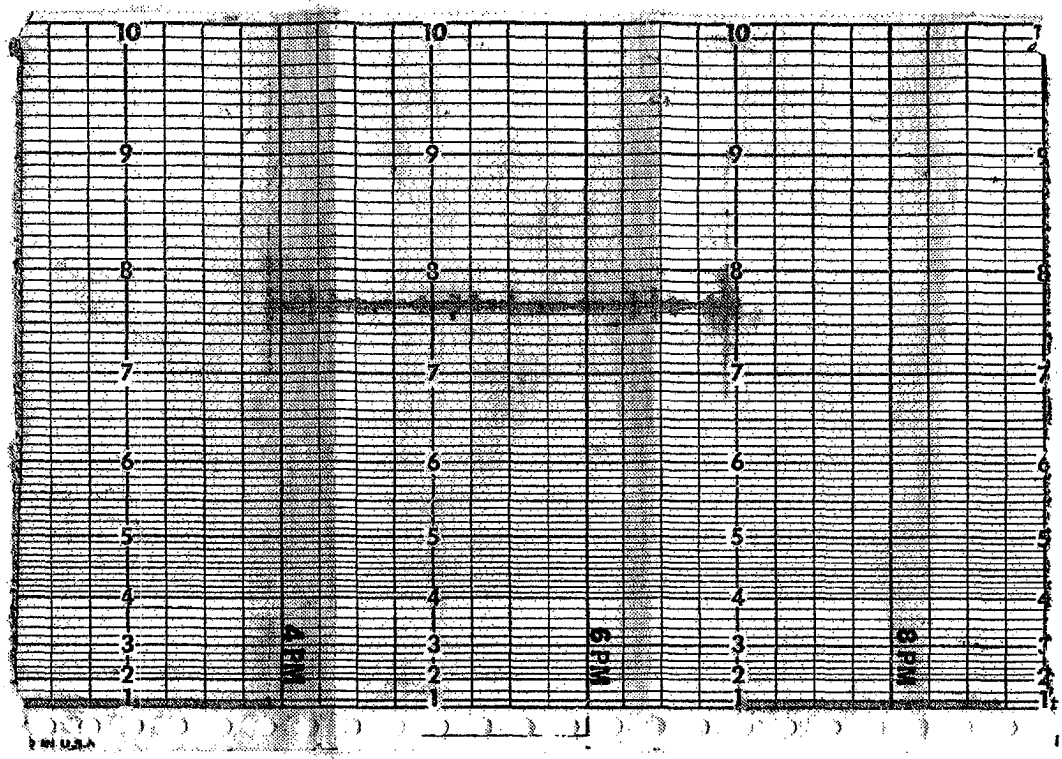

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