

JAN 20 1983

A2J65

KY-907-D (D) FWP 12/17/81

DATE

LOT NUMBER

STANDARD HRS. 8.9 TIME M

COMTYP JOB NAME: 03KY907DMD

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC-2-B	14558	93	2000	14	YC-2-B		93	
14	YC-2-B	M1468-1	93	500	14	YC-2-B		93	
14	YC-2-B		93		14	YC-2-B		93	

DO NOT USE LOTS 13839 - 13855

TOTAL EST'D WGT 3381* LBS.

NON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
	NAME: "KROLOP" YELLOW-MEDIUM			
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
203	2 WEIGH IN DRUM & POUR IN	250	32-D	250
	3 DUMP IN AND STIR 5 MIN	50X50	YC-2-B	2500
	RECORD: START 3:30 PM	2000		
	FIN 4:30 PM	500		
203	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-203			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	7 RECORD: V-203 VOL 58" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
263	1 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 4:30 TOTAL MINUTES 110			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
11	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 2 (V-243) OR POSITION 7 (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. (1) LG 100% PRESET #1 32 GAL		115-A	169
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.64 GPM		27-D	213
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 9.36 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.31			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 1.84 GPM		32-D	1425
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 7.40 GPM			
	8FR10 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.76			

243

320	SV	16	OPERATOR STEP PB			
SV		17	RECORD LEVEL 2LG 50% IF BELOW 35% FOLLOW SOL'N			
SP		18	MAKE-UP PROCEDURE FOR N-27-D			
CP		19	ADJUST SV TO 48" (2470 G)			
		20	RECORD PH 11.3. ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4		21	SIPHON INTO SV. RECORD: PH --- ASSUME 50%		7-D	
		22	OPERATOR STEP PB			

SV		21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.1			
SP		22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
		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:			

9:40 P.M.

PH	RANGE	TIME
13/46 (30 MIN)	9.3 9.0-10.0	10:10 P.M.
14/47 (60 MIN)	9.3 9.0-10.0	10:40 P.M.
15/48 (2 HRS)	9.4 9.0-10.0	11:40 P.M.
16/49 (2 HRS, 25 MIN)	9.4 9.0-10.0	12:05 A.M.
17/50 (FINAL 3 HRS)	6.2 7.5-8.5	12:40 A.M.

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		SIFT IN		50	128-A	50
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385		29	ADD 27" (208 G) WATER TO V-385			
6		30	ADD & STIR FOR 2 MIN FOR S 57 Dan ASSUME 50%	60	7-D	30

		31	DURING STRIKE CHECK LEVEL IN V-387.			
387		32	IF LOW LEVEL LIGHT IS NOT LIT, GO TO S-35			
7		33	IF LOW LEVEL LIGHT IS LIT, VERIFY BY CHECKING THAT LOW LEVEL PEG IN VAT IS ABOVE SURFACE			
		34	IF VISUAL CHECK CONFIRMS LOW LEVEL, FOLLOW STEARATE MAKE-UP PROCEDURE.			

		35	RUN IN 32" (317 GAL)			
388		36	TURN ON STEAM & AGITATOR			
8		37	ADJUST TO 42" (403 GAL) AT 178-182°F			
		38	SET BADGER METER FOR 404#			
		39	PUMP IN FROM V-387 THRU UNDERSURFACE DISTRIBUTORS AS FAST AS POSSIBLE	330	169-A	330
		40	SHUT OFF PUMP	37	155-A	37
		41	STIR 30 MIN AT 178-182°F FOR S 48	37	160-A	37
		42	DO NOT SHUT OFF AGITATOR			

SV		43	WHEN S28 COMPLETE HEAT SV TO 198-200 DEG F IN 5 TO 10 MIN			
SP		44	CLOSE WATER LINE & DISCHARGE VALVES AT STEARATE PUMP			
9		45	OPEN V-388 DISCHARGE VALVES TO STEARATE PUMP INLET			
		46	OPEN WATER VALVE AT STEARATE PUMP & RUN WATER THRU HOMOG AT 2900-3100 PSI TO SEWER			

EQUIP¹ | COMTYP JOB NAME: 03KY907DMD | USE | N- | ACCT
 MENT¹ | PAGE 03 CG 03 KY-907-D (D) EST WGT 3381# | LBS | CODE | LBS

SV 47 WHILE HOMOG WATER AT 2900-3100 PSI, OPEN HOMOG
 & DISCHARGE VALVE TO SV AND CLOSE VALVE TO
 SP SEWER
 9 48 IMMEDIATELY OPEN STEARATE PUMP DISCHARGE VALVE,
 CONT TURN ON PUMP & HOMOG V-388 TO SV AT 2900-3100
 PSI. MAINTAIN SV AT 198-200°F.
 49 WHILE HOMOG V-388 TO SV, SHUT OFF WATER VALVE
 AT STEARATE PUMP ASAP
 50 WHEN HOMOG COMPLETE, RINSE IN V-388 WITH HOT
 WATER FROM HOT WATER MIXER
 51 WHEN S50 COMPLETE TURN OFF HOMOG & STEARATE PUMP
 52 STIR 5 MIN AT 198-200°F
 53 SHUT OFF STEAM
 54 WHEN S53 COMPLETE, OPERATOR PB
 55 SP STEP 23/53 RECORD PH 5.3 (3.3-3.7)
 56 IF NECESSARY, ADJ PH TO 3.3-3.7 (DOWNWARD ONLY)
 & RECORD: PH 5.3
 NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA
 BADGER METER. STIR 5 MIN AFTER EACH
 ADDITION. ASSUME 50%
 57 RUN IN N-7-D FROM S-30 IN 10-12 MIN & STIR 5MIN
 58 RECORD: PH 4.2 (4.2-4.4) & IF NECESSARY, ADJ
 TO PH 4.2-4.4 & RECORD: PH 4.2 ASSUME 50%
 (DILUTE 10 PARTS TO 1 WITH WATER) ASSUME 78%
 SIPHON N-7-D INTO SV
 59 OPERATOR STEP PB
 60 OPERATOR STEP PB
 61 SP STEP 60 - BATCH COMPLETE

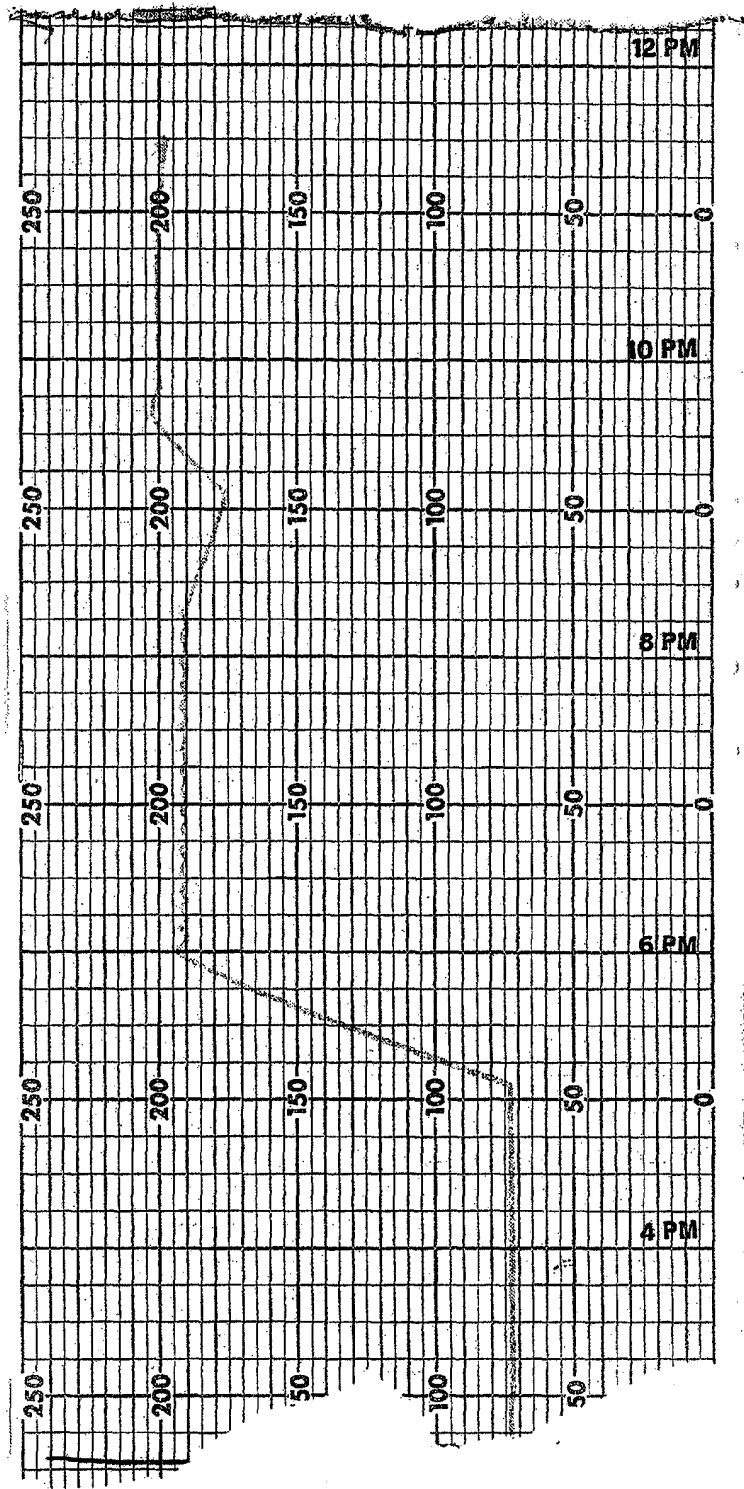
115-A

30

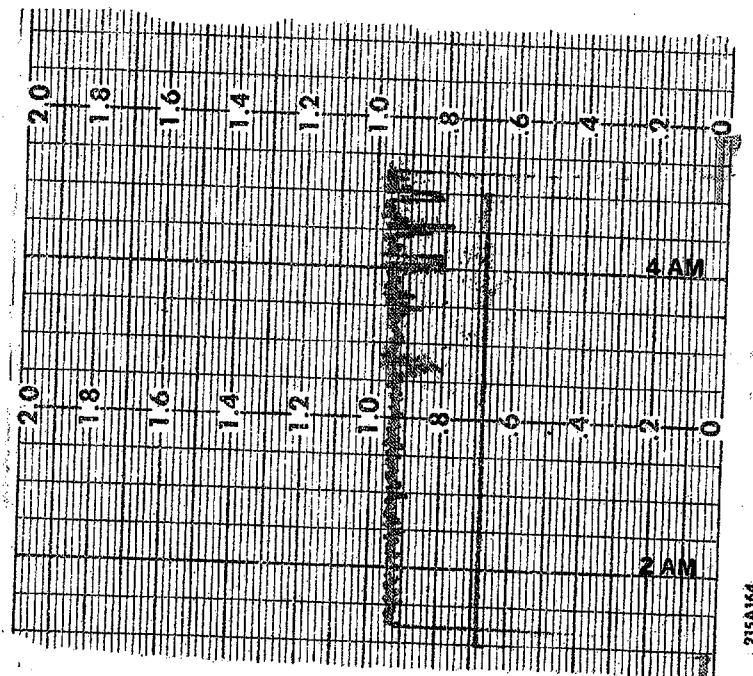
7-D

27-D

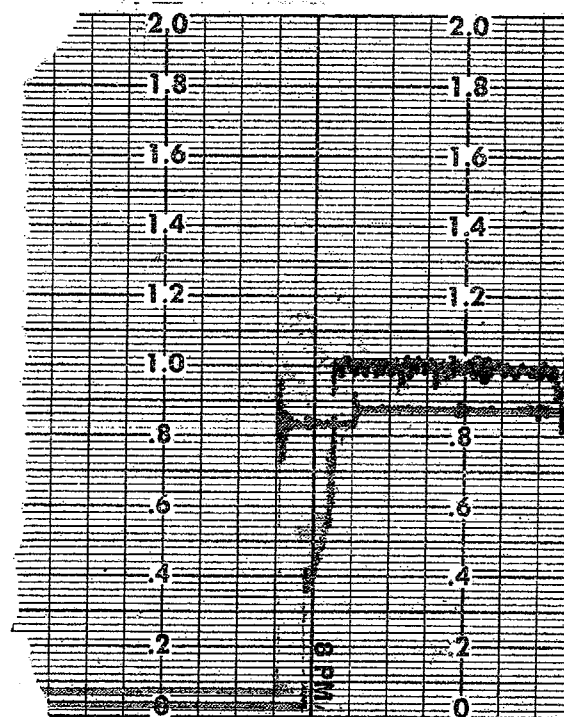
START		FINISH		OPERATOR
TIME	SP STEP	TIME	SP STEP	
<u>11:02</u>		<u>11:00 PM</u>		<u>282-381</u>
		<u>3:30 PM</u>		<u>382-166</u>



JTROLS CORPORATION BUFFALO, NEW YORK



215A164



GRAPHIC CONTROL

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