

CG 03 CODE KY-795-D PKG
4LOT

PROCESSES APPROVED BY
() KY-795-D (H) FWP 10/17/80
() (XOB-17: 3/4
() (N-32-D & 240
() (MIN STRIKE)
()
TYPED BY: FWP 10/17/80

STANDARD HRS. 8.2 TIME 3P M

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	<u>13187</u>	93	<u>3500</u>	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

Note lower ph in 5-19

TOTAL EST'D WGT 4380

CLEAN UP
AS YOU GO ALONG

Homog #4-127 Page

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN RECORD: START <u>5:AM</u> LOT <u>13187</u> FIN <u>5:50 AM</u>	475 70X50 <u>3500</u>	32-D YC-2-B	475 3500
1	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 <u>54</u> " & 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 <u>4:30</u> TOTAL MINUTES <u>150</u> 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	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (V-244) 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 <u>34</u> % PRESET #1 104 GAL			
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM 3FR10 (N-27-D/WATER) RATIO 1.04 8FC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM 8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM 8FC20 (N-32-D WATER) IN REMOTE 8FR10 (N-32-D/WATER) RATIO 1.59		15-A 27-D 32-D	208 296 1885

(Signature)

EQUIP	PAGE 2	CG 03	KY-795-D	EST WGT 4380#	USE	N-	USE
					LBS	CODE	LBS

	116	OPERATOR STEP PB			
	117	RECORD LEVEL 2LG ____% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	118	ADJUST SV TO 58" (2980 G)			
CP	119	RECORD PH ____ ADJ TO 11.1-11.3 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
4		SIPHON INTO SV. RECORD: PH ____ ASSUME 50%		7-D	
	120	OPERATOR STEP PB			

	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH ____			
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
		13/46 (30 MIN)	----	9.0-10.0	-----
		14/47 (60 MIN)	----	9.0-10.0	-----
		15/48 (2 HRS)	----	9.0-10.0	-----
		16/49 (3 HRS)	----	9.0-10.0	-----
		17/50 (FINISH)	----	7.5-8.5	-----
		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	

DRUM	128	WEIGH INTO 55 GAL DRUM	ASSUME 50%	56	7-D	28
6	129	FILL WITH WATER & STIR 2 MIN				

	130	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	131	SP STEP 23/53 - RECORD: PH ____ (3.3-3.7)			
SP	132	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
&		RECORD: PH ____		15-A	
CP		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
7		*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			
	133	SIFT IN	150	128-A	150
	134	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR			
		5 MIN			
	135	RECORD: PH ____ (4.0-4.2) & IF NECESSARY ADJ TO			
		PH 4.0-4.2 & RECORD: PH ____ ASSUME 77%		27-D	
		(DILUTE 10 TO 1 WITH WATER) ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
	136	OPERATOR STEP PB			
	137	SP STEP 24/54 - POUR IN & STIR 15 MIN	22	978-A	22
	138	OPERATOR STEP PB			
	139	SP STEP 60 - BATCH COMPLETE			
	140	OPERATOR STEP PB			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
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243

SV	16	OPERATOR STEP PB			
SP	17	RECORD LEVEL 2LG 68% IF (35% FOLLOW SOLUTION			
CP	18	MAKE-UP PROCEDURE FOR N-27-D			
	19	ADJUST SV TO 58" (2980 G) 10.4 10.6			
	20	RECORD PH 9.3. ADJ TO 44.4 44.3 WITH N-7-D AT			
		5% (10 PARTS WATER TO 1 PART N-7-D)			
	4	SIPHON INTO SV. RECORD: PH 10.6. ASSUME 50%	11	N-721-D	11
	20	OPERATOR STEP PB			

SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5.			
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:			

SP STEP

V-243/V-244

13/46 (30 MIN)

14/47 (60 MIN)

15/48 (2 HRS)

16/49 (3 HRS)

16/49 (4 HRS)

17/50 (FINISH)

PH	RANGE	TIME
9.4	9.0-10.0	10:45
9.5	9.0-10.0	11:15
9.6	9.0-10.0	12:15
9.7	9.0-10.0	1:15
9.8	9.0-10.0	2:15
9.9	7.5-8.5	3:00

10:15

instruments not set properly 2pm.

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

DRUM	28	WEIGH INTO 55 GAL DRUM	ASSUME 50%	721-D	28
6-	29	FILL WITH WATER & STIR 2 MIN	FLAKE	28	

SV	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SP	31	SP STEP 23/53 - RECORD: PH 3.0 (3.3-3.7)			
&	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
CP		RECORD: PH		15-A	
7		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
		*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.			

	33	SIFT IN	150	128-A	150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR			
		5 MIN			

	35	RECORD: PH 3.3 (4.0-4.2) & IF NECESSARY ADJ TO			
		PH 4.0-4.2 & RECORD: PH 4.2	ASSUME 77%	27-D	
		(DILUTE 10 TO 1 WITH WATER)	ASSUME 50%	18 721-D	18

		SIPHON N-7-D INTO SV			
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	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN & STIR 15 MIN	22	978-A	22

	38	OPERATOR STEP PB			
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	39	SP STEP 60 - BATCH COMPLETE			
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	40	OPERATOR STEP PB			
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Pumped To V240

START TIME SP STEP

9:00A

3pm

11 pm

FINISH

TIME SP STEP

2:00P

11pm

3:00A

OPTR

235-244

282-223

120-54







