

6.03
 LOT KY-787-D PKG

LOT 20 00 37039

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 3P M

PROCESSES

KY-787-D (Q) FWP 11/3/80
 () (XOB-17: 25%
 () LESS N-32-D
 () & 240 MIN
 () STRIKE)

TYPED BY FWP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13189	93	2000	14	YC002B		93	
14	YC002B	13191	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

38.9 140.1 140.3 566 burned

USE FLAME
 Cautie

GTAL EST'D WGT 3332

NON-BLEEDING

IP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
1	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
2	WEIGH IN DRUM & POUR IN	240	983-D	240
3	DUMP IN AND STIR 5 MIN RECORD: START 2:20 FIN 4:07	48X50 2000 400	YC-2-B	2400
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 " & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
9	RUN 10" (514 G) WATER INTO V-203 & START AGITATOR			
10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 4:20 TOTAL MINUTES 200			
11	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			
12	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
13	PRESS SV CAM RESET PB - SET 22 TC IN AUTO REMOTE (TEMP IS SET AT 190-194°F)			
14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 70% PRESET #1 80 GAL B. 13LG 65% PRESET #4 135 GAL			
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM 3FR10 (N-27-D/WATER) RATIO 1.35 3FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM 3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM 3FC20 (N-32-D WATER) IN REMOTE 3FR10 (N-32-D/WATER) RATIO 1.82			
			15-A	160
			20-A	135
			27-D	206
			983-D	1376

V-243

			USE LBS	CODE	LBS
320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG <u>87</u> % IF BELOW 35% FOLLOW SOL'N			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 48" (2470 G)			
4	20	RECORD PH <u>10.4</u> . ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)	15	7-D	15
	21	SIPHON INTO SV. RECORD: PH <u>11.2</u> ASSUME 50%			
	22	OPERATOR STEP PB			
SV	23	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>7.7</u>			
SP	24	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
	25	OPERATOR STEP PB			
5	26	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
	27	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	28	OPERATOR STEP PB			
	29	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		13/46 (30 MIN)	PH 9.3	RANGE 9.0-10.0	TIME 8:40 PM
		14/47 (60 MIN)	9.3	9.0-10.0	9:10
		15/48 (2 HRS)	9.3	9.0-10.0	9:40
		16/49 (3 HRS)	9.1	9.0-10.0	10:40
		16/49 (4 HRS)	9.1	9.0-10.0	11:40 PM
		17/50 (FINISH)	6.3	7.5-8.5	1:25 PM
		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	
339	30	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339	350	530-A	350
6	31	ADD IN 7-8 MIN			
	32	ADJ TO 49" (382 G) AT 80-100%F			
	33	STIR 5 MIN & RECORD: PH <u>10.2</u> (9.5-10.5)			
	34	STIR 15 MIN OR LONGER FOR SP STEP 26			
	35	RECORD: VOL <u>29</u> " & CALC <u>29</u> " X 0.78 = <u>38.2</u> GAL			
	36	SET PRESET #8 TO <u>38.2</u> GAL FROM S 33			
302	37	RUN 30" (360 G) WATER INTO V-302			
7	38	ADD & STIR 2 MIN FOR S 40 (2 DRAWS) ASSUME 50%	160	7-D	80
	39	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
SV	40	SIFT IN	100	128-A	100
SP	41	SP STEP 23/53. RECORD: PH <u>3.6</u> (3.7-4.2)			
8	42	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
	43	RECORD: PH <u>8.3</u> (9.0-9.5). ADJ IF NECESSARY & RECORD: PH <u>9.1</u> ASSUME 77%		27-D	
	44	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	9	7-D	9
	45	(SIPHON N-7-D INTO SV)			
	46	OPERATOR STEP PB			
	47	SP STEP 29/58. RECORD: PH <u>9.1</u> & TIME <u>2:30</u>			
	48	OPERATOR STEP PB			
	49	SP STEP 60. BATCH COMPLETE.			

START
TIME SP STEP

3:00 PM

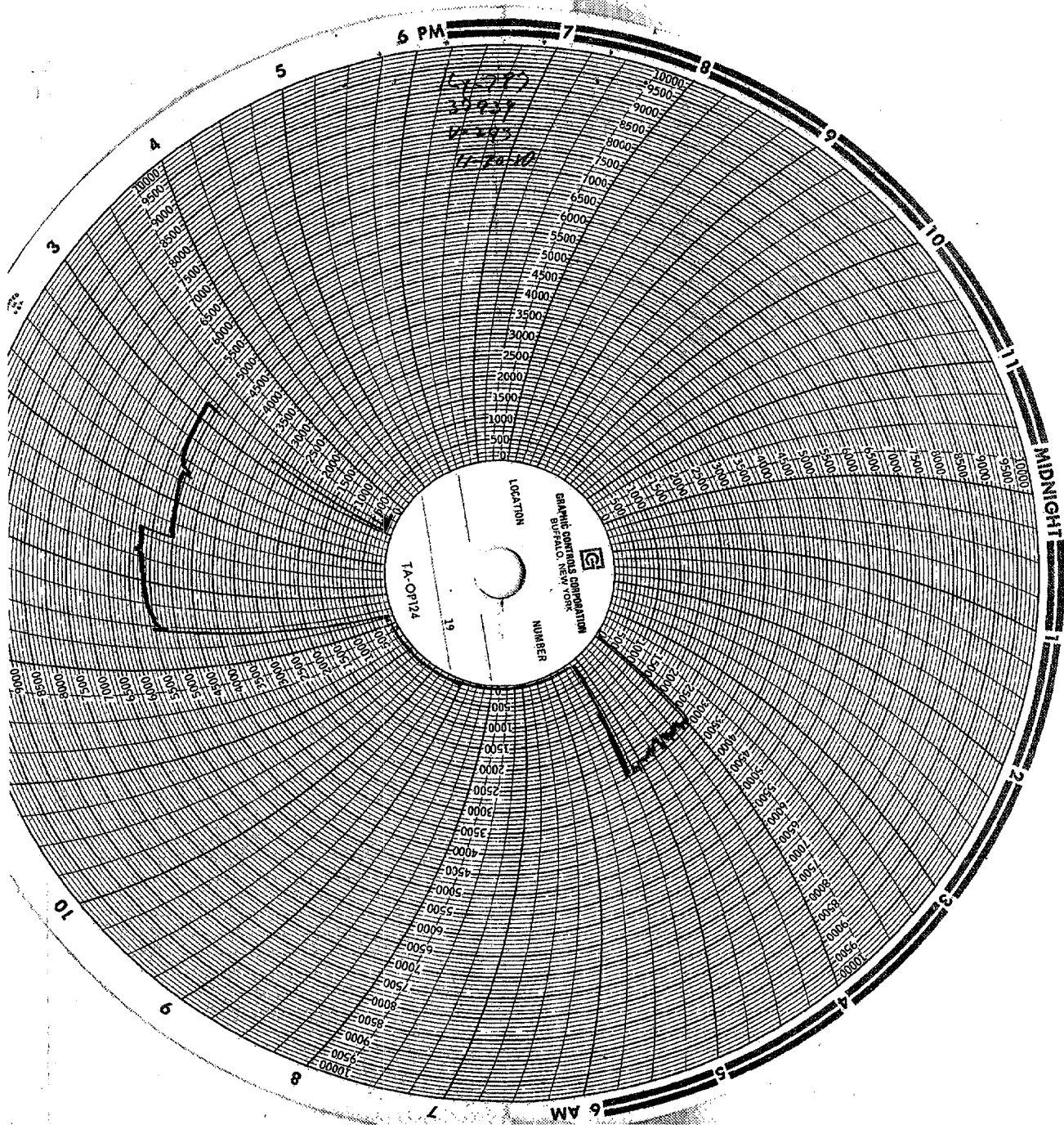
FINISH

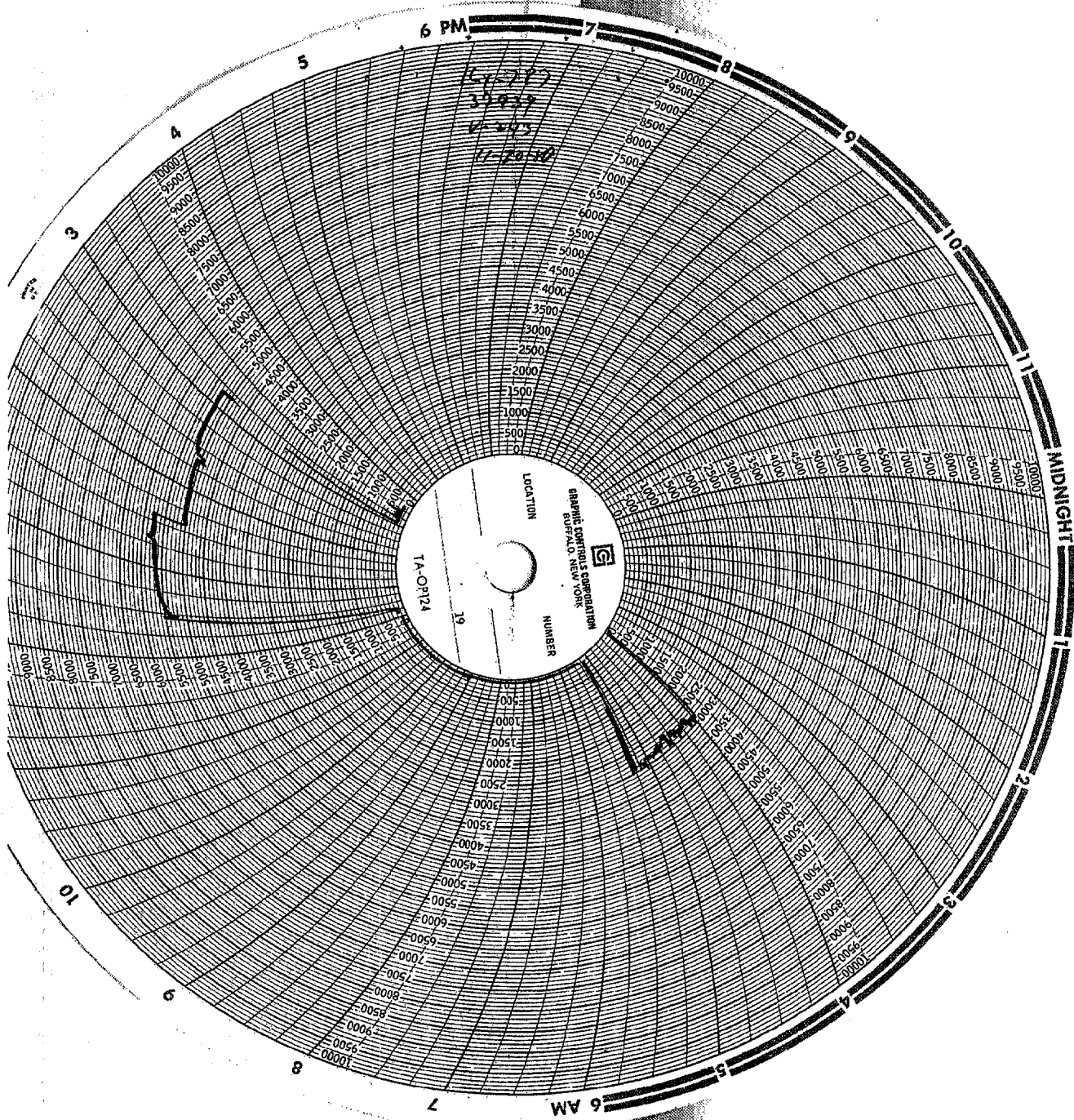
TIME SP STEP

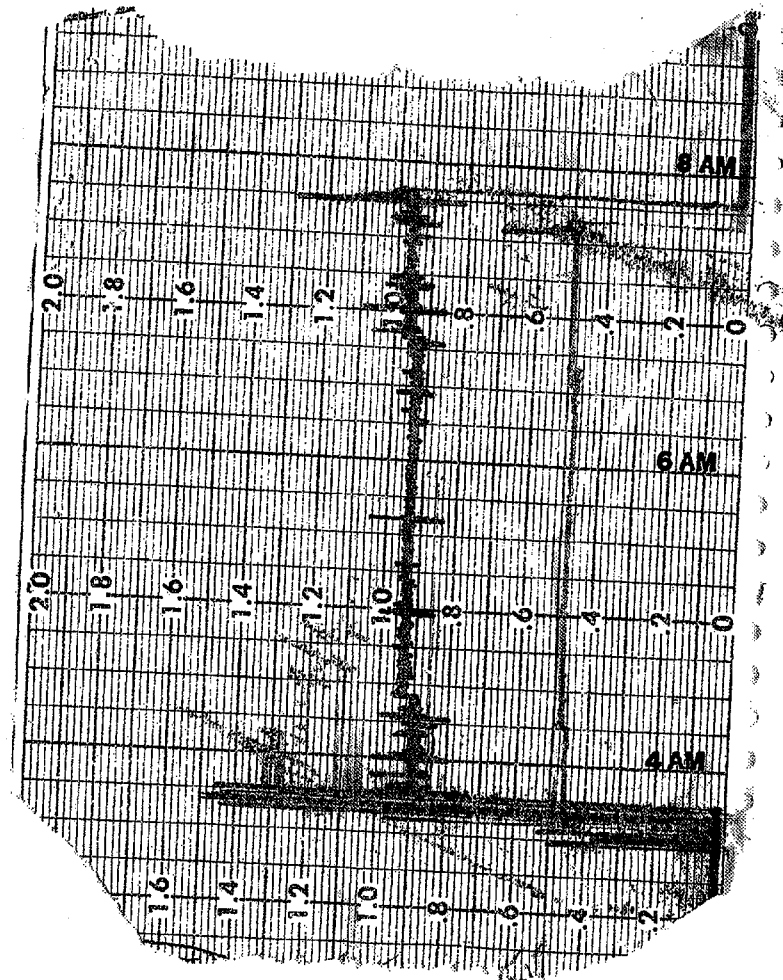
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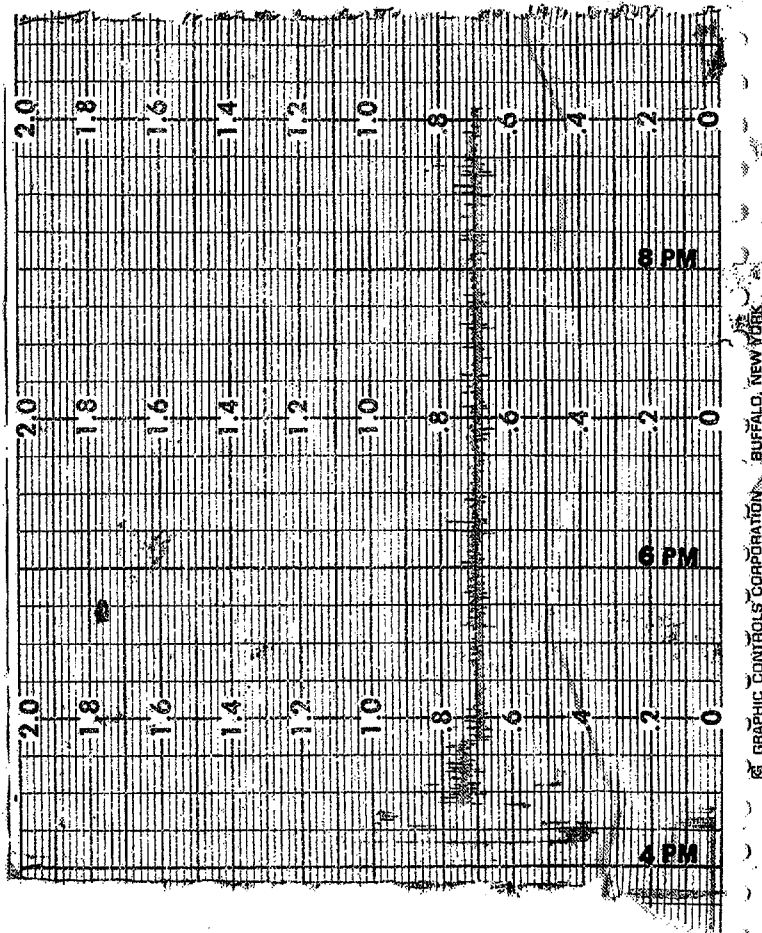
OPTR

120-
237-320









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