CG 03 CODE KY-781-D PKG

LOT A2H07

PROCESSES APPROVED BY
( ) KY-781-D (N) FWP 12/10/81
( )
( )
( )

STANDARD HRS. TIME 11P M

JOB NAME: 03KY781DMN

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	14853	93	2050	14	YC003B		93	
14	YC003B	13681	93	1100	14	YC003B		93	
14	YC003B	14852	93	262	14	YC003B		93	

TOTAL EST'D WGT 4233* LBS. NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW LIGHT	USE LBS	N-CODE	ACCT LBS
203 & 205	1	RUN 60"(990 G) WATER IN V-203 & ADD SET AGITATOR ON HIGH SPEED. ASSUME 50%	36	7-D	18
	2	WEIGH IN DRUM & POUR IN	442	32-D	442
	3	DUMP IN AND STIR 5 MIN LOT	66X50	YC-3-B	3300
1		RECORD: START 2:45 PM 14853 FIN 3:00 PM 13681 14852	2050 1100 262		
	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 50 " & ADJ TO 45" (1662 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 SV 2	9	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV RECORD: TIME START 215 TOTAL MINUTES 115			
		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)			
	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 92 % PRESET #3 70 GAL		115-A	374
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.90 GPM		27-D	373
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 6.3 GPM			
		3FR10 (N-27-D/WATER) RATIO 0.7			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 1.20 GPM		32-D	2527
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 0.9			

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EQUIP		PAGE 2 CG 03 KY-781-D COMTYP JOB NAME: 03KY781DMN	USE LBS	N-CODE	USE LBS
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 40% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
SP	18	ADJUST SV TO 54" (2800 G)			
CP	19	RECORD PH 9.7. 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 11.5. ASSUME 50%	60	7-D	30
	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			
	27	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244 PH RANGE TIME	12 Nond		
		13/41 (30 MIN) 10.0 9.3-10.0 1230			
		14/47 (60 MIN) 10.0 9.3-10.0 100			
		15/48 (2 HRS) 10.0 9.3-10.0 200			
		16/49 (3 HRS) 9.9 9.3-10.0 300			
		17/50 (FINAL) 7.2 7.5-8.5 345			
		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	150 ✓	128-A	150
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 ___	____	15-A	____
		NOTE: USE LIQUID ALUM, N-115-A. ADD TO SV VIA BADGER METER. STIR 5 MIN AFTER EACH ADDITION. ASSUME 50%	____	115-A	____
SP	34	RUN IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
7	35	RECORD: PH 3.9 (4.2-4.4). ADJ IF NECESSARY & RECORD: PH 4.3 ASSUME 77%	4	27-D	3
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	40	7-D	20
		(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 60. BATCH COMPLETE.			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
5 AM	____	7 AM	____	120-54
7 AM	____	3 PM	____	282
300 PM	____	500 PM	____	166

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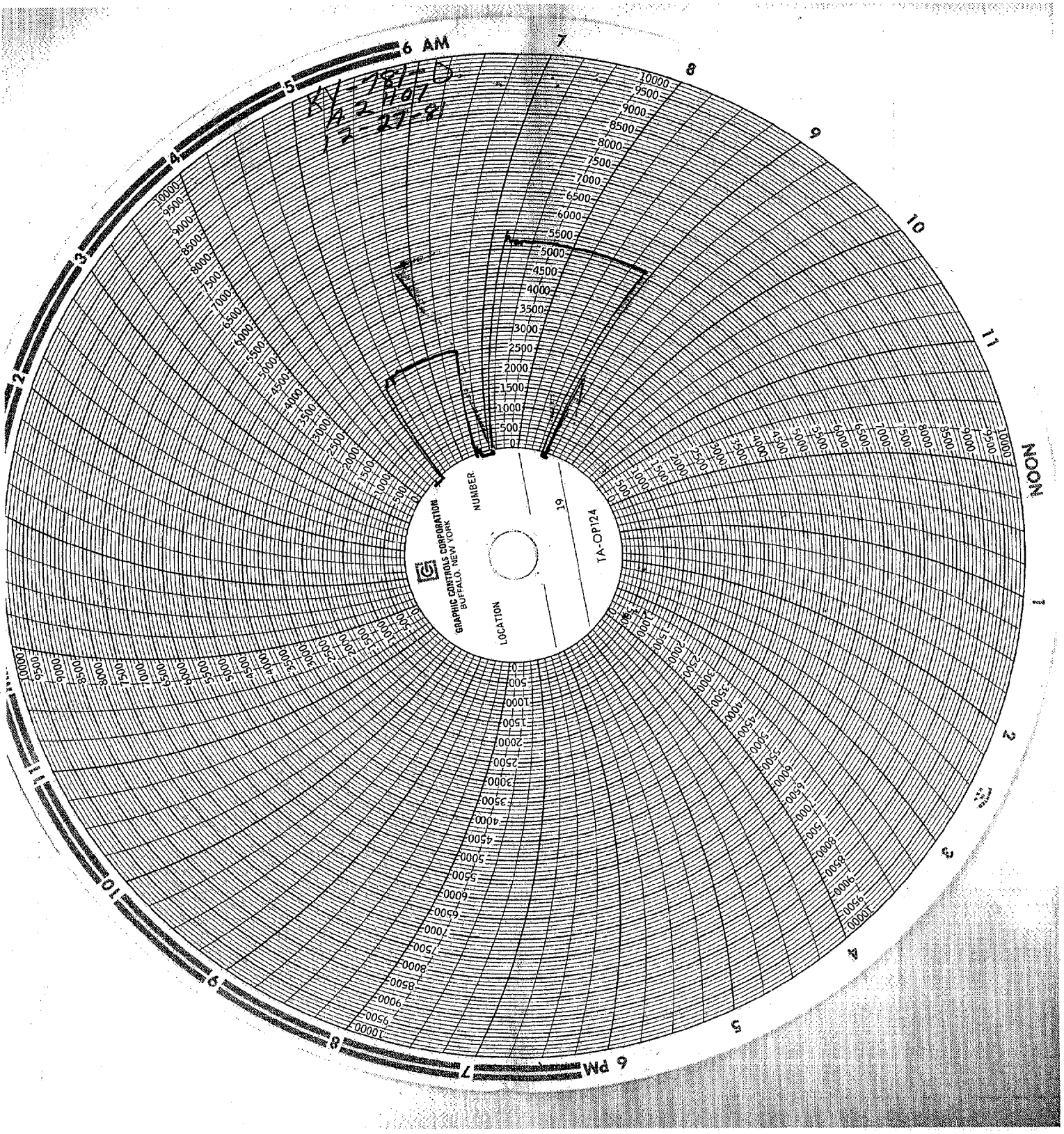

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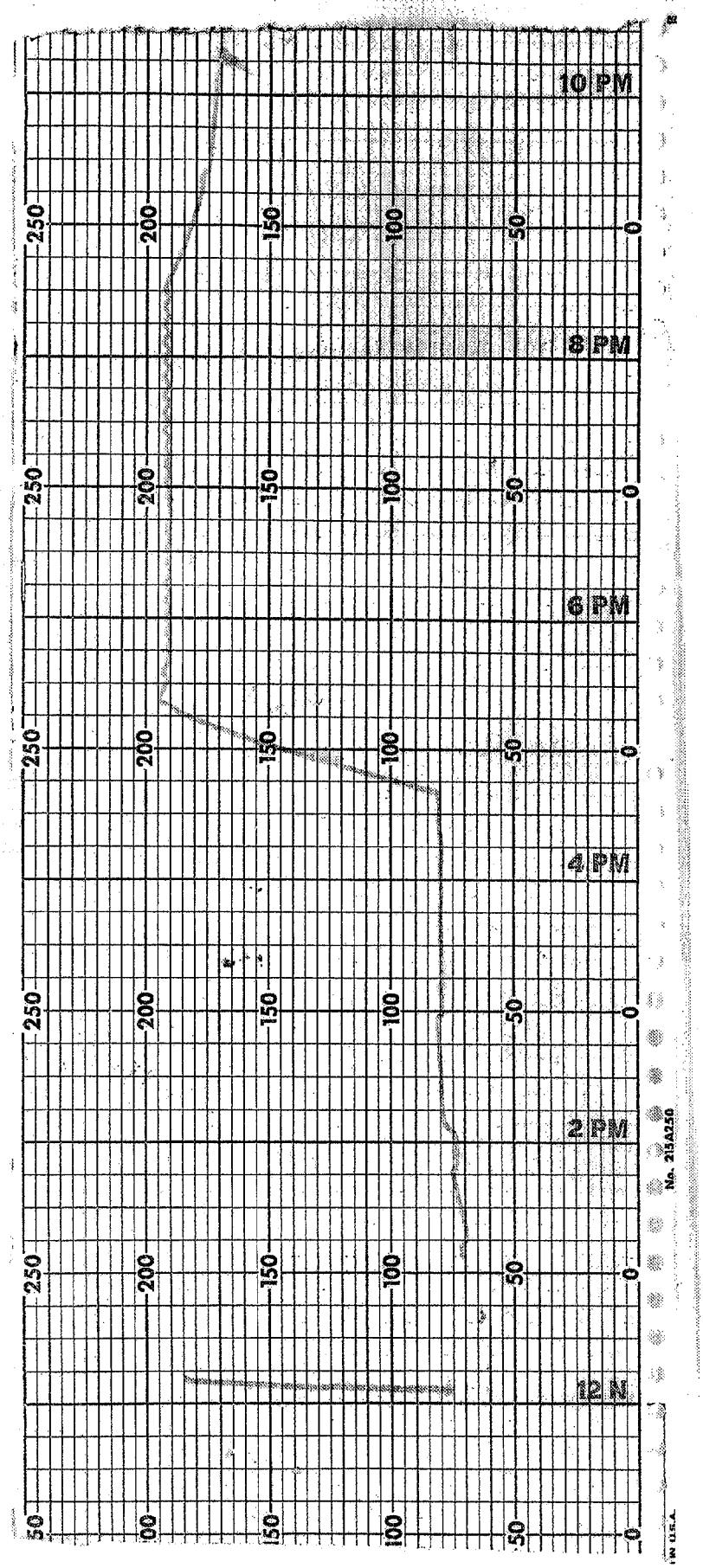

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