

CG 03 CODE KY-787-D ~~PREPARED & CHECKED~~
 LOT 1100-11 80 37805
 EST'D WGT 932 LBS NOV 1 1980
 STANDARD HRS. 8.9 TIME 7A

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

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13185	93	2400	14	YC002B		93	1
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

CLEAN UP AS YOU GO ALONG

NOV 12 1980

TOTAL EST'D WGT 3332

NON-BLEEDING

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	240	983-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 9:40 PM LOT 13185	2400		
1	FIN 10:45 PM			
	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			
205	9 RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:00 A TOTAL MINUTES 150			
2	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	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. 11LG 20% PRESET #1 80 GAL 15-A 160			
	B. 13LG 58% PRESET #6 135 GAL 20-A 135			
15	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	V3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM 27-D 206			
	V3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	V3FR10 (N-27-D/WATER) RATIO 1.35			
	V3FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM 983-D 1376			
	V3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	V3FC20 (N-32-D WATER) IN REMOTE			
	V3FR10 (N-32-D/WATER) RATIO 1.82			

N34705

116 OPERATOR STEP PB
 320 117 RECORD LEVEL 2LG 74% IF BELOW 35% FOLLOW SOL'N
 SV 118 MAKE-UP PROCEDURE FOR N-27-D
 SP 119 ADJUST SV TO 48" (2470 G)
 CP 120 RECORD PH 10.0. ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 121 SIPHON INTO SV. RECORD: PH 11.3. ASSUME 50% 30 7-D 15
 122 OPERATOR STEP PB

123 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9
 SV 124 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP 125 OPERATOR STEP PB
 126 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 127 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
 128 OPERATOR STEP PB 11:00 AM
 129 DURING STRIKE RECORD:
 SP STEP
 V-243/V-244

	PH	RANGE	TIME
13/46 (30 MIN)	9.3	9.0-10.0	11:30 AM
14/47 (60 MIN)	9.2	9.0-10.0	12:00 PM
15/48 (2 HRS)	9.2	9.0-10.0	1:00 PM
16/49 (3 HRS)	9.0	9.0-10.0	2:00 PM
16/49 (4 HRS)	9.0	9.0-10.0	3:00 PM
17/50 (FINISH)	6.8	7.5-8.5	3:45 PM

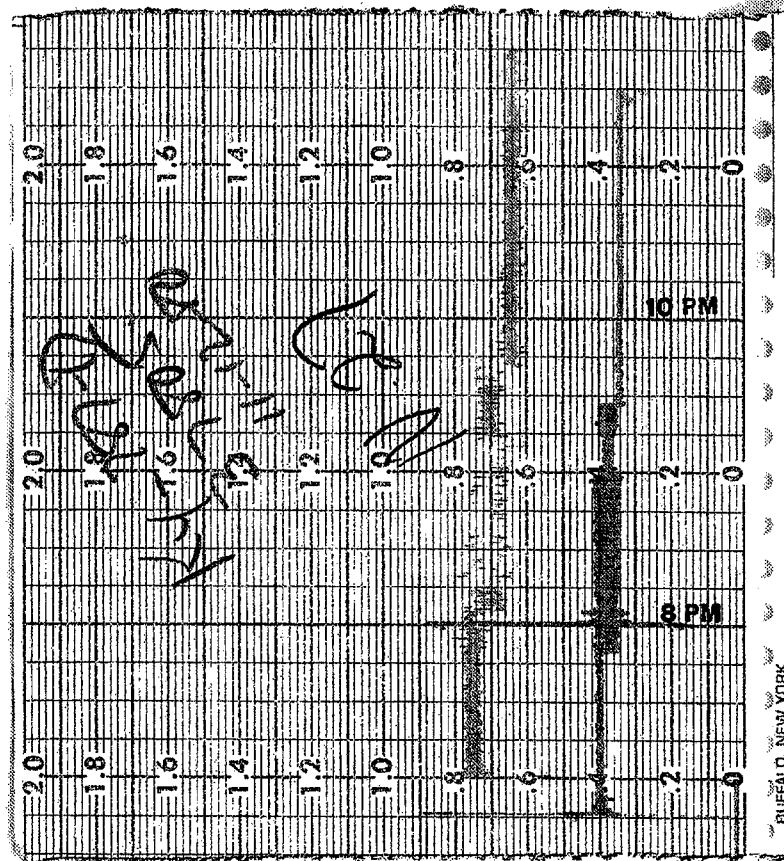
 NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE
 IN LOG. IF FINAL PH > 8.5, ADJ TO 7.5-8.5.
 & RECORD: PH ____ ASSUME 77% 27-D

128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 129 ADD IN 7-8 MIN 350 530-A 350
 339 130 ADJ TO 49" (382 G) AT 80-100°F
 6 131 STIR 5 MIN & RECORD: PH 9.1 (9.5-10.5)
 132 STIR 15 MIN OR LONGER FOR SP STEP 26
 133 RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL
 134 SET PRESET #8 TO 38.2 GAL FROM S 33

302 135 RUN 30" (360 G) WATER INTO V-302
 7 136 ADD & STIR 2 MIN FOR S 40 D ASSUME 50% 160 7-D 80

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 138 SIFT IN ✓ 100 128-A 100
 SV 139 SP STEP 23/53. RECORD: PH 3.7 (3.7-4.2)
 SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
 MIN
 8 141 RECORD: PH 8.5 (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH 9.1 ASSUME 77%
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50% 12 27-D 6
 (SIPHON N-7-D INTO SV) 7-D
 142 OPERATOR STEP PB
 143 SP STEP 29/58. RECORD: PH 9.1 & TIME 5:10 P.M.
 144 OPERATOR STEP PB
 145 SP STEP 60. BATCH COMPLETE.

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
11:00 P	7:00 P	259-101
7:00 A	3:00 PM	237-244
3:00 PM	5:10 P.M.	381-301



BUFFALO, NEW YORK

