

MAY - 8 1980

MAY 1 1980

(AUTOMATED)

S.V. 244 244

C.V.

MAKING INSTRUMENT
D.V.

CG 03 CODE KY-795-D PKG

LOT MAY-5 35618

PROCESSES

APPROVED BY

() KY-795-D (H) FWP 4/23/80

EST'D WGT ~~4110~~ 880 LBS

STANDARD HRS. 8.2 TIME 3P M

TYPED BY: FWP 4/23/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	-----	93	-----	14	YC002B	-----	93	-----
14	YC002B	-----	93	-----	14	YC002B	-----	93	-----
14	YC002B	-----	93	-----	14	YC002B	-----	93	-----

TOTAL EST'D WGT ~~4612~~ 4380

MAY 6 1980

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN	475	32-D	475
	3 DUMP IN AND STIR 5 MIN. LOT 24863	70X50	YC-2-B	3500
	RECORD: START 3:06 PM	3500		
	FIN 3:15 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 42" & 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 1:11 AM TOTAL MINUTES 250			
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 & 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 IS SET AT 190-194°F			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 8.2% PRESET #1 104 GAL		15-A	208
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.95 GPM 0.71		27-D	376
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 7.7 GPM 5.8			324
	3FR10 (N-27-D/WATER) RATIO 0.8			
	BFC10 (N-32-D CONTROLLER) IN MANUAL 1.27 GPM 0.70		32-D	2675
	BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.2 GPM 5.4			1885
	BFR10 (N-32-D/WATER) RATIO 1.0			

V244

EQUIP PAGE 2 CG 03 KY-795-D EST WGT 4612#

USE
LBS

N-
CODE

USE
LBS

16 OPERATOR STEP PB
17 RECORD LEVEL 2LG 46% IF <35% FOLLOW SOLUTION
SV MAKE-UP PROCEDURE FOR N-27-D
SP 18 ADJUST SV TO 68" (3495 G)
CP 19 RECORD PH 10.1. 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 11.2 ASSUME 50% 60 7-D 30
20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9
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
13/46 (30 MIN) 9.7 9.0-10.0 8:10
14/47 (60 MIN) 9.7 9.0-10.0 8:40
15/48 (2 HRS) 9.6 9.0-10.0 9:40
16/49 (3 HRS) 9.6 9.0-10.0 10:40
17/50 (FINAL 3-HRS) 7.9 7.5-8.5 11:25
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%

7:40/AM

DRUM 28 WEIGH INTO 55 GAL DRUM ASSUME 50% 56 27-D 28
6 29 FILL WITH WATER & STIR 2 MIN 7-D

30 SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.
SV 31 SP STEP 23/53 - RECORD: PH 3.7 (3.3-3.7)
SP 32 IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7
& RECORD: PH 15-A
CP 33 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.
34 SIFT IN 150 128-A 150
35 SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR
5 MIN
36 RECORD: PH 4.2 (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
37 SIPHON N-7-D INTO SV
38 OPERATOR STEP PB 22 978-A 22
39 SP STEP 24/54 - POUR IN & STIR 15 MIN
40 OPERATOR STEP PB
41 SP STEP 60 - BATCH COMPLETE
44 OPERATOR STEP PB

START
TIME SP STEP

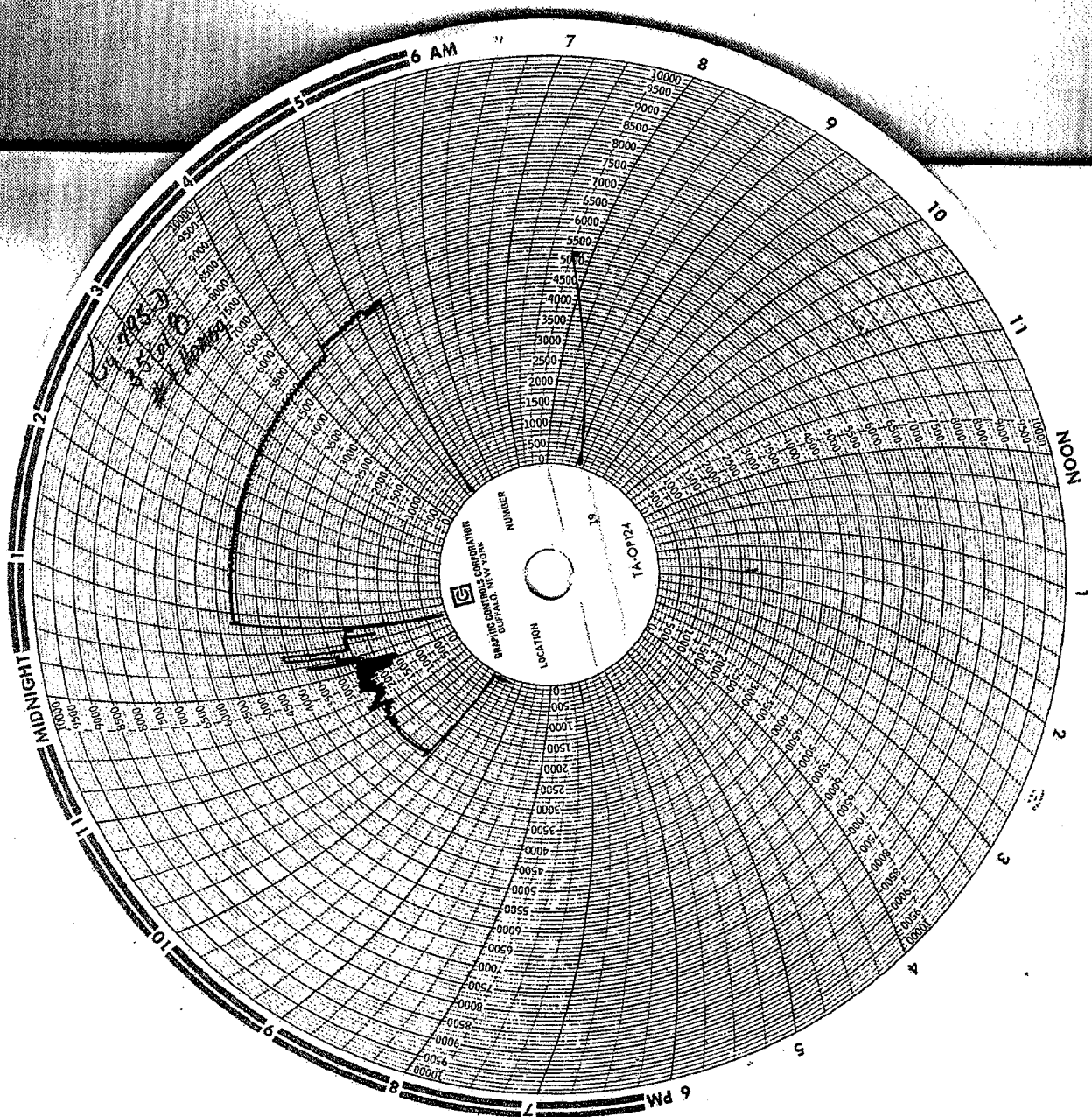
FINISH
TIME SP STEP

OPTR

U.P.M.
7:00A

7.A.M.
12:05 P.M.

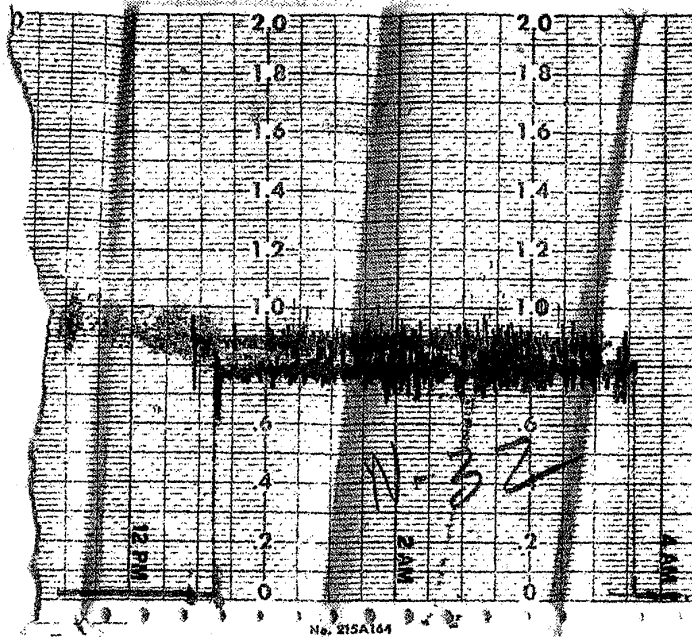
34
235



DUP050456651

N32108.01

V-244



DUP050456653
N32108.02

