CG 03 CODE KY-787-D PKG
LOT NOV-13 80 37727
EST'D WGT 932 LBS
STANDARD HRS. 8.9 TIME 7 A M

PUNCHED & CHECKED
NOV 12 1980

PROCESSES	APPROVED BY
( ) KY-787-D	(Q) FWP 9/23/80
( )	( ) (XOB-17: 25%
( )	( ) LESS N-32-D
( )	( ) & 240 MIN
( )	( ) STRIKE)

TYPED BY: FP 9/23/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13174	93	1800	14	YC002B		93	
14	YC002B	13193	93	600	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

NOV 11 1980

TOTAL EST'D WGT 3332 NON-BLEEDING

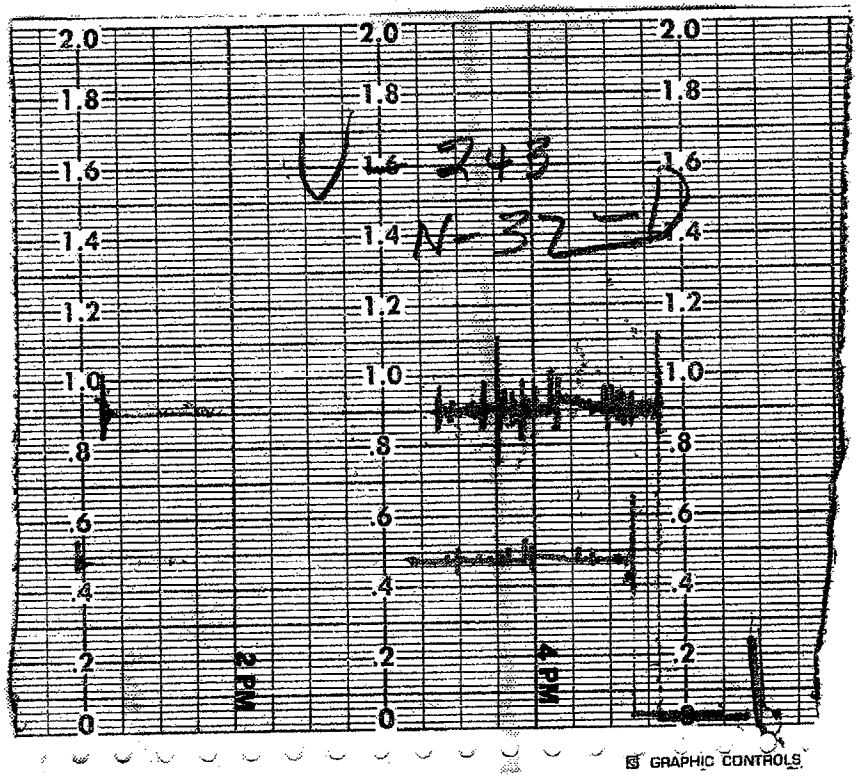
EQUIP		NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203 & 205	1	RUN 60"(990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.		983	
	2	WEIGH IN DRUM & POUR IN	240	~~32~~-D	240
	3	DUMP IN AND STIR 5 MIN LOT	48X50	YC-2-B	2400
1		RECORD: START 6:30 PM 13174	1800		
		FIN 7:20 13193	600		
	4	ADJUST 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-243 & START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 10:43 AM TOTAL MINUTES 142			
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 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)			
3	14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
		A. 11LG 46 % PRESET #1 80 GAL		15-A	160
		B. 13LG 86 % PRESET #6 135 GAL		20-A	135
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
		3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
		3FR10 (N-27-D/WATER) RATIO 1.35			
		8FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		~~32~~-D	1376
		8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM		983	
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.82			
		Sourced to repair V383 outlet + leaking piping to auto Krolor Rinse		1-22-D	700

EQUIP | PAGE 2 CG 03 KY-787-D EST WGT 3332# V-243 | USE LBS | N-CODE | USE LBS

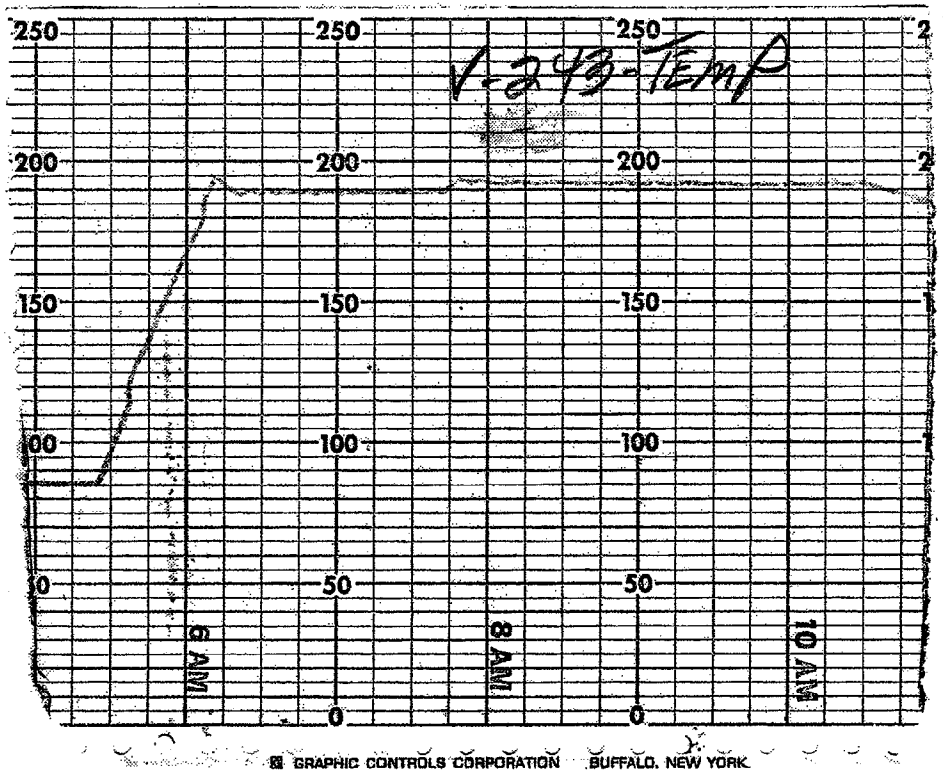
	19	OPERATOR STEP PB		
320		RECORD LEVEL 2LG 93% IF BELOW 35% FOLLOW SOL'N		
SV		MAKE-UP PROCEDURE FOR N-27-D		
SP	18	ADJUST SV TO 48" (2470 G)		
CP	19	RECORD PH 10.1. ADJ TO 11.1-11.3 WITH N-7-D AT		
		5% (10 PARTS WATER TO 1 PART N-7-D)		
4		SIPHON INTO SV. RECORD: PH 11.2. ASSUME 50%	30	7-D 15
	20	OPERATOR STEP PB		
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8		
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	5:10	
		13/46 (30 MIN) 9.6 9.0-10.0 5:40		
		14/47 (60 MIN) 9.6 9.0-10.0 6:10		
		15/48 (2 HRS) 9.6 9.0-10.0 7:10		
		16/49 (3 HRS) 9.6 9.0-10.0 8:10		
		16/49 (4 HRS) 9.5 9.0-10.0 9:10		
		17/50 (FINISH) 7.0 7.5-8.5 9:55		
		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 ____
	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339		
	29	ADD IN 7-8 MIN	350	530-A 350
339	30	ADJ TO 49" (382 G) AT 80-100*F		
6	31	STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)		
	32	STIR 15 MIN OR LONGER FOR SP STEP 26		
	33	RECORD: VOL 51" & CALC 51" X 0.78 39.8 GAL		
	34	SET PRESET #8 TO 398 GAL FROM S 33		
302	35	RUN 30" (360 G) WATER INTO V-302		
7	36	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	160	7-D 80
	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.		
	38	SIFT IN	100	128-A 100
SV	39	SP STEP 23/53. RECORD: PH 3.9 (3.7-4.2)		
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5		
		MIN		
8	41	RECORD: PH 9.5 (9.0-9.5). ADJ IF NECESSARY &		
		RECORD: PH____ ASSUME 77%	____	27-D ____
		(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%	____	7-D ____
		(SIPHON N-7-D INTO SV)		
	42	OPERATOR STEP PB		
	43	SP STEP 29/58. RECORD: PH 9.5 & TIME 11:15 P.M		
	44	OPERATOR STEP PB		
	45	SP STEP 60. BATCH COMPLETE		
		45A PUMP V-243 TO V-240		

	START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
	2:00AM	____	3:00A	____	144
	3:PM	____	11:PM	____	223
	11:PM	____	11:15/PM	____	57

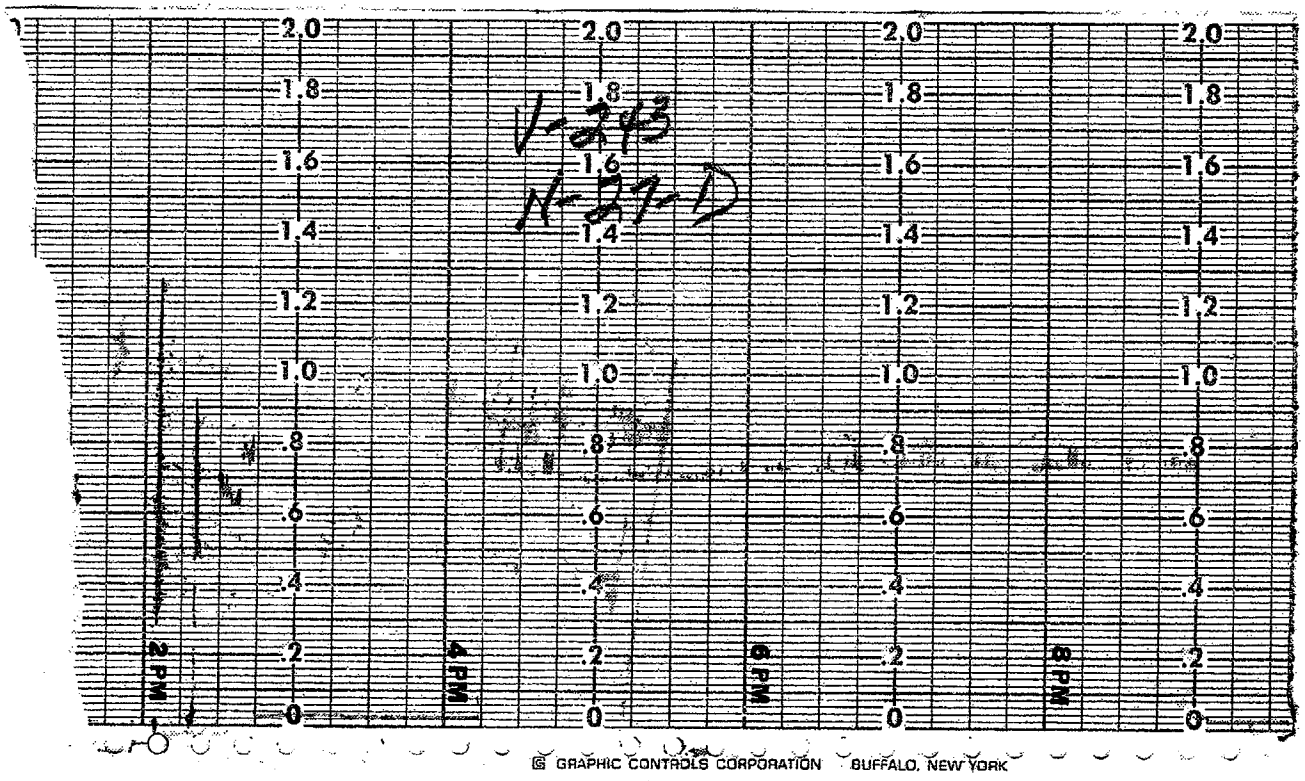
DUP050105019



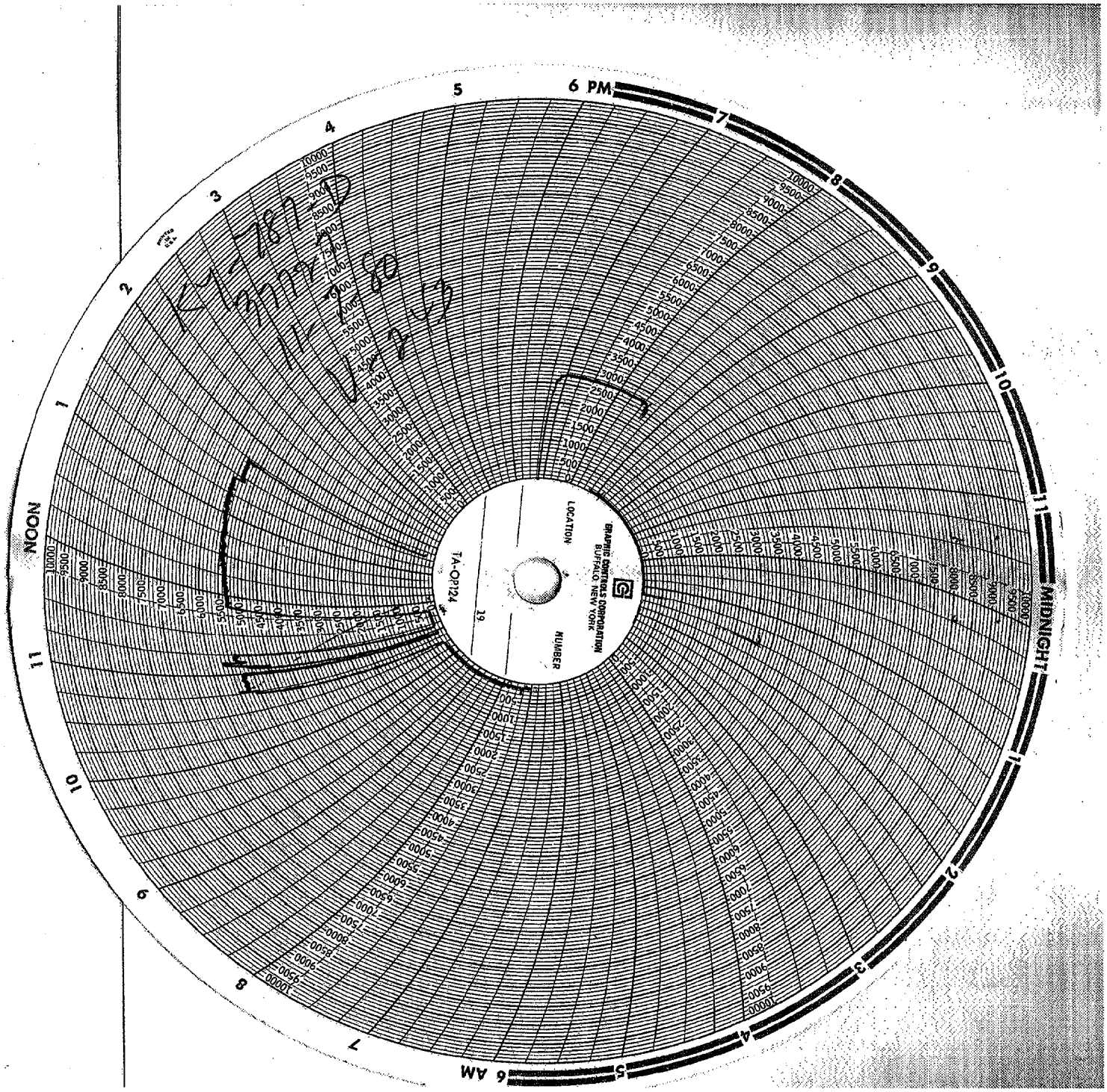
DUP050105020



DUP05010502



DUP050105022



DUP050105023