CG 03 CODE KY-795 PUNCHED & CHECKED

MAY 8 35638 MAY 12 1980

EST'D WGT 880 LBS

STANDARD HRS. 8.2 TIME M

PROCESSES APPROVED BY

( ) KY-795-D (H) FWF 5/1/80

( ) 374 N-32-D STRIKE TO

( ) IMPROVE GLOSS

( )

( )

TYPED BY FWF 5/1/80

COMPONENT CONSUMPTION								
CG	CODE	LOT	PO	LBS	CG	CODE	LOT	PO	LBS
14	YC002B	24790	93	3000	14	YC002B		93	
14	YC002B	24774	93	500	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

MAY 9 1980

TOTAL EST'D WGT 4380

NON-BLEEDING

NOTE		NAME "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ACCT LBS
03	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	70X50	YC-2-B1	3500
		RECORD START 3:30 PM 24790	3000		
		FIN 3:50 PM 24774	500		
V-263	4	ADJUST TO 75* (1275 G)			
	5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	6	HOMOG AT 2400-2600 PSI INTO V-205			
	7	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
		OF HOT WATER AT 2400-2600 PSI INTO V-205			
	8	RECORD V-205 VOL ____" & ADJ TO 60" (2100 G)			
	9	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
V-263	10	RUN 10* (514 G) WATER INTO V-___ *A START			
V		AGITATOR 263			
		PUMP V-205 THRU HOMOG 3:35 4800-5200 PSI INTO SV 3:45			
		RECORD TIME START ____ TOTAL MINUTES 10			
		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			
RP 142		SF STEE 01 - SET FORMULA SELECTOR TO POSITION			
A		5 (V-243) OR POSITION 10 (V-244)			
CF 113		PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
		REMOTE (TEMP IS SET AT 190-194*F)			
3	114	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS			
		A: 11LG 66% PRESET #1 104 GAL		15-A	208
	115	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		SFC10 (N-27-D CONTROLLER) IN MANUAL 0.71 GPM		27-D	296
		SFC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
		SFR10 (N-27-D/WATER) RATIO 0.8			
		SFC10 (N-32-D CONTROLLER) IN MANUAL 0.90 GPM		32-D	1885
		SFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		SFC20 (N-32-D WATER) IN REMOTE			
		SFR10 (N-32-D/WATER) RATIO 1.0			

QUIP		PAGE 2 CG 03 KY 795-D EST WGT 4612	USE LBS	N-CODE	USE LBS
		V-244			
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 82% IF <35% FOLLOW SOLUTION			
SV		MAKE-UP PROCEDURE FOR N-27-D			
P	18	ADJUST SV TO 68° (3495 G)			
P	19	RECORD PH 10.7 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%	12	7-D	6
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
V	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
P	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) 9.8 9.0-10.0 9:35			
		14/47 (60 MIN) 9.8 9.0-10.0 10:05			
		15/48 (2 HRS) 9.8 9.0-10.0 11:05			
		16/49 (3 HRS) 9.8 9.0-10.0 12:05			
		17/50 (FINISH) 8.2 7.5-8.5 12:50			
		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	
DRUM	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	56	7-D	28
	29	FILL WITH WATER & STIR 2 MIN			
	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB			
SV	31	SP STEP 23/53 - RECORD: PH 3.4 (3.3-3.7)			
SP	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7			
&		RECORD: PH ___		15-A	
CP		NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140			
		*F IN DRUM. USE 30 GAL WATER TO 50% N-15-A.			
		STIR 5 MIN AFTER EACH ADDITION.		65A	
	33	SIFT IN	150	~~128-A~~	150
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR			
		5 MIN			
	35	RECORD: PH 4.1 (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	
		SIPHON N-7-D INTO SV			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN &STIR 15 MIN	22	978-A	22
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	44	OPERATOR STEP PB			

9:05/AM

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
11PM		7AM		120
7:00A		1:55PM		235

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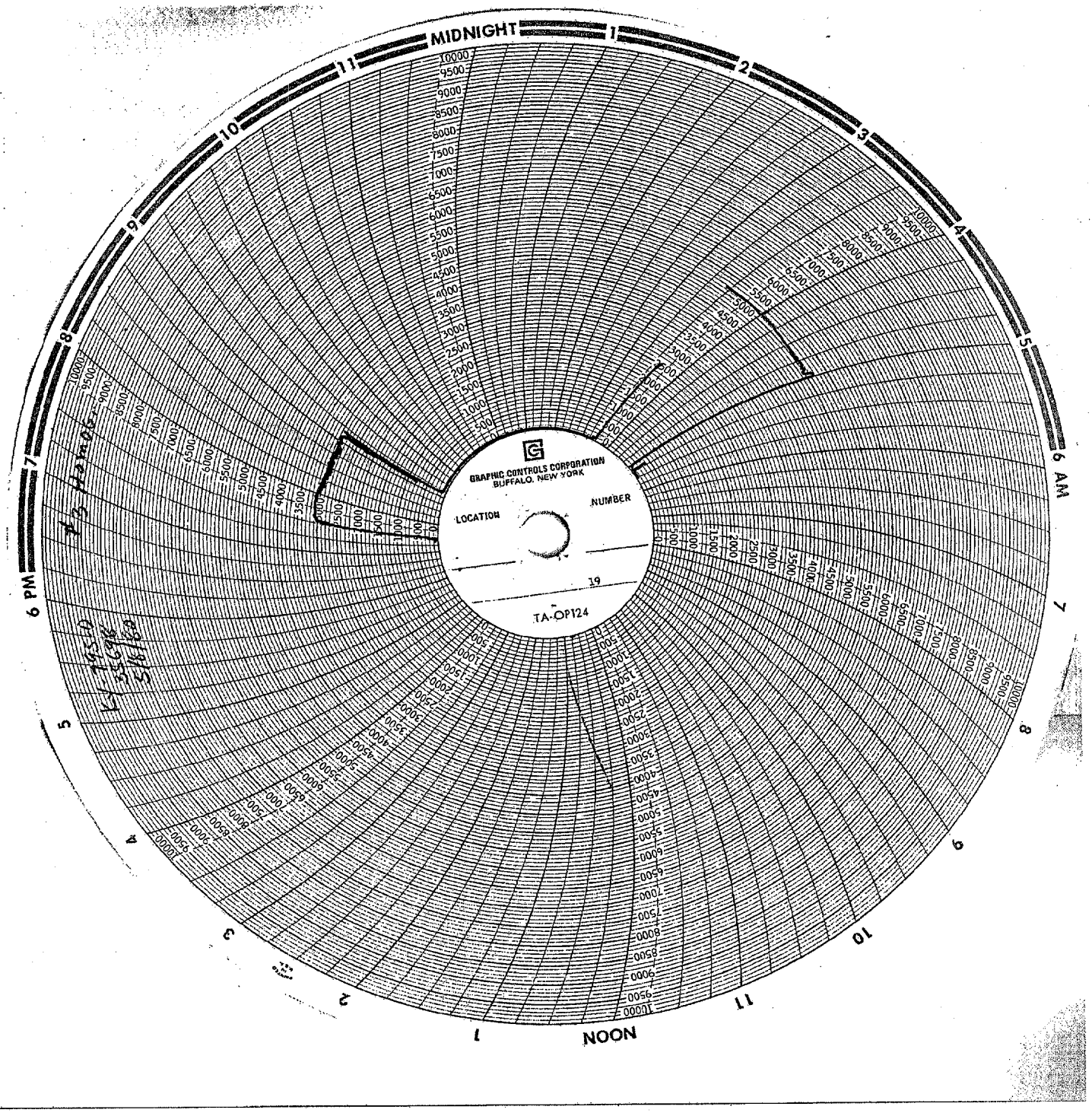

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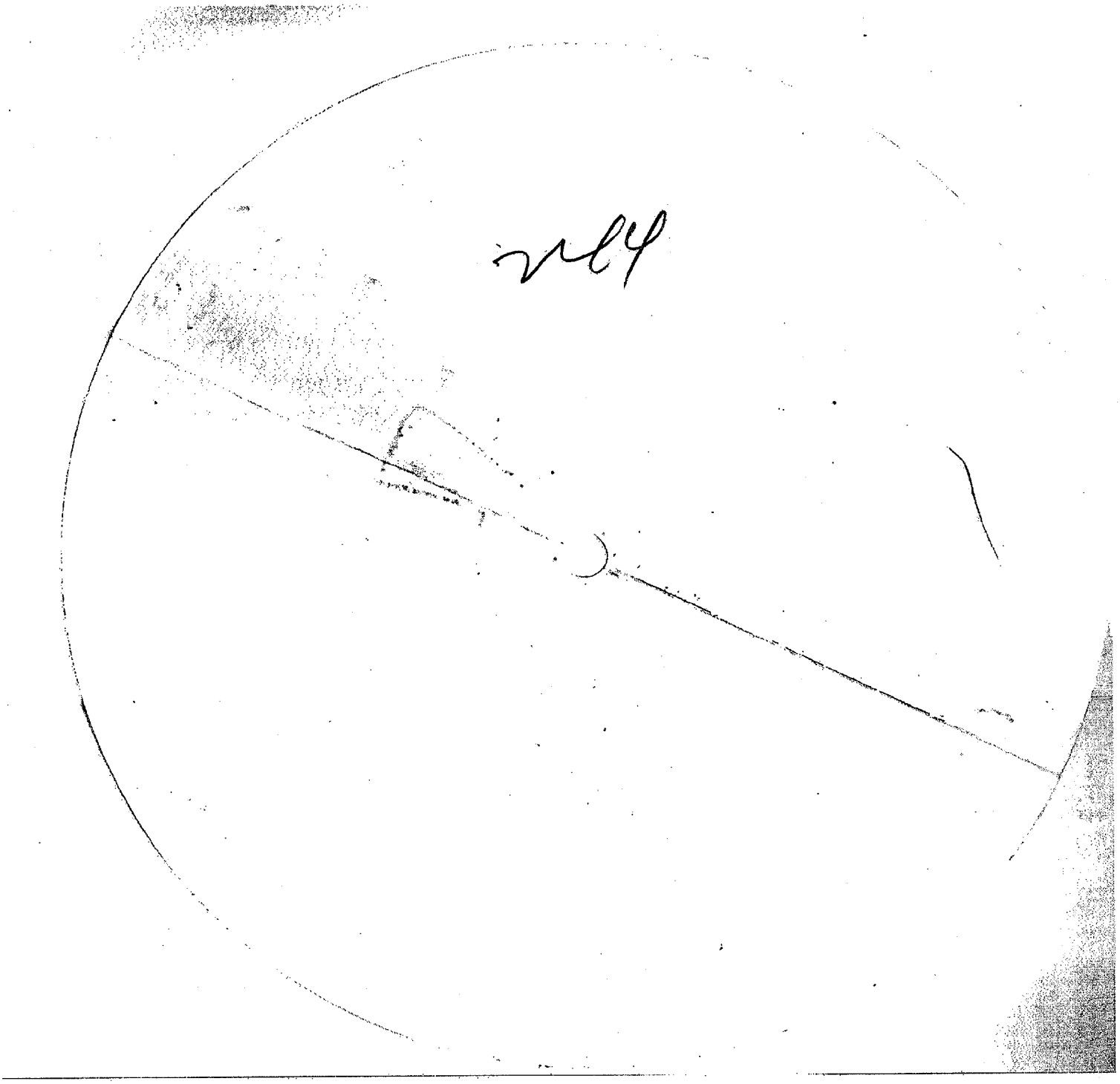

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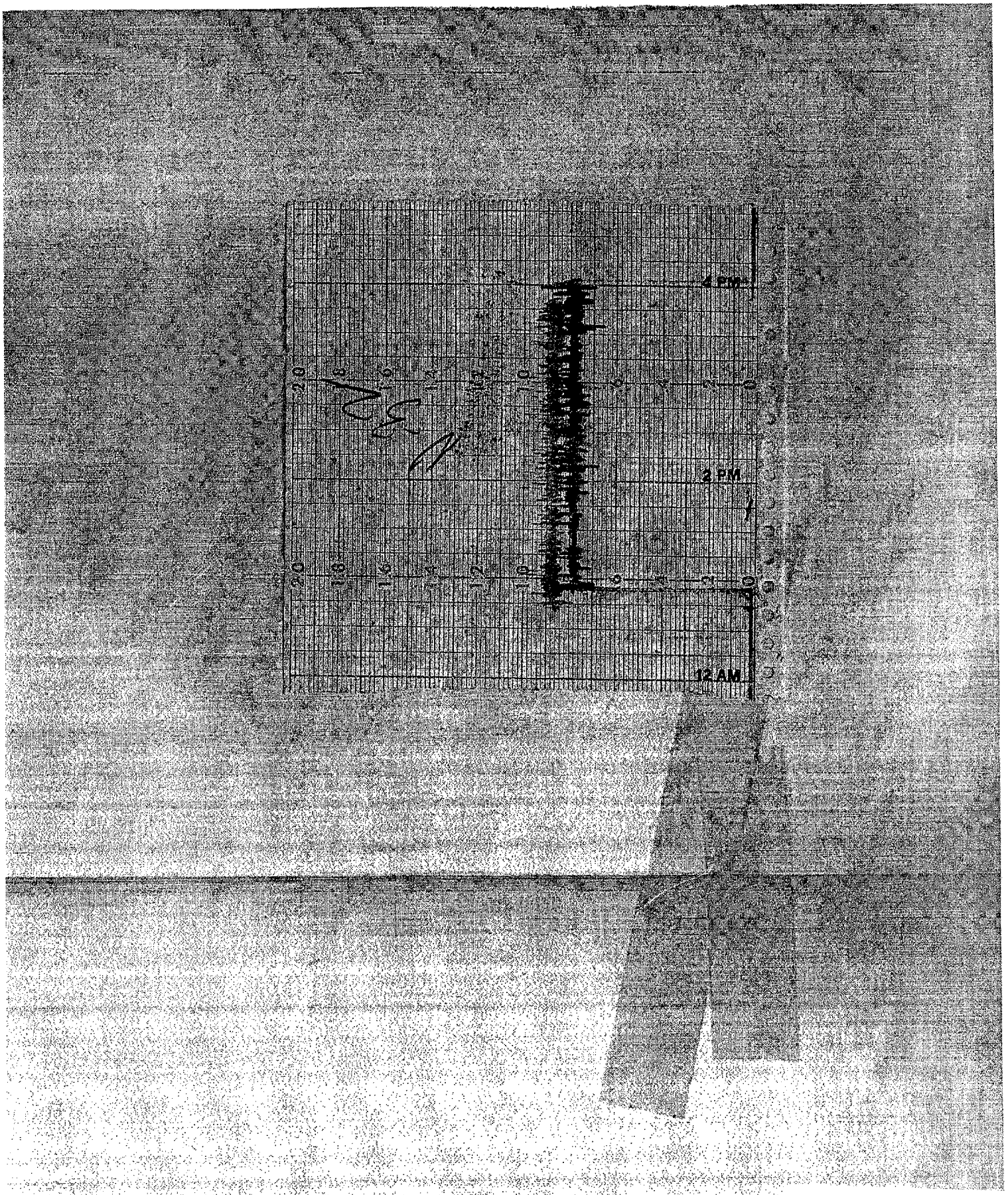

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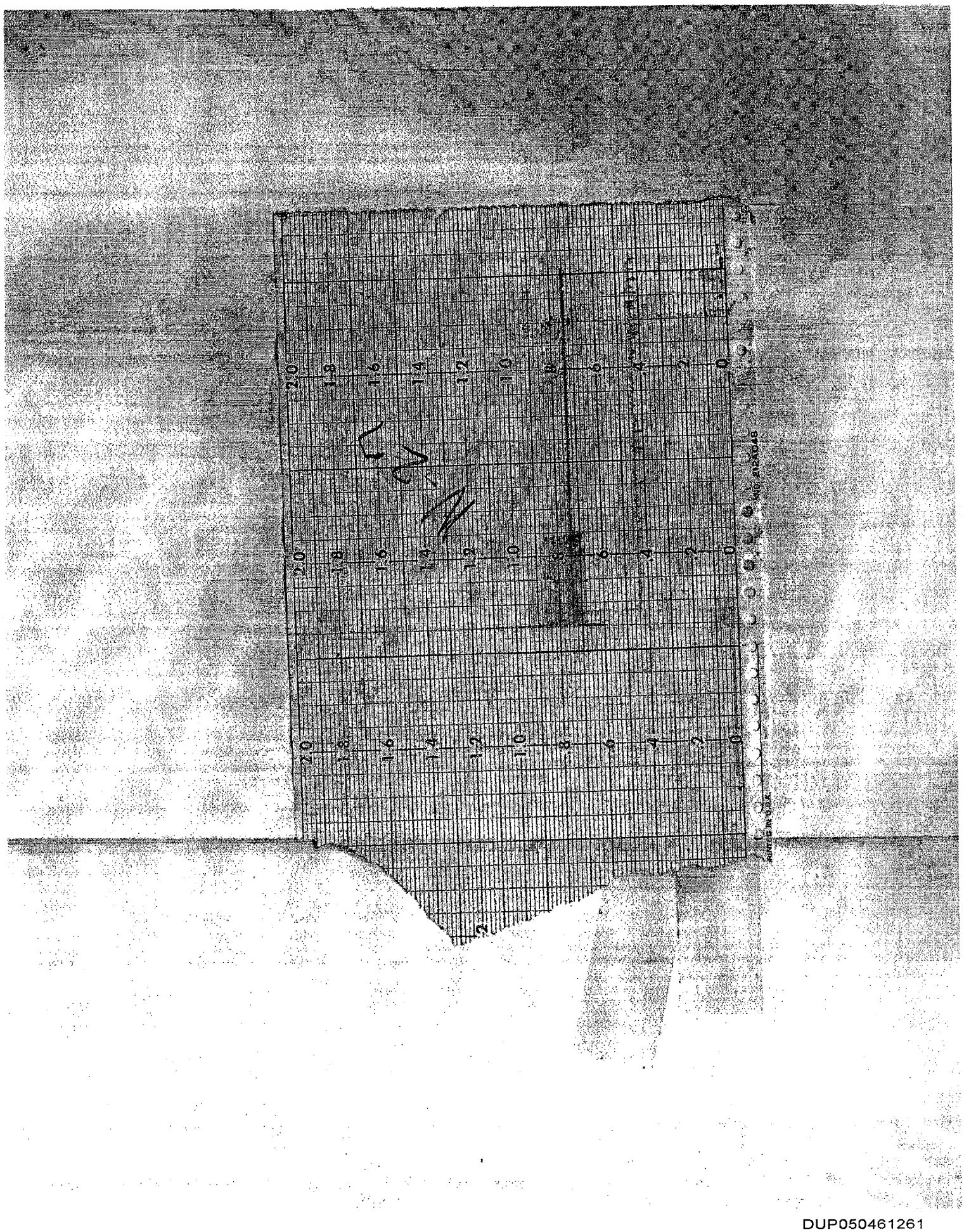

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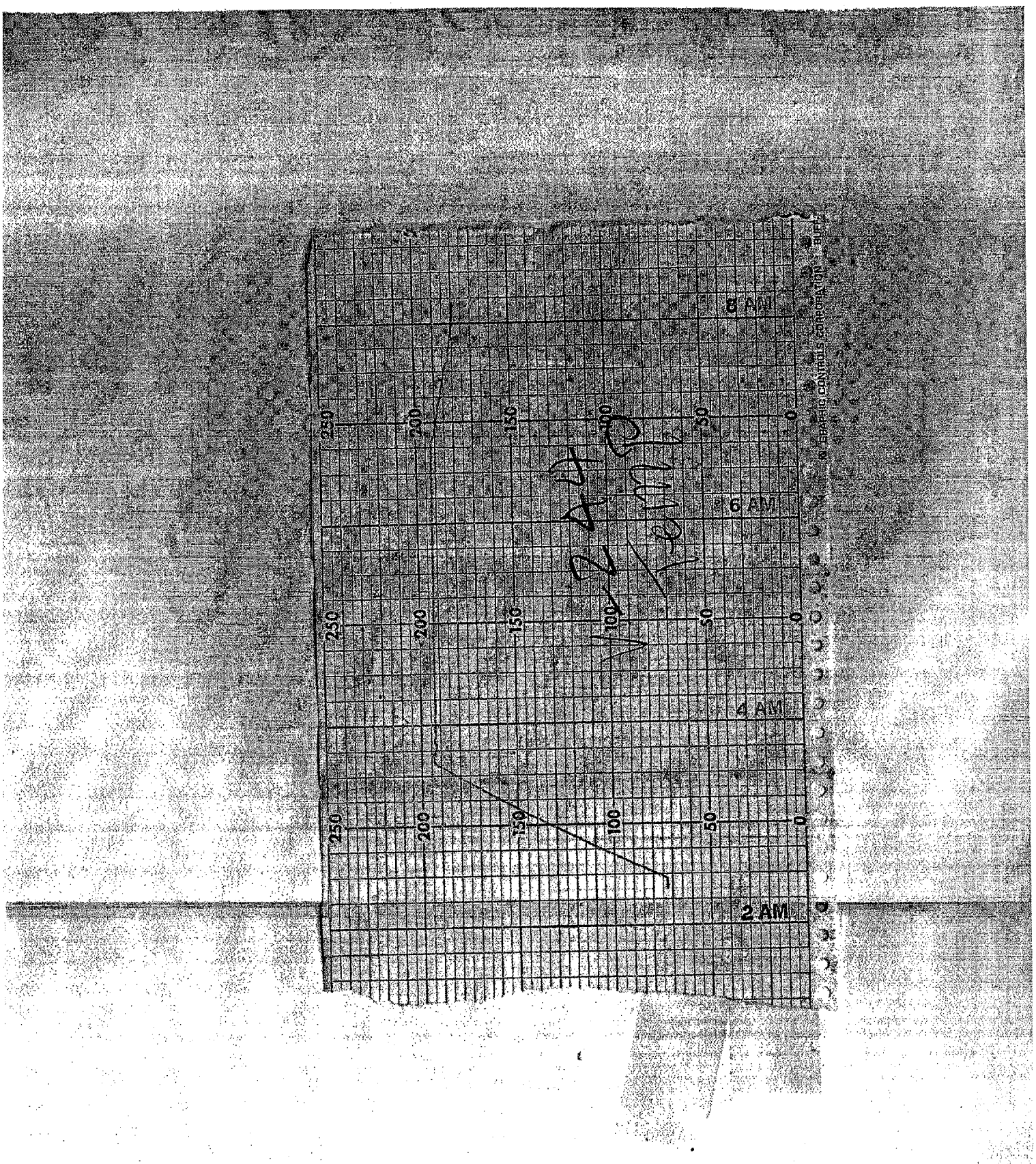

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