

CG 03 CODE KY-788-D PKG

LOT May '81 E1136

PROCESSES

APPROVED BY

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME _____ M

JOB NAME 03KY788DMJ

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	14028	93	2500	14	YC003B		93	
14	YC003B	13669	93	100	14	YC003B		93	
14	YC003B		93		14	YC003B		93	
03	KY-788-D	82946-1	78	50					

DO NOT USE YC-3-B LOTS 14001 THRU 14004

TOTAL EST'D WGT 3560 3610

Homeg #3 - 2nd Pass NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	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	345	32-D	345
	3 DUMP IN AND STIR 5 MIN	52X50	YC-3-B	2600
	RECORD: START 5:15AM	14028		
	FIN 6:25AM	13669		
		82946-1		50
	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-205 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 2:35 TOTAL MINUTES 160			
	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 112	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 3 (V-243) OR POSITION 8 (V-244)		
CP 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 3.0% PRESET #2 208 GAL	15-A	416
	B. 13LG 7.3% PRESET #6 135 GAL	20-A	135
115	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:		
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.54 GPM	27-D	180
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 4.4 GPM		
	3FR10 (N-27-D/WATER) RATIO 0.8		
	BFC10 (N-32-D CONTROLLER) IN MANUAL 0.72 GPM	32-D	1215
	BFC20 (N-32-D WATER) IN MANUAL LOCAL 3.9 GPM		
	BFC20 (N-32-D WATER) IN REMOTE		
	BFR10 (N-32-D/WATER) RATIO 1.1		

EQUIP

PAGE 2 CG 2 KY-788-D EST WGT 3560#

USE

N-

USE

LBS

CODE

LBS

V-243

116	OPERATOR STEP PB			
320	117 RECORD LEVEL 2LG 89% IF (35% FOLLOW SOLUTION			
SV	MAKE-UP PROCEDURE FOR N-27-D			
SP	118 ADJUST SV TO 47" (2400 G)			
CP	119 RECORD PH 10.2 ADJ TO 11.0-11.2 WITH N-7-D AT			
	5% (10 PARTS WATER TO 1 PART N-7-D)			
4	SIPHON INTO SV. RECORD: PH 11.0 ASSUME 50%	40	7-D	20
120	OPERATOR STEP PB			

121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0			
SV	122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	123 OPERATOR STEP PB			
124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS			
	ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN			
	LIMITS, SWITCH 3FC20 TO REMOTE			
126	OPERATOR STEP PB			
127	DURING STRIKE RECORD:			
	SP STEP			
	V-243/V-244			
	PH RANGE TIME			
	13/46 (30 MIN) 9.8 9.3-10.0 8:00			
	14/47 (60 MIN) 9.8 9.3-10.0 8:30			
	15/48 (2 HRS) 9.7 9.3-10.0 9:30			
	16/49 (2 HRS, 25 MIN) 9.6 9.3-10.0 9:55			
	17/50 (FINAL 3 HRS) 8.2 7.5-8.5 10:30			
	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 10.1 (9.5-10.5)			
132	STIR 15 MIN OR LONGER FOR SP STEP 26/56			
133	RECORD: VOL 4.1 & CALC 4.1 X 0.78 = 3.2 GAL			
134	SET PRESET #8 TO 3.2 GAL FROM S 33			

302	135 RUN 40" (440 G) WATER INTO V-302			
7	136 ADD & STIR 2 MIN FOR S 40 ASSUME 50%	360	7-D	180

137	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
138	STET IN	100	12B-A	100
SV	139 SP STEP 23/53. RECORD: PH 3.3 (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 9.4 (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)			
142	OPERATOR STEP PB			
143	SP STEP 29. RECORD: PH ____ & TIME ____			
144	OPERATOR STEP PB			
145	SP STEP 60. BATCH COMPLETE.			

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
7A	3P	120-301
3:00P	11:00P	235-244

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