

CG 03 CODE KY-787-D PKG

LOT SEP-28-80 37249

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 11P M

PROCESSES

() 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
14	YC002B	24983	93	2400
14	YC002B		93	
14	YC002B		93	

CG	CODE	LOT	PQ	LBS
14	YC002B		93	
14	YC002B		93	
14	YC002B		93	

3M

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.			
203	2 WEIGH IN DRUM & POUR IN	240	32-D	240
203	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
1	RECORD: START 310			
1	FIN 435			
1	4 ADJUST TO 75" (1275 G)			
1	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
1	6 WHEN V-205 MT, WASH COLOR THRU HOMOG WITH MIN			
1	7 OF HOT WATER AT 2400-2600 PSI INTO V-205			
1	8 RECORD: V-205 VOL 40" & ADJ TO 60" (2100 G)			
1	9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
SV	10 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
2	11 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
2	RECORD: TIME START 8:50 PM TOTAL MINUTES 135			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
11	12 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	13 STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
CP	14 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
3	15 REMOTE (TEMP IS SET AT 190-194°F)			
3	16 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
3	A. 11LG 57% PRESET #1 80 GAL		15-A	160
3	B. 13LG 52% PRESET #6 135 GAL		20-A	135
15	17 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
15	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
15	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
15	3FR10 (N-27-D/WATER) RATIO 1.35			
15	3FC10 (N-32-D CONTROLLER) IN MANUAL 0.49 GPM		32-D	1376
15	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
15	3FC20 (N-32-D WATER) IN REMOTE			
15	3FR10 (N-32-D/WATER) RATIO 1.82			

#2 Pass 1st Pass
#2 11 2nd Pass

263

FN

1/2

V-243

16 OPERATOR STEP PB
 320 17 RECORD LEVEL 2LG 86% 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 10.5. ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 20 SIPHON INTO SV. RECORD: PH 11.2. ASSUME 50% 20 7-D 10
 20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP. RECORD: PH 10.1.
 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: 135A
 SP STEP

V-243/V-244

PH	RANGE	TIME
13/46 (30 MIN)	9.9 9.0-10.0	205A
14/47 (60 MIN)	9.8 9.0-10.0	2:35A
15/48 (2 HRS)	9.7 9.0-10.0	3:35A
16/49 (3 HRS)	9.7 9.0-10.0	4:35A
16/49 (4 HRS)	9.6 9.0-10.0	5:35A
17/50 (FINISH)	9.4 7.5-8.5	6:20A

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

29 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 29 ADD IN 7-8 MIN 350 530-A 350
 339 30 ADD TO 49" (382 G) AT 80-100°F
 6 31 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
 32 STIR 15 MIN OR LONGER FOR SP STEP 26
 33 RECORD: VOL 49 " & CALC 49 " X 0.78 = 38.2 GAL
 34 SET PRESET #8 TO 38.2 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 9.7 (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 9.1 (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 9.1 & TIME 7:20/AM
 44 OPERATOR STEP PB
 45 SP STEP 60. BATCH COMPLETE.

PUMP TO V-240

START
TIME SP STEPFINISH
TIME SP STEP

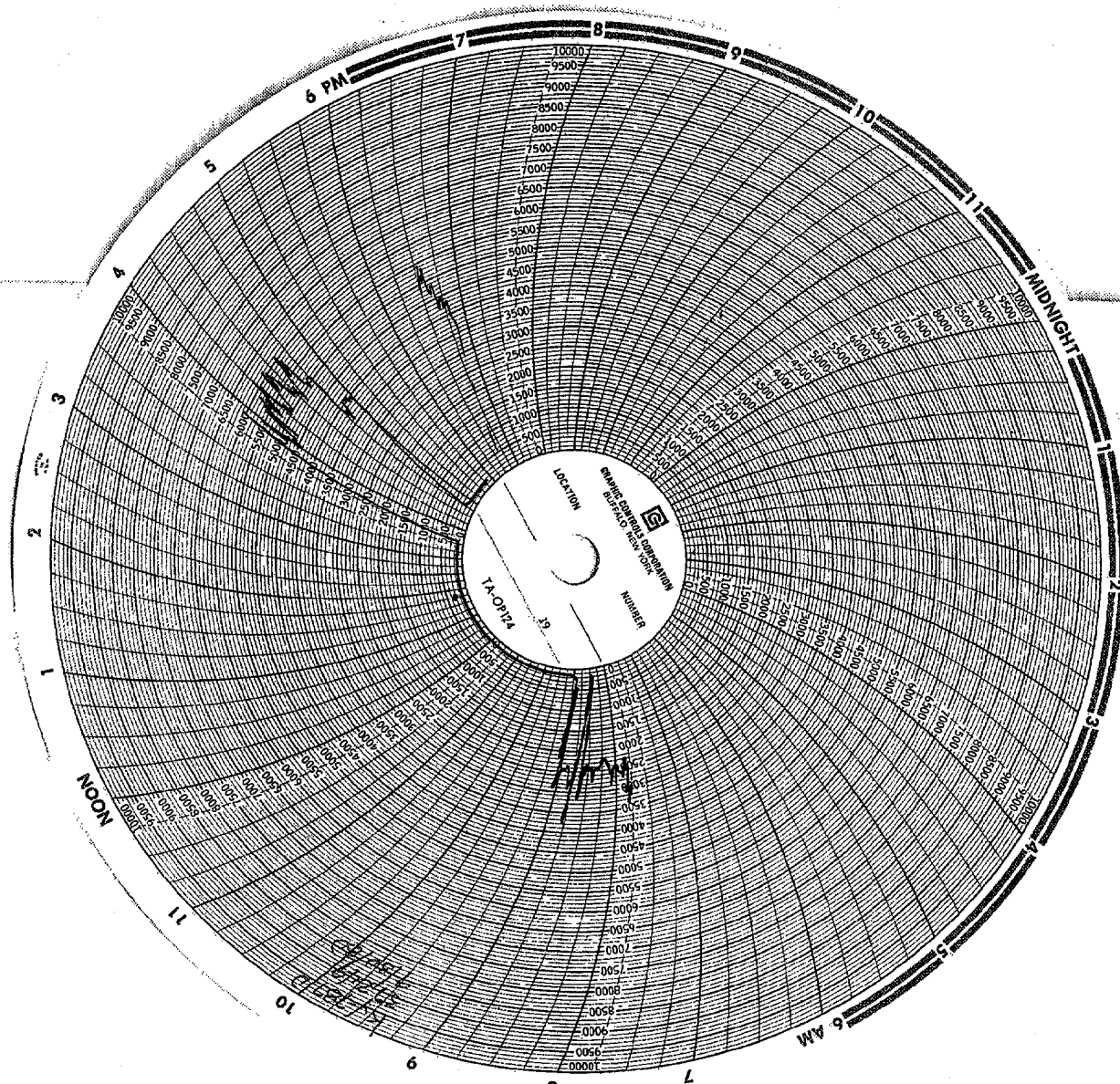
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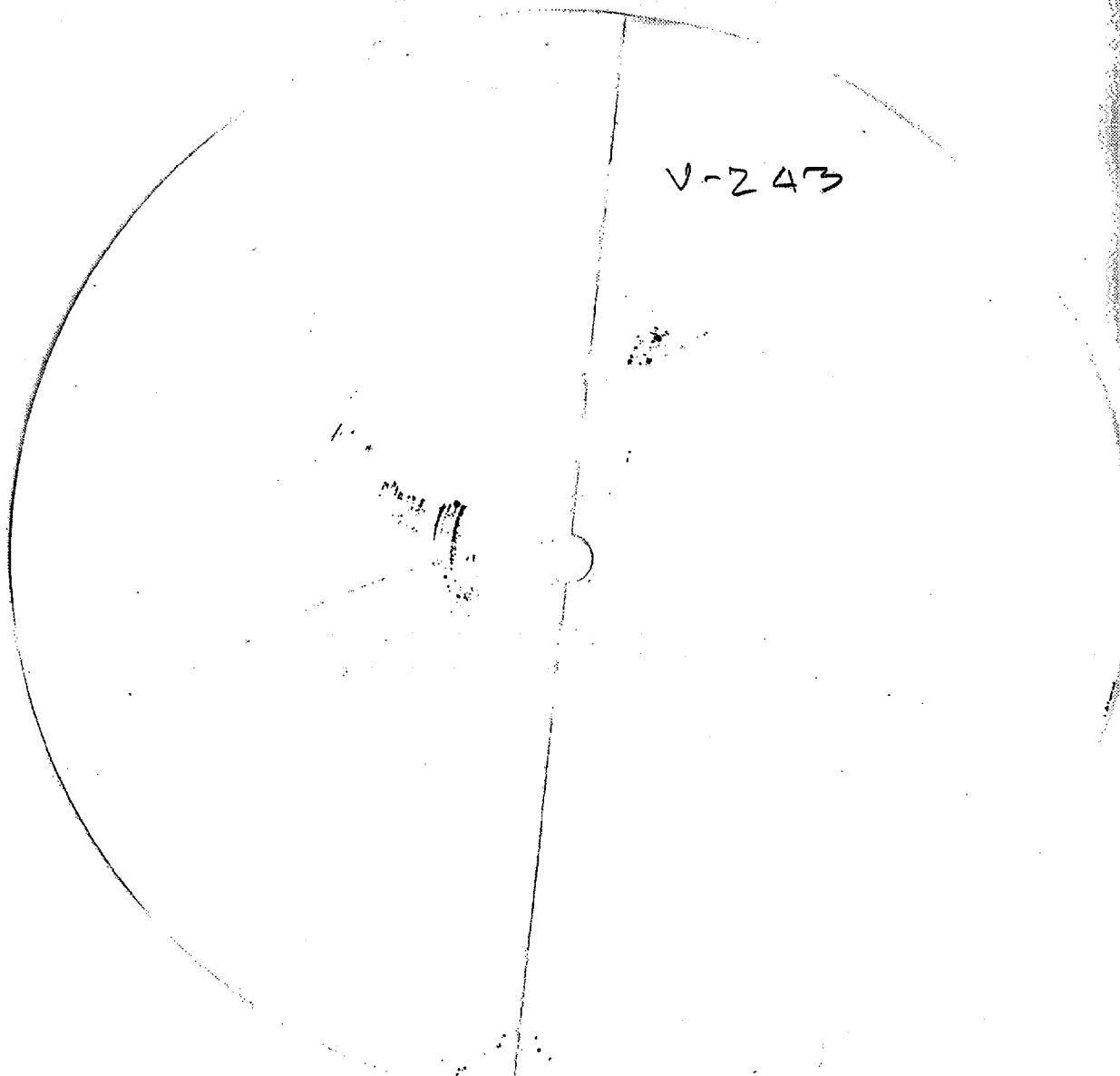
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3:00PM3:00PM
11:00PM330
34239

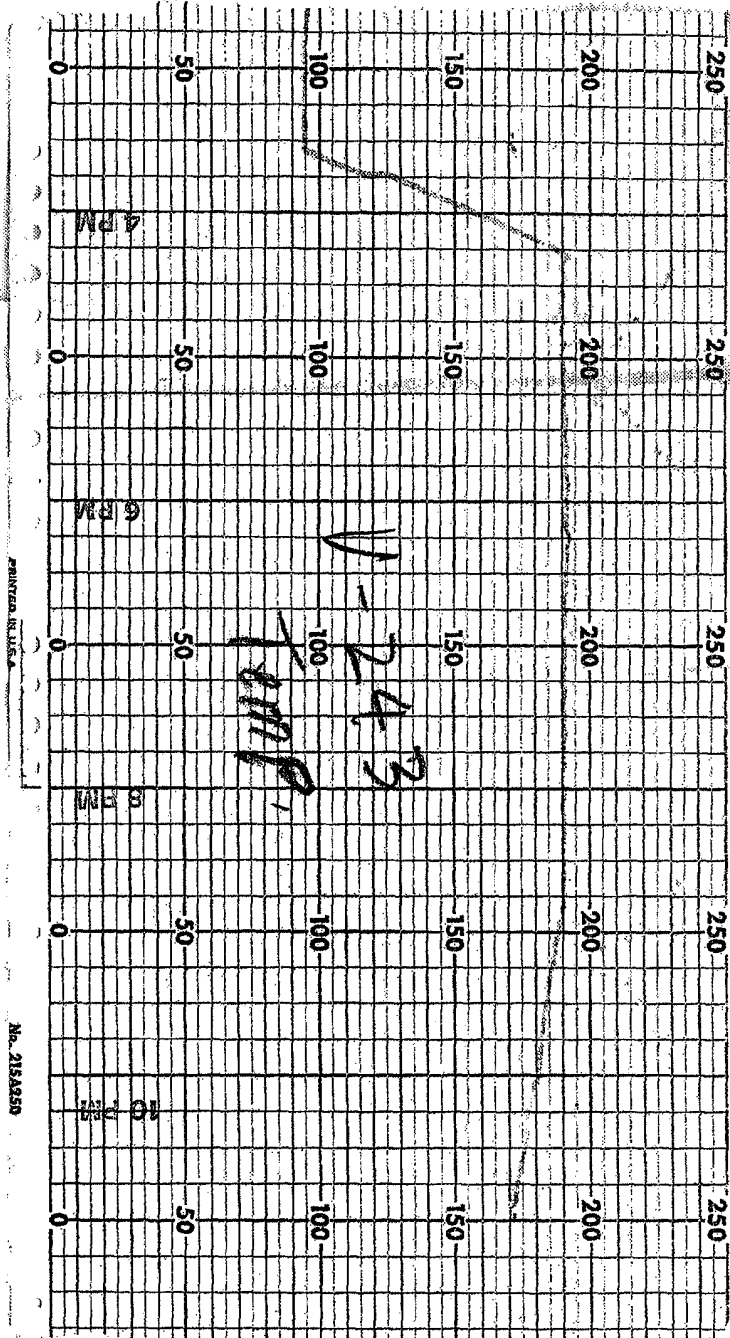
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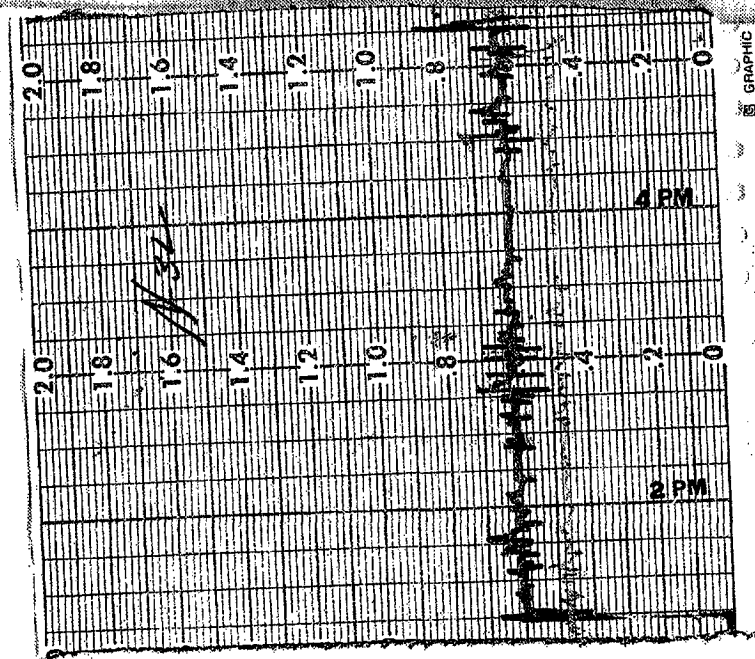
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235



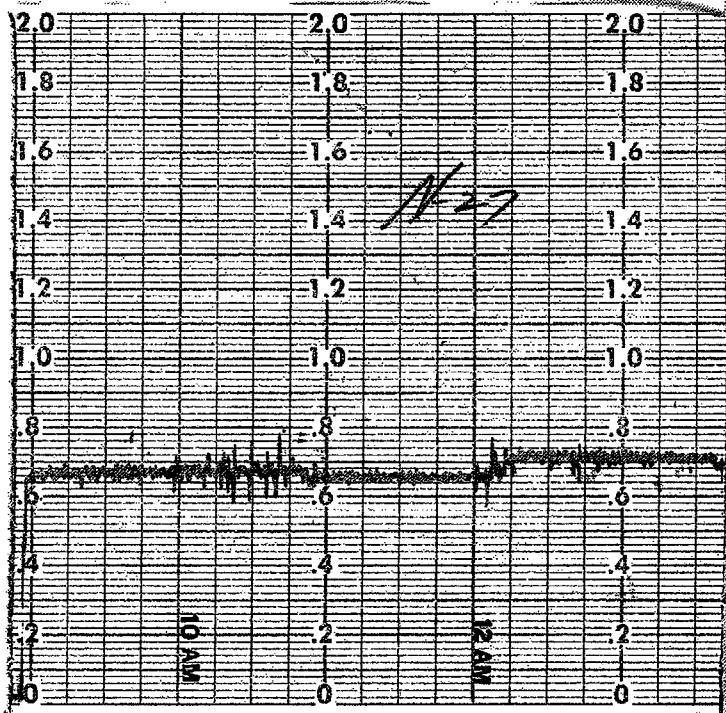






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