

(AUTOMATED)
S.V. 243

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-787-D 5K5
LOT 36132 JUN 19 1980

PROCESSES APPROVED BY
() KY-787-D (Q) FWP 5/20/80

EST'D WGT 1090 LBS

STANDARD HRS. 8.9 TIME 3P M

TYPED BY: FP 5/20/80

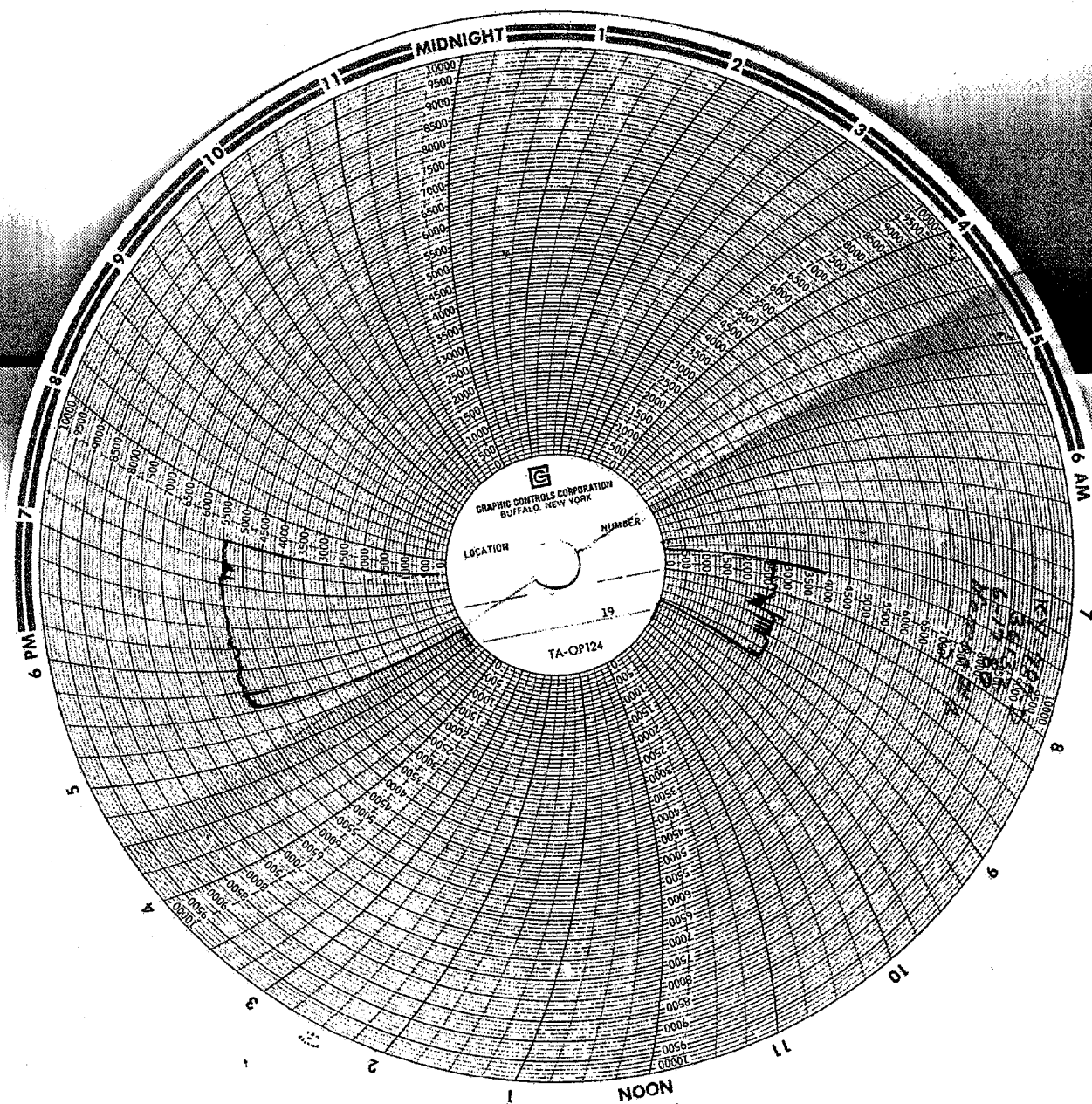
COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	22204	93	2400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 3490

Homog #4 - 1st Pass
" #3 - 2nd " NON-BLEEDING

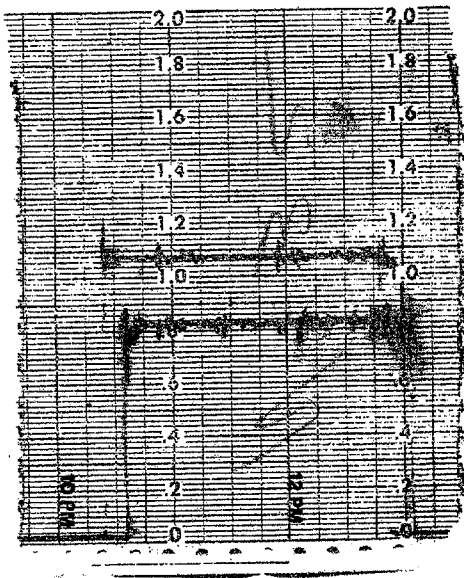
EQUIP	NAME	USE LBS	N- CODE	ACC LBS
203	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
203	WEIGH IN DRUM & POUR IN	320	32-D	320
1	DUMP IN AND STIR 5 MIN RECORD: START 12:00 A. 22204 FIN 1:50 PM	48X50 2400	YC-2-B	2400
203	ADJUST TO 75" (1275 G)			
203	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
203	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
203	RECORD: V-205 VOL 4.5" & ADJ TO 60" (2100 G)			
203	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
SV	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
2	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 5:30 PM TOTAL MINUTES 120			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
12	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
3	REMOTE (TEMP IS SET AT 190-194°F)			
14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS: A. 11LG 49% PRESET #1 80 GAL 15-A 160 B. 13LG 50% PRESET #6 135 GAL 20-A 135			
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3PC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM 27-D 275 3PC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM 3ER10 (N-27-D/WATER) RATIO 0.64 BEC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM 32-D 1846 BEC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM BPC20 (N-32-D WATER) IN REMOTE BPR10 (N-32-D/WATER) RATIO 0.83			

EQUIP	PAGE	CG 03	KY-757-D	EST WGT 3490#	USE LBS	N- CODE	USE LBS																		
V.243																									
320	16	OPERATOR STEP PB																							
SV	17	RECORD LEVEL 2LG 15% IF BELOW 35% FOLLOW SOL'N																							
SP	18	MAKE-UP PROCEDURE FOR N-27-D																							
CP	19	ADJUST SV TO 48" (2470 G)																							
	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	20	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%			25	7-D	7																		
	20	OPERATOR STEP PB																							
SV	24	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0																							
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO																							
	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																							
		13/46 (30 MIN)	PH 9.5	RANGE 9.0-10.0	TIME 10:30 PM																				
		14/47 (60 MIN)	9.8	9.0-10.0	10:50 PM																				
		15/48 (2 HRS)	9.8	9.0-10.0	11:50 PM																				
		16/49 (2 HRS, 25 MIN)	9.8	9.0-10.0	12:15 AM																				
		17/50 (FINAL 3 HRS)	6.2	7.5-8.5	12:50 AM																				
		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	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339																							
129	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)																							
132	32	STIR 15 MIN OR LONGER FOR SP STEP 26			38.2																				
133	33	RECORD: VOL 49" & CALC 49" X 0.78 = --- GAL																							
134	34	SET PRESET #8 TO 38.2 FROM S 33																							
302	35	RUN 30" (360 G) WATER INTO V-302																							
7	36	ADD & STIR 2 MIN FOR S 40			160	7-D	80																		
137	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.																							
138	38	STIR IN			100	128-A	100																		
SV	39	SP STEP 23/53. RECORD: PH 4.0 (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 9.2 (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	42	OPERATOR STEP PB																							
143	43	SP STEP 29/58. RECORD: PH 9.2 & TIME ---																							
144	44	OPERATOR STEP PB																							
145	45	SP STEP 60. BATCH COMPLETE.																							
<table border="0"> <tr> <td>START</td> <td>FINISH</td> <td>OPTR</td> </tr> <tr> <td>TIME SP STEP</td> <td>TIME SP STEP</td> <td></td> </tr> <tr> <td>2:00 PM</td> <td>7:00 PM</td> <td>120</td> </tr> <tr> <td>3:00 PM</td> <td>7:00 PM</td> <td>235-B7</td> </tr> <tr> <td>11:00 PM</td> <td>2:10 PM</td> <td>391-252</td> </tr> <tr> <td></td> <td></td> <td>301-27</td> </tr> </table>								START	FINISH	OPTR	TIME SP STEP	TIME SP STEP		2:00 PM	7:00 PM	120	3:00 PM	7:00 PM	235-B7	11:00 PM	2:10 PM	391-252			301-27
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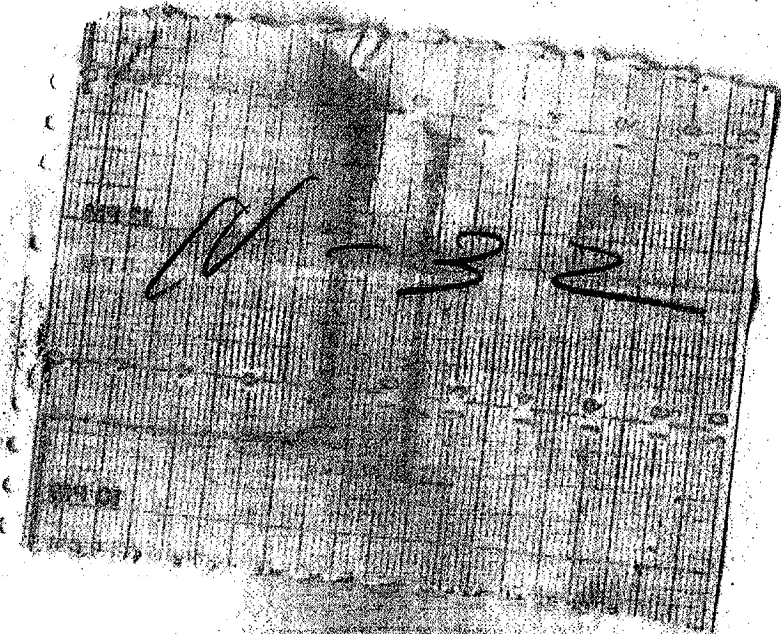
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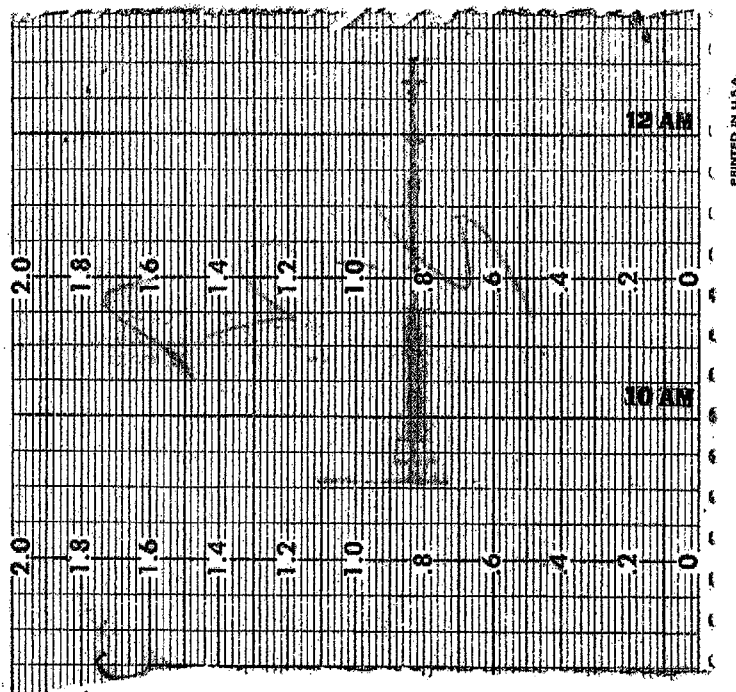
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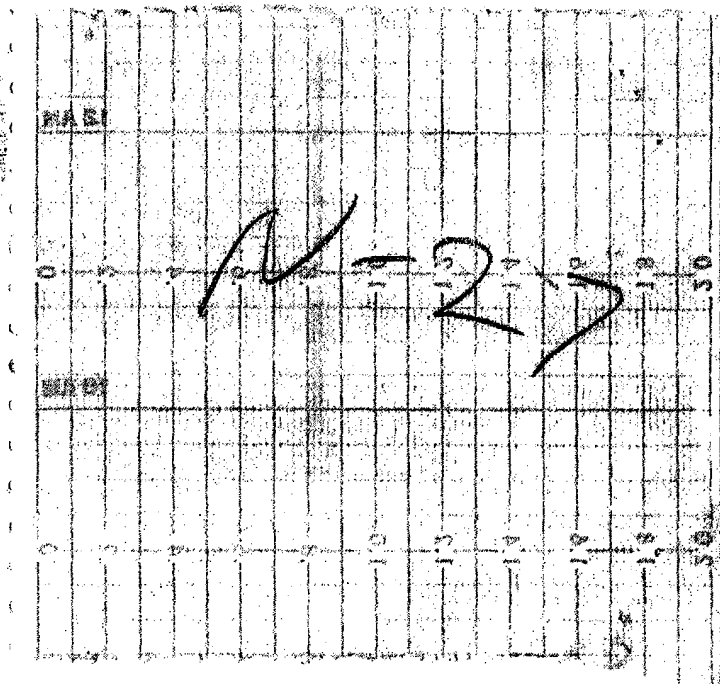


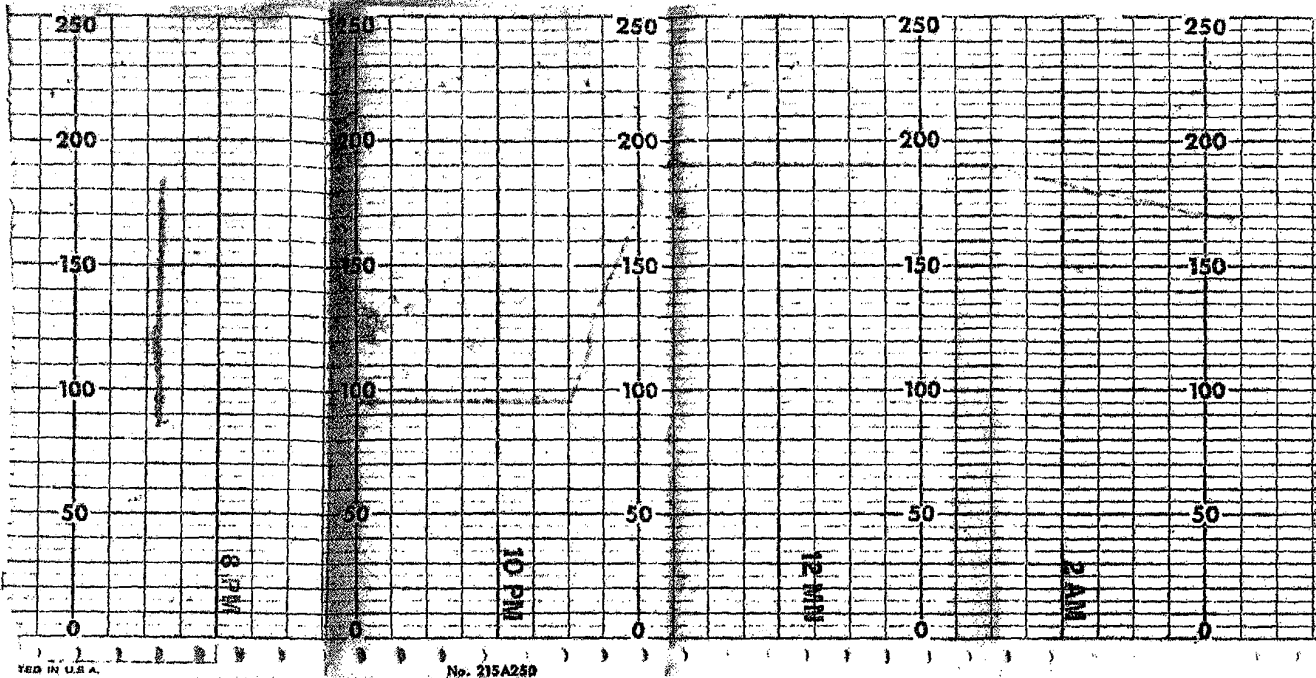
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