

S.V. 243 244

C.V.

D.V.

CG 03 CODE KY-787-D PKG

LOT DATE DEC 23 80 38378

PROCESSES

APPROVED BY

EST'D WGT '932

LBS

STANDARD HRS. 8.9

() KY-787-D (Q) FWP 12/04/80

() XOB-17: 25% LESS SILICA &

() A 240 MIN STRIKE

COMTYP JOB NAME: XOB17:787Q

COMPONENT CONSUMPTION

CG	CODE	LOT	PR	LBS	CG	CODE	LOT	PR	LBS
14	YC002B	13478	93	2000	14	YC002B		93	
14	YC002B	13179	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

DEC 29 1980

Homog #3 - 1st Pass
#4 - 2nd Pass

TOTAL EST'D WGT 3332

NON-BLEEDING

EQUIP	NAME	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	245	983-D	245
V-263	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 7:01 PM	2000		
	FIN 9:00 PM	400		
4	ADJUST TO 75" (1275 G)			
5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 263			
6	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205 263			
V-263	7 RECORD: V-205 VOL 263" & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	9 RUN 10" (514 G) WATER INTO V-243 START			
V-263	AGITATOR			
SV	140 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 9:20 TOTAL MINUTES 120			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
141	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP			
1	THRU HOMOG AT 4800-5200 PSI INTO SV			

SP 112 SP STEP 01 - SET FORMULA SELECTOR TO POSITION

& 2 (V-243) OR POSITION 7 (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 78% PRESET #1 80 GAL

B. 13LG 69% PRESET #6 135 GAL

115 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:

3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM

3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM

3FR10 (N-27-D/WATER) RATIO 1.35

3FC10 (N-32-D CONTROLLER) IN MANUAL 0.50 GPM

3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.55 GPM

3FR10 (N-32-D WATER) IN REMOTE

3FR10 (N-32-D/WATER) RATIO 1.82

15-A 160

20-A 135

27-D 206

983-D 1405

N34792

V-243

LBS CODE LBS

320 ~~118~~ OPERATOR STEP PB
 SV ~~119~~ RECORD LEVEL 2LG **75%** IF BELOW 35% FOLLOW SOL'N
 SP ~~120~~ MAKE-UP PROCEDURE FOR N-27-D
 CP ~~121~~ ADJUST SV TO 48" (2470 G)
 4 ~~122~~ RECORD PH **9.9** ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 120 ~~123~~ SIPHON INTO SV. RECORD: PH **11.2** ASSUME 50% **30** 7-D **15**
 OPERATOR STEP PB

SV ~~124~~ SP STEP 06/39. AFTER HEAT-UP RECORD: PH **9.7**
 SP ~~125~~ SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 SP ~~126~~ OPERATOR STEP PB
 5 ~~127~~ SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
 OPERATOR STEP PB
 DURING STRIKE RECORD:

2:20/pm

SP STEP
 V-243/V-244

PH	RANGE	TIME
9.5	9.0-10.0	2:50
9.5	9.0-10.0	3:20
9.5	9.0-10.0	4:20
9.4	9.0-10.0	5:20
9.2	9.0-10.0	6:20
7.2	7.5-8.5	7:05

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
 133 RECORD: VOL **49** & CALC **49** X 0.78 = **38.2** GAL
 134 SET PRESET #8 TO **38.2** GAL FROM S 33

302 135 RUN 30" (360 G) WATER INTO V-302
 7 136 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 160 7-D 80

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 138 SIFT IN 100 128-A 100
 SV 139 SP STEP 23/53. RECORD: PH **3.8** (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 **9.5** (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)
 142 OPERATOR STEP PB
 143 SP STEP 29/58. RECORD: PH ____ & TIME ____
 144 OPERATOR STEP PB
 145 SP STEP 60. BATCH COMPLETE.

Run to 240

START TIME SP STEP	FINISH TIME SP STEP	OPTR
7:00 2:00 3pm	7:00 3:00 7:45	120 235 282