

CG 03
LOT

CODE KT-795-D PKG

OCT-21-80 37517

STANDARD HRS. 8.2

TIME 3P M

PROCESSED () KY-795-D (H) FWP 10/14/80
() (XOB-17: 3/4
() N-32-D & 240
() MIN STRIKE)
()

TYPED BY: FWP 10/14/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	13178	93	2000
14	YC002B	13182	93	1500
14	YC002B		93	

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

2ND PASS - #4

TOTAL EST'D WGT 4380

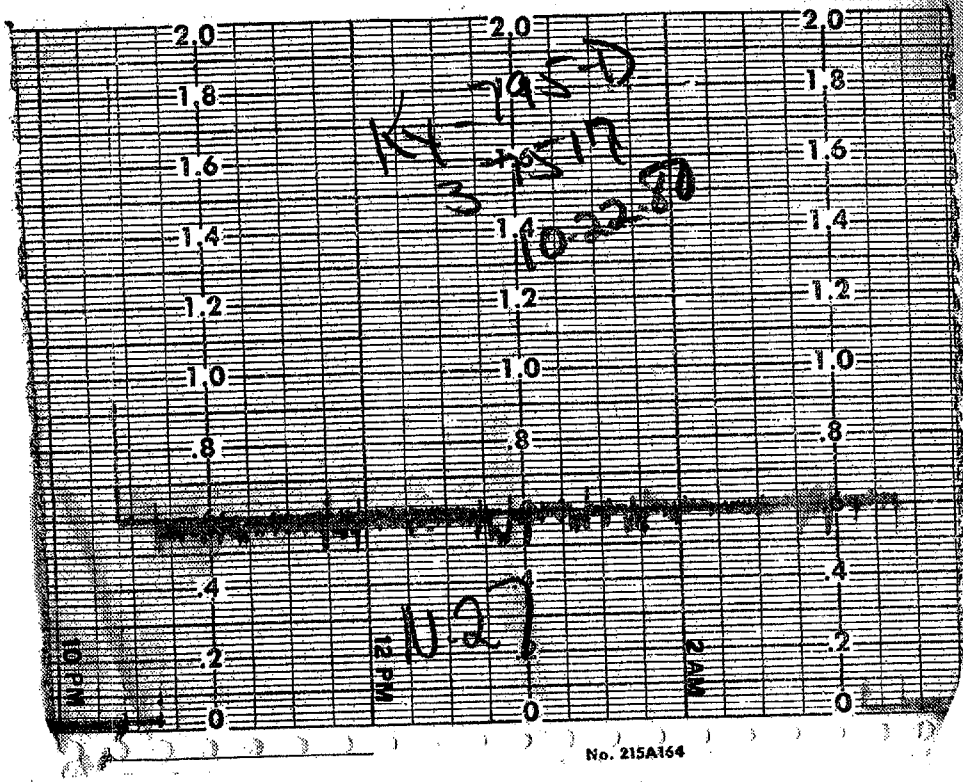
NON-BLEEDING

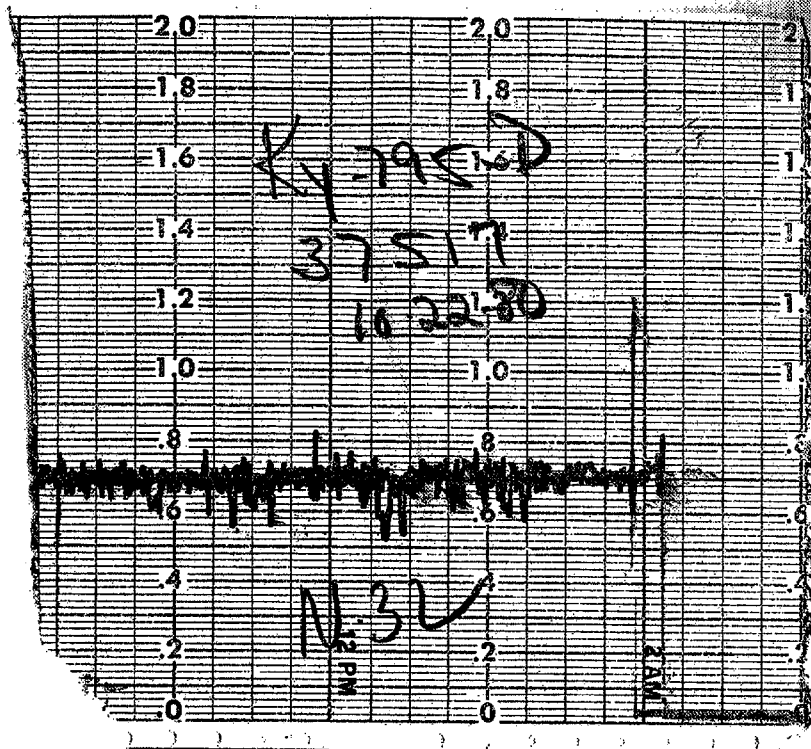
LEAVE ONE STUMP ONLY

EQUIP	NAME : "KROLOR" YELLOW MEDIUM	USE LBS	N- CODE	ACCT LBS
203 & 205	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	WEIGH IN DRUM & POUR IN	475	32-D	475
	DUMP IN AND STIR 5 MIN.	70X50	YC-2-B	3500
	RECORD: START 12:00 PM 13178 2000			
	FIN 1:10 AM 13182 1500			
205	ADJUST TO 75" (1275 G)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	WHEN V-203 MT, WASH COLDR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL 44" & ADJ TO 60" (2100 G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 7:40 AM TOTAL MINUTES 160			
2	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			
SP & CR	SET STEP 04 - SET FORMULA SELECTOR TO POSITION 5 (V-243) OR POSITION 10 (V-244)			
	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 62% PRESET #1 104 GAL		15-A	208
15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3PC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM		27-D	296
	3PC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.04			
	8PC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM		32-D	1885
	8PC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.59			

N35028

EQUIP	PAGE 2	CG 03	KY-795-D	EST WGT 43804	USE LBS	N- CODE	USE LBS
V-243							
116	OPERATOR STEP PB						
SV 117	RECORD LEVEL 2LG 62% IF (35% FOLLOW SOLUTION						
SP 118	MAKE-UP PROCEDURE FOR N-27-D						
CP 119	ADJUST SV TO 58" (2980 G)						
4	RECORD PH 10.4 ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)						
20	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	20	72-D	30			
21	OPERATOR STEP PB						
SV 22	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0						
SP 23	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO						
24	OPERATOR STEP PB						
25	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB						
5	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)	9.75	9.0-10.0	1:40			
	14/47 (60 MIN)	9.75	9.0-10.0	2:10			
	15/48 (2 HRS)	9.75	9.0-10.0	3:10			
	16/49 (3 HRS)	9.5	9.0-10.0	4:10			
	16/49 (4 HRS)	9.5	9.0-10.0	5:10			
	17/50 (FINISH)	8.3	7.5-8.5	5:55			
	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%					
6	FILL WITH WATER & STIR 2 MIN	FLAKE	20	72-D	28		
30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.						
SV 31	SP STEP 23/53 - RECORD: PH 4.2 (3.3-3.7)						
SP 32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7						
&	RECORD: PH 3.6	140	15-A	140			
CP 7	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140						
	WF IN DRUM. USE 30 GAL WATER TO 50# N-15-A.						
	STIR 5 MIN AFTER EACH ADDITION.						
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						
40	OPERATOR STEP PB						
	START TIME SP STEP	FINISH TIME SP STEP	OPTR				
	2:00P	3:00P	235-244				
	5:00P	7:15P	201-381				
Pump To VAT 240							





No. 215A164

V-243