

LOT 100-21 30 37938

EST'D WGT 932 LBS

STANDARD HRS. 8.9 TIME 7A M

() KY-787-D (Q) FWP 11/3/80
() (XOB-17: 25%
() () LESS N-32-D
() & 240 MIN
() () STRIKE)

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13189	93	2000	14	YC002B		93	
14	YC002B	13191	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

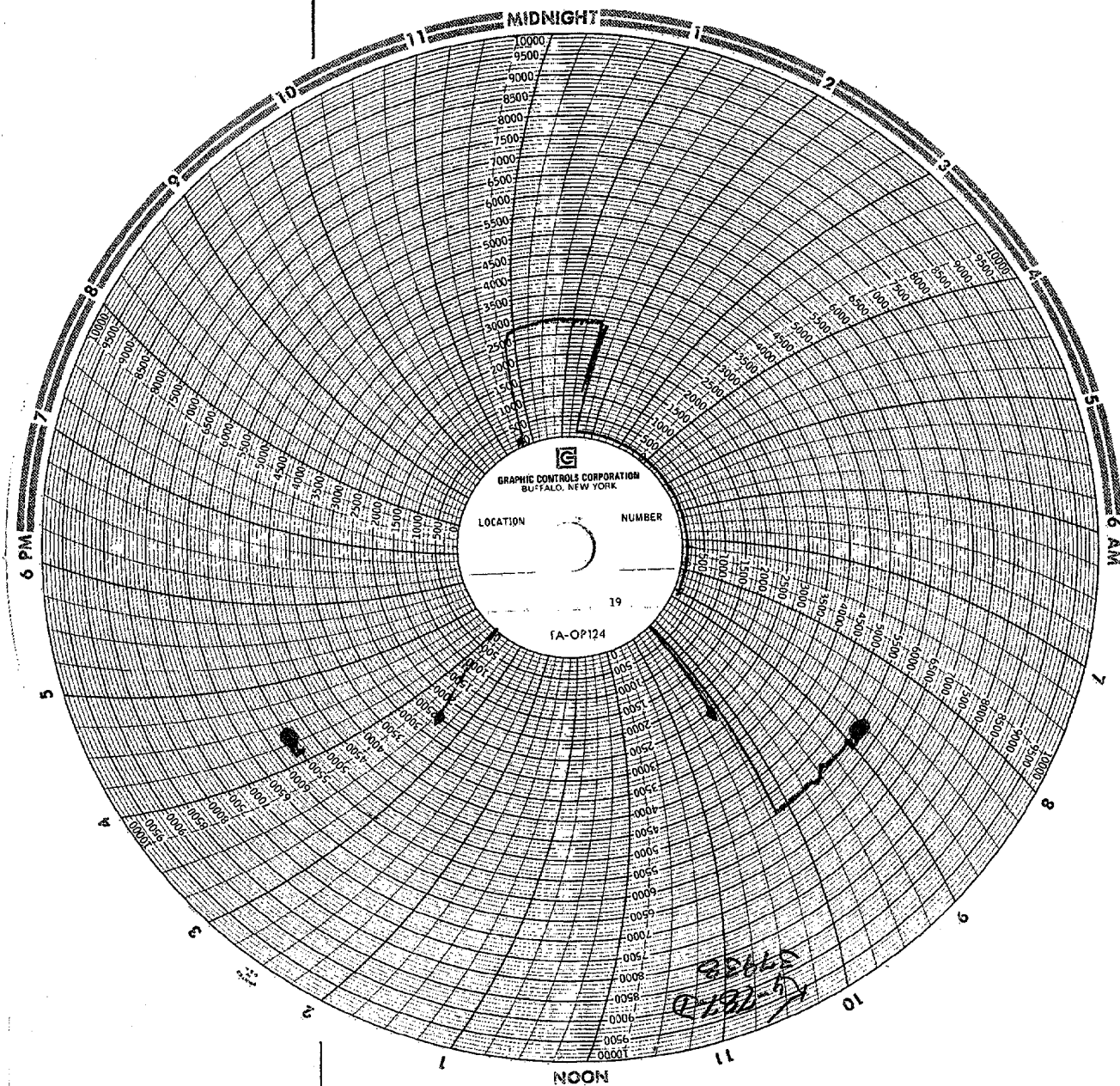
TOTAL EST'D WGT 3332

Use Flare
caution

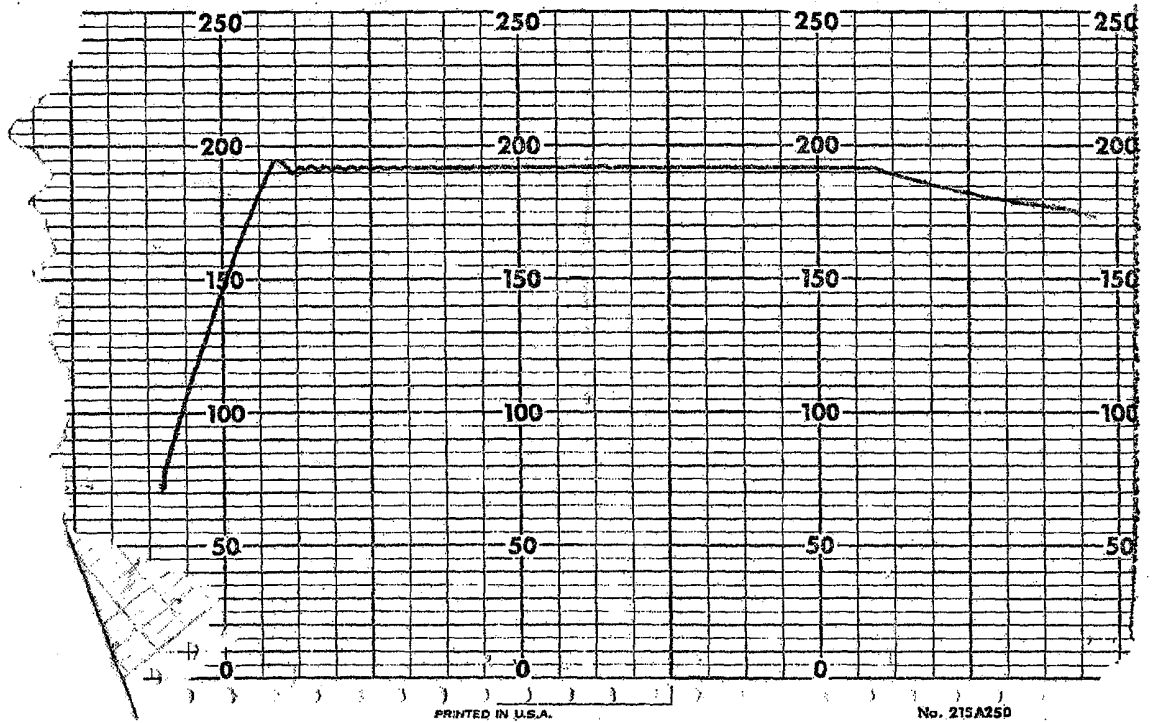
NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	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	240	983-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-E	2400
	RECORD: START 4:00 LOT 13129-2000			
	FIN 4:30 13191-400			
1	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 4" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V- & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START TOTAL MINUTES			
2	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 & CP	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
	13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 7.8% PRESET #1 80 GAL		15-A	160
	B. 13LG 7.2% PRESET #6 135 GAL		20-A	135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
	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 0.49 GPM		983-D	1376
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	3FR10 (N-32-D/WATER) IN REMOTE 1.82			

					LBS	CODE	LBS
	16	OPERATOR STEP PB	50				
320	17	RECORD LEVEL 2LG ____% IF BELOW 35% FOLLOW SOL'N					
SV		MAKE-UP PROCEDURE FOR N-27-D					
SP	18	ADJUST SV TO 48" (2470 G)					
CP	119	RECORD PH <u>10.8</u> ADJ TO 11.1-11.3 WITH N-7-D AT					
		5% (10 PARTS WATER TO 1 PART N-7-D)					
4		SIPHON INTO SV. RECORD: PH <u>11.2</u> ASSUME 50%			8	7-D	8
	120	OPERATOR STEP PB					
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>10.7</u>					
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:					
		SP STEP					
		V-243/V-244	PH	RANGE	TIME		
		13/46 (30 MIN)	<u>10.0</u>	9.0-10.0	<u>12:20</u>		
		14/47 (60 MIN)	<u>10.09</u>	9.0-10.0	<u>12:50</u>		
		15/48 (2 HRS)	<u>9.75</u>	9.0-10.0	<u>1:50</u>		
		16/49 (3 HRS)	<u>9.75</u>	9.0-10.0	<u>2:50</u>		
		16/49 (4 HRS)	<u>9.5</u>	9.0-10.0	<u>3:50</u>		
		17/50 (FINISH)	<u>8.4</u>	7.5-8.5	<u>4:35</u>		
		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	
	28	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339					
	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 <u>9.8</u> (9.5-10.5)					
	32	STIR 15 MIN OR LONGER FOR SP STEP 26					
	33	RECORD: VOL <u>51</u> " & CALC <u>51</u> " X 0.78 = <u>39.8</u> GAL					
	34	SET PRESET #8 TO <u>39.8</u> 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 <u>3.7</u> (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 <u>9.5</u> (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 <u>9.5</u> & TIME <u>6:00 PM</u>					
	44	OPERATOR STEP PB					
	45	SP STEP 60. BATCH COMPLETE.					
		START	FINISH	OPTR			
		TIME SP STEP	TIME SP STEP				
		<u>7:00 PM</u>	<u>3</u>				
		<u>3:00 PM</u>	<u>6:00 PM</u>		<u>120.720</u>		
					<u>277.320</u>		



200



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