

CG 03 CODE KY-788-D PKG

LOT MAY -0-81-1055

EST'D WGT 960 LBS

STANDARD HRS. 8.8 TIME M

PROCESSES

APPROVED BY

() KY-788-D (J) FWP 01/16/B1
 () () 4 HOUR STRIKE
 () () AS FOR XOB-17
 () ()
 () ()

JOB NAME: XOB17:788J

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC003B	14030	93	2600	14	YC003B		93	
14	YC003B		93		14	YC003B		93	
14	YC003B		93		14	YC003B		93	

03 125 781-D 82946-1 98

50

52

TOTAL EST'D WGT 3560 360

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-LIGHT	USE LBS	N- CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN.	345	32-D	345
1	3 DUMP IN AND STIR 5-MIN. RECORD: START 12:25 PM FIN 1 PM	52X50	YC-3-B	2600
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205	2,600		
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205	50		
	7 RECORD: V-205 VOL 42" & ADJ TO 60" (2100 G)	650		
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-244 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 12:25 TOTAL MINUTES 200			
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 13 (V-243) OR POSITION B (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 30% PRESET #2 208 GAL B. 13LG 40% PRESET #6 135 GAL		15-A 20-A	416 135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.34 GPM 3FC20 (N-27-D WATER) IN MANUAL LOCAL 2.8 GPM 3FR10 (N-27-D/WATER) RATIO 0.8 3FC10 (N-32-D CONTROLLER) IN MANUAL 0.44 GPM 3FC20 (N-32-D WATER) IN MANUAL LOCAL 2.4 GPM 3FC20 (N-32-D WATER) IN REMOTE 3FR10 (N-32-D/WATER) RATIO 1.1		27-D 32-D	180 1215

HOMOG #4 - 1ST PASS

V-244

320 116 OPERATOR STEP PB
SV 117 RECORD LEVEL 2LG 88 % IF <35% FOLLOW SOLUTION
SP 118 MAKE-UP PROCEDURE FOR N-27-D
CP 119 ADJUST SV TO 47" (2400 G)
120 RECORD PH 9.8. ADJ TO 11.0-11.2 WITH N-7-D AT
5% (10 PARTS WATER TO 1 PART N-7-D)
4 121 SIPHON INTO SV. RECORD: PH 11.1. ASSUME 50% 40 7-D 20
122 OPERATOR STEP PB

123 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.0
SV 124 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 125 OPERATOR STEP PB 5.10 A
126 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 127 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
128 OPERATOR STEP PB
129 DURING STRIKE RECORD:
SP STEP

V-243/V-244

13/46 (30 MIN)

14/47 (60 MIN)

15/48 (2 HRS)

16/49 (3 HRS)

16/49 (4 HRS)

17/50 (FINISH)

PH	RANGE	TIME
<u>9.7</u>	9.3-10.0	<u>5:40</u>
<u>9.6</u>	9.3-10.0	<u>6:10</u>
<u>9.4</u>	9.3-10.0	<u>7:10</u>
<u>9.3</u>	9.3-10.0	<u>8:10</u>
<u>9.2</u>	9.3-10.0	<u>9:10</u>
<u>6.8</u>	7.5-8.5	<u>9:55</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

130 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
131 ADD IN 7-8 MIN 350 530-A 350
339 132 ADJ TO 49" (382 G) AT 80-100%F
6 133 STIR 5 MIN & RECORD: PH 10.0 (9.5-10.5)
134 STIR 15 MIN OR LONGER FOR SP STEP 26/56
135 RECORD: VOL 49 " & CALC 49 " X 0.78 = 38.2 GAL
136 SET PRESET #8 TO 38.2 GAL FROM S 33

302 137 RUN 40" (440 G) WATER INTO V-302
7 138 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 360 7-D 180

139 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
140 SIFT IN 100 128-A 100
SV 141 SP STEP 23/53. RECORD: PH 3.2 (3.7-4.2)
SP 142 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
MIN
8 143 RECORD: PH 9.4 (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)
144 OPERATOR STEP PB
145 SP STEP 29. RECORD: PH 9.8 & TIME 10:58 AM
146 OPERATOR STEP PB
147 SP STEP 60. BATCH COMPLETE.

START
TIME SP STEP

7:00 PM

12:25 A

7:00 AM

FINISH
TIME SP STEP

11:00 PM

7:00 A

11:00 AM

OPTR

381-201

126-259

144