

CG 02 CODE KY-787-D PKG

LOT DATE DEC 16 80 38281

TIME

EST'D WGT 932 LBS

STANDARD HRS. 8.9

PROCESSES APPROVED BY

() 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	PQ	LBS
14	YC002B	13410	93	1750
14	YC002B	13411	93	650
14	YC002B		93	

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

TOTAL EST'D WGT 3332

DEC 18 1980

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
203	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	245	983-D	245
	RECORD: START 4:00 PM LOT 13410 1750	48X50	YC-2-B	2400
	FIN 4:55 PM 13411 650			
V.263	ADJUST TO 75" (1275 G)			
5	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 V.263			
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 58" & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-205 START AGITATOR			
SV	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 12:00 PM TOTAL MINUTES 90			
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	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 16% PRESET #1 80 GAL 15-A 160			
	B. 13LG 12% 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			
	2FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	2FR10 (N-27-D/WATER) RATIO 1.35			
	3EC10 (N-32-D CONTROLLER) IN MANUAL 0.50 GPM 983-D 1405			
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.55 GPM			
	3FE20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.82			

V 243

16	OPERATOR STEP PB			
320	147	RECORD LEVEL 2LG <u>88%</u> IF BELOW 35% FOLLOW SOL'N		
SV		MAKE-UP PROCEDURE FOR N-27-D		
SP	118	ADJUST SV TO 48" (2470 G)		
CP	119	RECORD PH <u>11.1</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 ____ ASSUME 50%	36	7-D 18
	120	OPERATOR STEP PB		

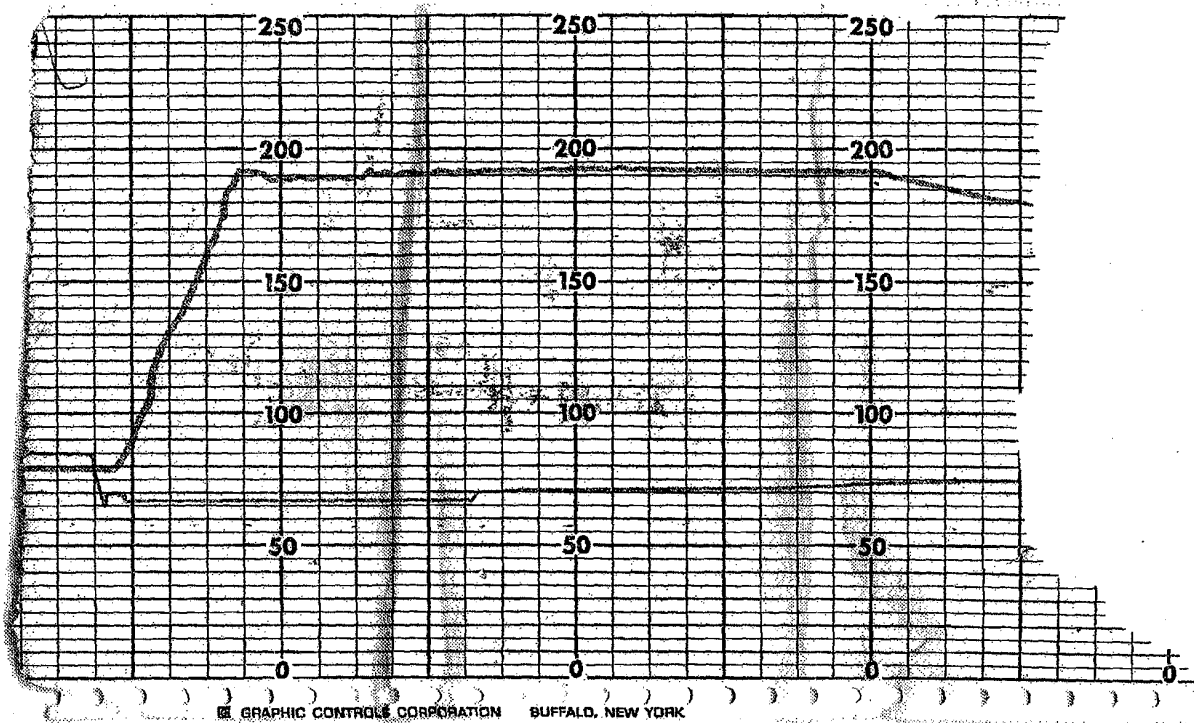
SV	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH <u>9.6</u>		
SP	122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO		
	123	OPERATOR STEP PB		
	124	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS		
		ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB		
5	125	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN		
		LIMITS, SWITCH 3FC20 TO REMOTE		
	126	OPERATOR STEP PB		
	127	DURING STRIKE RECORD: <u>3 35P</u>		
		SP STEP		
		V-243/V-244		
		13/46 (30 MIN)	PH <u>9.1</u> RANGE 9.0-10.0 TIME <u>4:05P</u>	
		14/47 (60 MIN)	<u>9.1</u> 9.0-10.0 <u>4:35P</u>	
		15/48 (2 HRS)	<u>9.2</u> 9.0-10.0 <u>5:35P</u>	
		16/49 (3 HRS)	<u>9.2</u> 9.0-10.0 <u>6:35P</u>	
		16/49 (4 HRS)	<u>9.3</u> 9.0-10.0 <u>7:35P</u>	
		17/50 (FINISH)	<u>7.6</u> 7.5-8.5 <u>8:20P</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

	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 <u>10.2</u> (9.5-10.5)		
	132	STIR 15 MIN OR LONGER FOR SP STEP 26		
	133	RECORD: VOL <u>49</u> & CALC <u>49</u> X 0.78 = <u>38.2</u> GAL		
	134	SET PRESET #8 TO <u>38.2</u> 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 <u>9.4</u> (3.7-4.2)		
SP	140	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5		
		MIN <u>9.4</u>		
8	141	RECORD: PH ____ (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 <u>9.35</u> & TIME ____		
	144	OPERATOR STEP PB		
	145	SP STEP 60. BATCH COMPLETE. <u>PUMPED TO V240</u>		

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>6:20</u> _____	<u>11:00</u> _____	<u>301-126</u>
<u>3:00P</u> _____	<u>9:30</u> _____	<u>120-209</u>
_____	_____	_____



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