

CG 63
LOT DEC-9 80 38149

2000

OK
FP

PROCESSES
() KY-795-D (H) FWP 11/20/80
() (XOB-17: 3/4
() 315 () N-32-D & 240
() () MIN STRIKE)
() ()

STANDARD HRS. 8.2 TIME _____ M

JOB NAME: XOB17:795H

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13191	93	2000	14	YC002B	_____	93	_____
14	YC002B	13185	93	180	14	YC002B	_____	93	_____
14	YC002B	13197	93	500	14	YC002B	_____	93	_____
		13176		900					

**CLEAN UP
AS YOU GO ALONG**

TOTAL EST'D WGT 4380

NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACET LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	485	983-D	485
	3 DUMP IN AND STIR 5 MIN	70X50	YC-2-B	3500
	RECORD: START <u>12:45 AM</u> LOT <u>13191</u>			
	FIN <u>1:30 AM</u> <u>13185</u>			
	ADJUST TO 75" (1275 G) <u>13176</u>			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL <u>48</u> " & ADJ TO 60" (2100 G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-243 & START			
	AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <u>9:30 AM</u> TOTAL MINUTES <u>180</u>			
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	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
	5 (V-243) OR POSITION 10 (V-244)			
CP	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 <u>48</u> % 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			
	3PR10 (N-27-D/WATER) RATIO 1.04			
	BFC10 (N-32-D CONTROLLER) IN MANUAL 0.69 GPM		983-D	1925
	BFC20 (N-32-D WATER) IN MANUAL LOCAL 5.5 GPM			
	BFC20 (N-32-D WATER) IN REMOTE			
	BER10 (N-32-D/WATER) RATIO 1.39			

N34814

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V-243

SV	16	OPERATOR STEP PB				
SP	17	RECORD LEVEL 2LG 50% IF <35% FOLLOW SOLUTION				
CP	18	MAKE-UP PROCEDURE FOR N-27-D				
	19	ADJUST SV TO 48" (2980 G)				
	20	RECORD PH 10.5. ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)				
4	21	SIPHON INTO SV. RECORD: PH 11.1. ASSUME 50%	36	7-D	18	
	22	OPERATOR STEP PB				
SV	23	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8.				
SP	24	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
	25	OPERATOR STEP PB				
	26	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB				
5	27	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE				
	28	OPERATOR STEP PB				
	29	DURING STRIKE RECORD:	2:35/p			
	30	SP STEP				
	31	V-243/V-244				
	32	13/46 (30 MIN)	9.6	9.0-10.0	3:05/p	
	33	14/47 (60 MIN)	9.5	9.0-10.0	3:35/p	
	34	15/48 (2 HRS)	9.9	9.0-10.0	4:35/p	
	35	16/49 (3 HRS)	9.3	9.0-10.0	5:35/p	
	36	16/49 (4 HRS)	9.25	9.0-10.0	6:35/p	
	37	17/50 (FINISH)	7.7	7.5-8.5	7:20/p	
	38	NOTE: IF PH NOT IN RANGE, NOTIFY SUPV & NOTE IN LOG. IF FINAL PH >8.5, ADJ TO 7.5-8.5.				
	39	& RECORD: PH ____.				
	40	ASSUME 77%				
	41	27-D				
DRUM	42	WEIGH INTO 55 GAL DRUM	ASSUME 50%	56	7-D	28
6	43	FILL WITH WATER & STIR 2 MIN				
SV	44	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.				
SP	45	SP STEP 23/53 - RECORD: PH 3.5 (3.3-3.7)				
CP	46	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7				
	47	RECORD: PH ____			15-A	
	48	NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140				
	49	*F IN DRUM. USE 30 GAL WATER TO 50# N-15-A.				
	50	STIR 5 MIN AFTER EACH ADDITION.				
	51	SIFT IN	150	128-A	150	
	52	SIPHON IN N-7-D FROM S. 29 IN 10-12 MIN & STIR 5 MIN				
	53	RECORD: PH 4.05 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH ____			27-D	
	54	(DILUTE 10 TO 1 WITH WATER)			7-D	
	55	SIPHON N-7-D INTO SV				
	56	OPERATOR STEP PB				
	57	SP STEP 24/54 - POUR IN & STIR 15 MIN	22	978-A	22	
	58	OPERATOR STEP PB				
	59	SP STEP 60 - BATCH COMPLETE				
	60	OPERATOR STEP PB				
	61	PUMP TO V-240				

START
TIME SP STEP

7:AM
3:00P

FINISH
TIME SP STEP

3:PM
8:00PM

OPTR

54
144-235