

CG 03 CODE KY-787-D PKE
 LOT DATE DEC 23 80 38388
 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	CG	CODE	LOT	PQ	LBS
14	YC002B	13479	93	2000	14	YC002B		93	
14	YC002B	13788	93	700	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 3332

NON-BLEEDING

EQUIP	NAME	USE LBS	N-CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
203	2 WEIGH IN DRUM & POUR IN			
203	3 DUMP IN AND STIR 5 MIN			
203	RECORD: START 11:30 P			
203	FIN 12:45 A			
203	4 ADJUST TO 75" (1275 G)			
203	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
203	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
203	7 RECORD: V-205 VOL 11" & ADJ TO 60" (2100 G)			
203	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.			
2	RECORD: TIME START 7:55 A TOTAL MINUTES 120			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
2	11 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 2 (V-243) OR POSITION 7 (V-244)			
CP	13 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
3	14 REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
3	A. 11LG 64% PRESET #1 80 GAL		15-A	160
3	B. 13LG 54% PRESET #6 135 GAL		20-A	135
3	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
3	3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
3	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
3	3FB10 (N-27-D/WATER) RATIO 1.35			
3	3FC40 (N-32-D CONTROLLER) IN MANUAL 0.50 GPM		983-D	1405
3	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.55 GPM			
3	3FC20 (N-32-D WATER) IN REMOTE			
3	3FB10 (N-32-D/WATER) RATIO 1.82			

DEC 29 1980

PUMPED & BLENDED
 DEC 30 1980

V-244

LMS CODE L477

320 ~~12~~ OPERATOR STEP PB
 SV ~~13~~ RECORD LEVEL 2LG ~~42%~~ IF BELOW 35% FOLLOW SOL'N
 SP ~~14~~ MAKE-UP PROCEDURE FOR N-27-D
 CP ~~15~~ ADJUST SV TO 48" (2470 G)
~~16~~ RECORD PH 9.1. ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 ~~17~~ SIPHON INTO SV. RECORD: PH 11.3. ASSUME 50% 40 7-D 20
~~18~~ OPERATOR STEP PB

~~19~~ SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8.
 SV ~~20~~ SWITCH 3FC20, BFC10, & BFC20 TO AUTO
 SP ~~21~~ OPERATOR STEP PB
~~22~~ SP STEP 10/43. WHEN 3FC20, BFC10 & BFC20 FLOWS
 5 ~~23~~ ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
~~24~~ SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
~~25~~ OPERATOR STEP PB
~~26~~ DURING STRIKE RECORD:
 SP STEP
 V-243/V-244
 PH RANGE TIME
 13/46 (30 MIN) 9.5 9.0-10.0 12:20 PM
 14/47 (60 MIN) 9.5 9.0-10.0 1:30 PM
 15/48 (2 HRS) 9.5 9.0-10.0 2:30 PM
 16/49 (3 HRS) 9.5 9.0-10.0 3:30 PM
 16/49 (4 HRS) 9.4 9.0-10.0 4:30 PM
 17/50 (FINISH) 7.3 7.5-8.5 5:05 PM
 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 10.1 (9.5-10.5)
~~32~~ STIR 15 MIN OR LONGER FOR SP STEP 26
~~33~~ RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL
~~34~~ SET PRESET #8 TO 38.2 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 3.4 (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 9.5 (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 9.4 & TIME 6:15 PM
~~44~~ OPERATOR STEP PB
~~45~~ SP STEP 60. BATCH COMPLETE.

START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>10 AM</u>	<u>7 AM</u>	<u>126</u>
<u>2 AM</u>	<u>3 PM</u>	<u>34</u>
<u>3:00 P</u>	<u>6:20 P</u>	<u>235</u>