

S.V. (243), 244

C.V.

D.V.

CG 03 CODE KY-787-D PKG

LOT DATE DEC-28 80 38418

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

CG	CODE	LOT	PQ	LBS
14	YC002B	13479	93	2000
14	YC002B	13478	93	400
14	YC002B		93	

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

TOTAL EST'D WGT 3332

DEC 29 1980

Homog #4 - 1st Pass
Homog #4 - 2nd Pass

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	245	983-D	245
	3 DUMP IN AND STIR 5 MIN	140X50	YC-2-B	2400
	RECORD: START 8:45 AM	13479		
	FIN 8:55 AM	13478		
	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 50" & ADJ TO 60" (2100 G)			
	8 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 3:10 PM TOTAL MINUTES 110			
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	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			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 5.8% PRESET #1 80 GAL	15-A	160	
	B. 13LG 4.8% PRESET #6 135 GAL	20-A	135	
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	3FB10 (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 0.50 GPM	983-D	1405	
	3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.55 GPM			
	3FC20 (N-32-D WATER) IN REMOTE			
	3FR10 (N-32-D/WATER) RATIO 1.82			

N34788

V-243

LBS COSE LBS

16 OPERATOR STEP PB
 320 17 RECORD LEVEL 2LG 85% IF BELOW 35% FOLLOW SOL'N
 SV 17 MAKE-UP PROCEDURE FOR N-27-D
 SP 18 ADJUST SV TO 48" (2470 G)
 CP 19 RECORD PH 10.0 ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 20 SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50% 36 7-D 18
 20 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8
 SV 22 SWITCH 3FC20, BFC10, & BFC20 TO AUTO
 SP 23 OPERATOR STEP PB
 24 SP STEP 10/43. WHEN 3FC20, BFC10 & BFC20 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

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
9.45	9.0-10.0	8:45
9.4	9.0-10.0	9:15
9.35	9.0-10.0	10:15
9.3	9.0-10.0	11:15
9.3	9.0-10.0	12:15
6.7	7.5-8.5	1:00

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 T 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 SIET IN 100 ✓ 128-A 100
 SV 39 SP STEP 23/53. RECORD: PH 3.5 (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 10.0 (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH 9.5 ASSUME 77% 15 27-D 10
 (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 9.3 & TIME 2:30 AM
 44 OPERATOR STEP PB
 45 SP STEP 60. BATCH COMPLETE. Pumped to V-240

START
TIME SP STEP

10:30 AM

3:00 P

4-P

FINISH
TIME SP STEP

3:10 PM

11:00 P

2:30

OPTR

54

235

201