

S.V. 242, 244

C.V.

D.V.

CG 03 CODE KY-787-D PKG

LOT DATE DEC 23 80 38377

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	13173	93	400	14	YC002B		93	
14	YC002B	13478	93	2000	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

DEC 23 1980

(3)

H.0000#4 - 1ST Pass

TOTAL EST'D WGT 3332

DUMP WASH WATER ONLY

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.			
205	2 WEIGH IN DRUM & POUR IN	245	983-D	245
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 1:10 PM 13478			
	FIN 11:45 PM 13173			
	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 44" & ADJ TO 60" (2100 G)			
	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 3:50 AM TOTAL MINUTES 120			
	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 8.1% PRESET #1 80 GAL		15-A	160
	B. 13LG 2.4% 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
	3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	3FR10 (N-27-D/WATER) RATIO 1.35			
	8FC10 (N-32-D CONTROLLER) IN MANUAL 0.50 GPM		983-D	1405
	8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.55 GPM			
	8FR10 (N-32-D/WATER) RATIO 1.82			

		V 244		LBS		LBS
320	118	OPERATOR STEP PB	93			
SV	117	RECORD LEVEL 2LG % IF BELOW 35% FOLLOW SOL'N				
SP	118	MAKE-UP PROCEDURE FOR N-27-D				
CP	119	ADJUST SV TO 48" (2470 G)				
	119	RECORD PH 12.1 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 11.3 ASSUME 50%	32	7-D	16	
	120	OPERATOR STEP PB				
	121	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.6				
SV	122	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
SP	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	7.20/Ans			
		LIMITS, SWITCH 3FC20 TO REMOTE				
	126	OPERATOR STEP PB				
	127	DURING STRIKE RECORD:				
		SP STEP				
		V-243/V-244				
		13/46 (30 MIN)	PH 9.3 RANGE 9.0-10.0 TIME 7:50			
		14/47 (60 MIN)	9.3 9.0-10.0 8:20			
		15/48 (2 HRS)	9.3 9.0-10.0 9:20			
		16/49 (3 HRS)	9.35 9.0-10.0 10:20			
		16/49 (4 HRS)	9.35 9.0-10.0 11:20			
		17/50 (FINISH)	7.3 7.5-8.5 12:05			
		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 (9.5-10.5)				
	132	STIR 15 MIN OR LONGER FOR SP STEP 26				
	133	RECORD: VOL 49" & CALC 69" X 0.78 = 38.2 GAL				
	134	SET PRESET #8 TO 28.7 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	12B-A	100	
SV	139	SP STEP 23/53. RECORD: PH 3.5 (3.7-4.2)				
SP	140	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5				
		MIN				
8	141	RECORD: PH 9.7 (9.0-9.5). ADJ IF NECESSARY &				
		RECORD: PH 9.5 ASSUME 77%	10	27-D	7	
		(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 9.4 & TIME 1:10				
	144	OPERATOR STEP PB				
	145	SP STEP 60. BATCH COMPLETE.				
START		FINISH	OPTR			
TIME SP STEP		TIME SP STEP				
2:00P		3:00P	235		322	
11.6		7.4	120			
7:00A		1:15 PM	235			