

S.V. 243, 244

C.V.

D.V.

CG 03 CODE KY-787-D PKG
 LOT 38172 DATE 12/10/80
 TIME
 EST'D WGT 932 LBS
 STANDARD HRS. 8.9

12/10

OK
AP

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	13371	93	2400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

Homog #3 - 1st Pass

DEC 11 1980

NON-BLEEDING

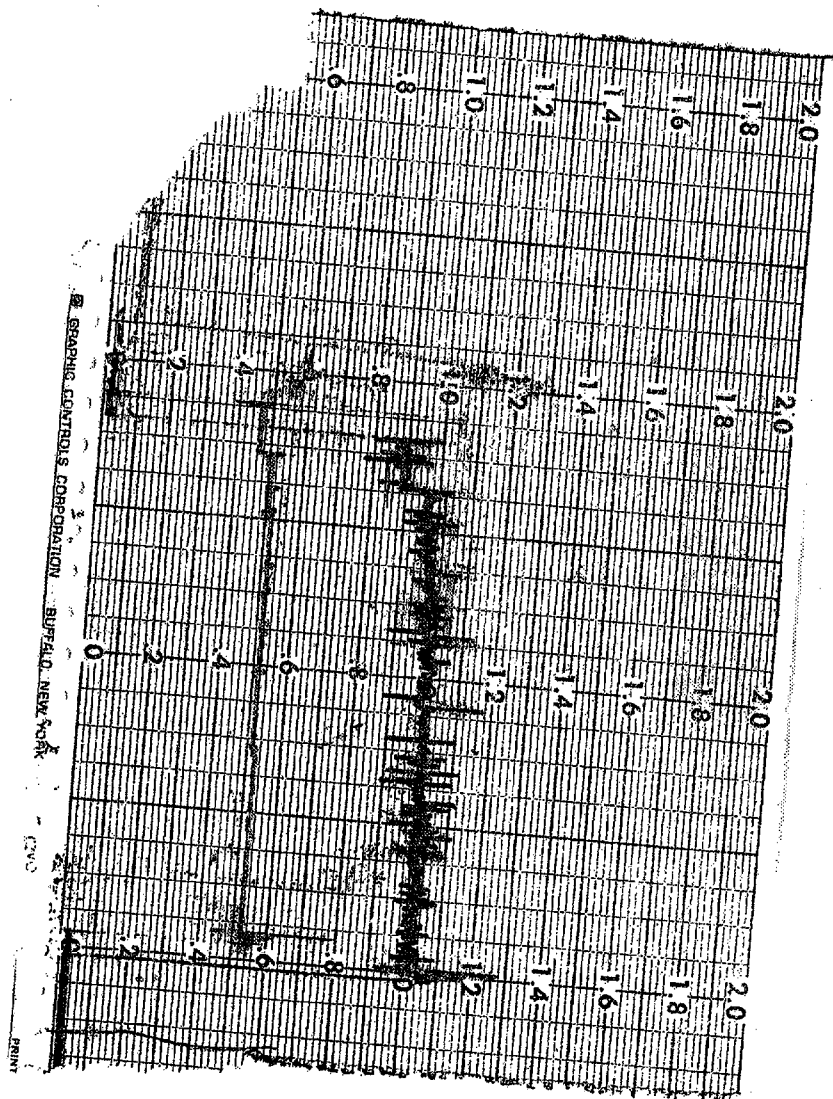
TOTAL EST'D WGT 3332

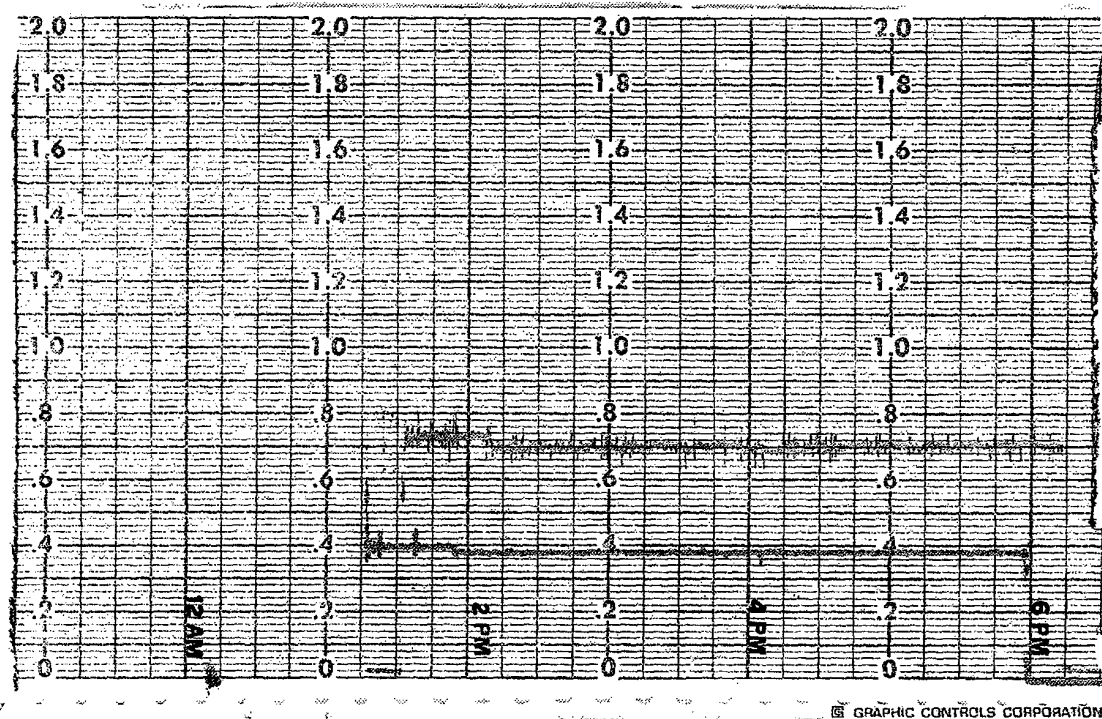
EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN. RECORD: START 5:14 PM. FIN 6:14 PM.	245 48X50 2400	983-D YC-2-B	245 2400
1	4 ADJUST TO 75" (1275 G) WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	5 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 40" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 SV	9 RUN 10" (514 G) WATER INTO V-205 & START AGITATOR			
	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 9:30 / 10:30 TOTAL MINUTES 160			
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 & CP	12 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
	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 3% PRESET #1 80 GAL B. 13LG 3% PRESET #6 135 GAL		15-A 20-A	160 135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS: BFC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM BFC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM BFR10 (N-27-D/WATER) RATIO 1.35 BFC10 (N-32-D CONTROLLER) IN MANUAL 0.50 GPM BFC20 (N-32-D WATER) IN MANUAL LOCAL 4.55 GPM BFC20 (N-32-D WATER) IN REMOTE BFR10 (N-32-D/WATER) RATIO 1.82		27-D 983-D	206 1405

N34812

EQUIP		PAGE 2	CG 03	KY-787-D	EST WGT 33329	LBS	CODE	LBS
V-244								
120	11	OPERATOR STEP PB						
SV	17	RECORD LEVEL 2LG 94% IF BELOW 35% FOLLOW SOL'N						
SV		MAKE-UP PROCEDURE FOR N-27-D						
SP	18	ADJUST SV TO 48" (2470 G)						
CP	19	RECORD PH 9.8. 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%				36	7-D	18
	20	OPERATOR STEP PB						
21								
SV	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.5.						
SP	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO						
	23	OPERATOR STEP PB						
	24	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 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)	PH 9.5	RANGE 9.0-10.0	TIME 9:20 PM			
		14/47 (60 MIN)	9.5	9.0-10.0	4:30 PM			
		15/48 (2 HRS)	9.5	9.0-10.0	5:01 PM			
		16/49 (3 HRS)	9.4	9.0-10.0	6:21 PM			
		16/49 (4 HRS)	9.4	9.0-10.0	7:50 PM			
		17/50 (FINISH)	7.0	7.5-8.5	7:50 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 ____.						
							27-D	
28								
	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 50" & CALC 50" X 0.78 = 39.0 GAL						
	34	SET PRESET #8 TO 39.0 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								
	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 9.7 (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 10.2 (9.0-9.5). ADJ IF NECESSARY &						
		RECORD: PH 9.5 ASSUME 77%				70	27-D	15
		(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 9.5 & TIME 9:30 PM						
	44	OPERATOR STEP PB						
	45	SP STEP 60. BATCH COMPLETE.						

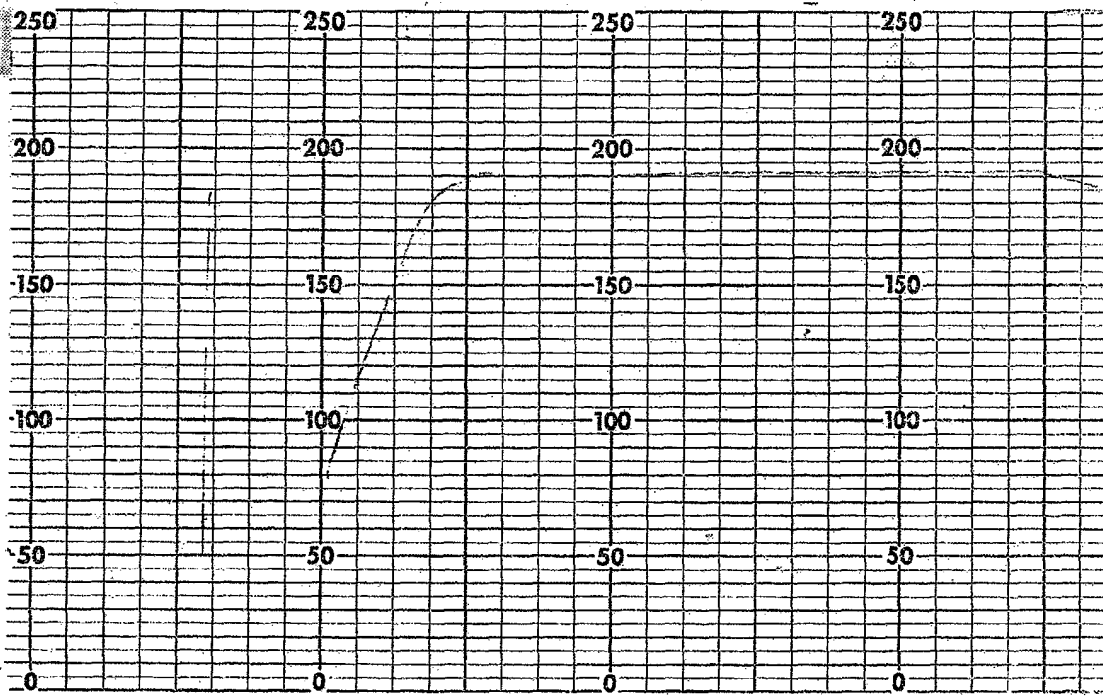
START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
8:30 PM	11:00 PM	320-235
6:00 PM	9:40 PM	37





GRAPHIC CONTROLS CORPORATION

DUP050105361



U.S.A.

No. 215A250

