DEC 18-80 38320

STANDARD HRS. 10.6 TIME _____ M

( ) KY-787-D (R) FWP 11/20/80
( ) ( ) (XOB-17: 3/4
( ) ( ) N-32-D & 240
( ) ( ) MIN STRIKE)
JOB NAME: 03KY-787-DMR

CG	CODE	PQ	LOT	LBS
14	YC002B	93	13164	200
14	YC002B	93	13179	200
14	YC002B	93	13770	2000

DEC 22 1980

TOTAL EST'D WGT 3332

NON-BLEEDING

EQUIP		NAME : "KROLOR" YELLOW MEDIUM	USE LBS	NCODE	ACCT LBS
203 & 205	1	RUN 60"(990 GAL) WATER INTO V-203. RUN AGITATOR ON HIGH SPEED.			
	2	WEIGH SODIUM SILICATE INTO DRUM & POUR IN	245	983-D	245
	3	DUMP IN CHROME YELLOW & STIR 5 MIN	48X50	YC-2-B	2400
1		RECORD: START 4:30PM FIN 5:45PM	200 200 2000		
	4	ADJUST TO 75" (1275 GAL)			
	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 HOT WATER AT 2400-2600 PSI INTO V-205			
	7	RECORD: V-205 VOL._____" & ADJUST TO 60"(2100 GAL)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208 & SV	9	RUN 7 "(200 GAL) WATER INTO V-244 START AGITATOR & INSTALL TEMP CHART			
	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START 200A 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 GAL) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384	12	WHILE HOMOG, RUN 6" (284 GAL) WATER INTO V-349			
	13	RUN 1000# WATER INTO V-384 & HEAT TO 110-120*F			
	14	WEIGH INTO V-384 & PUMP TO V-349	1410	983-D	1410
	15	RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16	ADJ V-349 TO 17" (805 GAL) & STIR 15 MIN			
	17	RECORD DENSITY: 1.060 G/ML (1.059-1.060)			
SV	18	WHEN S-11 HOMOG COMPLETE, ADJ SV TO 47 "(2420 GAL)			
	19	RECORD: PH 9.4 & ADJ TO 11.1-11.3 WITH CAUSTIC			
4		AT 5% (10 PARTS WATER TO 1 PART N-7-D) ASSUME 50%	40	7-D	20
		SIPHON N-7-D INTO SV & RECORD: PH 11.3			
	20	HEAT TO 190-194*F IN 55-65 MIN & REC: HT ____*F & RECORD: ____*F			
		NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON ON COMPLETION OF HEATING			
343 & 386	21	WHILE HEATING SV, RUN 39" (1070 GAL) WATER INTO V-343 & METER IN SULFURIC ACID FROM V-386 MK 30 9.677#/GAL 21.3 GAL		27-D	206
	22	STIR 15 MIN OR LONGER			
5	23	RECORD: DENSITY 1.014 G/ML (1.013-1.014)			

PUNCHED & CHECKED DEC 23 1980

V-244

			LBS	CODE	LBS
	24	WHEN S 20 HEATING COMPLETE, RECORD: PH 9.6			
	25	SET V-343 ACID PUMP AT 49 SETTING (285 MIN)			
	26	SET V-349 SILICATE PUMP AT 38 SETTING (240 MIN)			
	27	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV			
SV		AT 190-194*F DURING STRIKE			
	28	RECORD: START FINISH MINUTES			
		V-343 _____ _____			
		V-349 8AM _____ _____			
		V-343 V-349 SV NORMAL			
		TIME INCHES INCHES PH PH			
		AT 20 MIN 820 (37) (16) 9.4 (9.3-10.0)			
		40 MIN 840 (34) (14) 9.4 (9.3-10.0)			
6		1 HR 900 (31) (13) 9.4 (9.3-10.0)			
		2 HR 1000 (23) (9) 9.3 (9.3-10.0)			
		3 HR 1100 (15) (4) 9.3 (9.3-10.0)			
		4 HR 1200 (6) (0) 9.2 (9.3-10.0)			
		FINISH 1245 (0) 7.1 (7.5-8.5)			
		NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP PUMPS & SEE SUPV. IF FINAL PH IS ABOVE 8.5, ADJ TO 7.5-8.5 ASSUME 77%	_____	27-D	_____
330	29	RUN 20" (392 GAL) WATER INTO V-330 & HEAT TO			
7		80-100*F			
	30	ADD DRESINATE "X" IN 7-8 MIN	350	530-A	350
	31	STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)			
	32	STIR 20 MIN OR LONGER FOR S-45			
385	33	RUN 40"(308 GAL) WATER INTO V-385 & HEAT TO			
8		135-140*F			
	34	DUMP IN ALUM & STIR TO DISSOLVE FOR S-41	160	15-A	160
302	35	ADD 30" (360 GAL) WATER TO V-302			
9	36	ADD & STIR 2 MIN FOR S-43 (D) ASSUME 50%	180	7-D	90
SV	37	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
10	38	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	39	TURN OFF STEAM			
	40	SIFT IN BLANC FIXE	100	128-A	100
	41	RUN IN V-385 FROM S 34 & STIR 5 MIN			
	42	RECORD: PH 3.4 (3.7-4.2)			
	43	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
	44	RECORD: PH 10.0 (9.0-9.5) & IF NECESSARY ADJ TO PH 9.0-9.5. RECORD: PH 9.5 ASSUME 77%	2	27-D	1
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%	_____	7-D	_____
		SIPHON N-7-D INTO SV			
	45	RUN IN V-330 THRU 20 MESH SCREEN & STIR 20 MIN			
313	46	RUN 10" (128 GAL) WATER INTO V-313			
11	47	DUMP IN CALCIUM CHLORIDE & STIR 5 MIN FOR S-48	135	20-A	135
SV	48	RUN V-313 INTO SV IN 15-20 MIN			
12	49	STIR 15 MIN & RECORD: PH ____ (9.0-10.0)			
	50	STOP AGITATOR (DO NOT STOP AGITATOR IN V-262)			
		START FINISH OPERATOR			
		2:A 2:P 282			
		STEP V-262 (20 RPM) V-243,244,246,247			
		9 2* 4*			
		8 24 47			

DUP050105097

(AUTOMATED)
S.V. 243, 244 C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03 CODE KY-787-D PKG
LOT _____ DATE _____ DEC 18 80 38320
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	13184	93	200	14	YC002B	_____	93	_____
14	YC002B	13179	93	200	14	YC002B	_____	93	_____
14	YC002B	13370	93	2000	14	YC002B	_____	93	_____

TOTAL EST'D WGT 3332 Converted to Manual Batch NON-BLEEDING

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	245	983-D	245
	3	DUMP IN AND STIR 5 MIN LOT	48X50	YC-2-B	2400
		RECORD: START 4:30 PM 13184	200		
1		FIN 5:02 PM 13179	200		
		13370	2000		
	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 ____" & ADJ TO 60" (2100 G)			
	8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9	RUN 10" (514 G) WATER INTO V-___ & START AGITATOR			
SV	10	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START _____ TOTAL MINUTES _____			
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 ____% PRESET #1 80 GAL		15-A	160
		B. 13LG ____% 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			
		8FC20 (N-32-D WATER) IN REMOTE			
		8FR10 (N-32-D/WATER) RATIO 1.82			

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EQUIP		PAGE 2 LG 03 KIT 101-D EST WGT 9000#		USE		USE
				LBS	CODE	LBS
	16	OPERATOR STEP PB				
320	17	RECORD LEVEL 2LG ___% 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 ___. 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 ___.	ASSUME 50%	_____	7-D	_____
	20	OPERATOR STEP PB				
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH ___.				
SV	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO				
SP	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	PH RANGE TIME			
		13/46 (30 MIN)	____ 9.0-10.0 _____			
		14/47 (60 MIN)	____ 9.0-10.0 _____			
		15/48 (2 HRS)	____ 9.0-10.0 _____			
		16/49 (3 HRS)	____ 9.0-10.0 _____			
		16/49 (4 HRS)	____ 9.0-10.0 _____			
		17/50 (FINISH)	____ 7.5-8.5 _____			
		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 ___ (9.5-10.5)				
	32	STIR 15 MIN OR LONGER FOR SP STEP 26				
	33	RECORD: VOL ___" & CALC ___" X 0.78 = ___ GAL				
	34	SET PRESET #8 TO ___ 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 ___ (3.7-4.2)				
SP	40	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5				
		MIN				
8	41	RECORD: PH____ (9.0-9.5). 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 ____ & TIME ____				
	44	OPERATOR STEP PB				
	45	SP STEP 60. BATCH COMPLETE.				

START		FINISH		OPTR
TIME	SP STEP	TIME	SP STEP	
____	_____	____	_____	____
____	_____	____	_____	____
____	_____	____	_____	____

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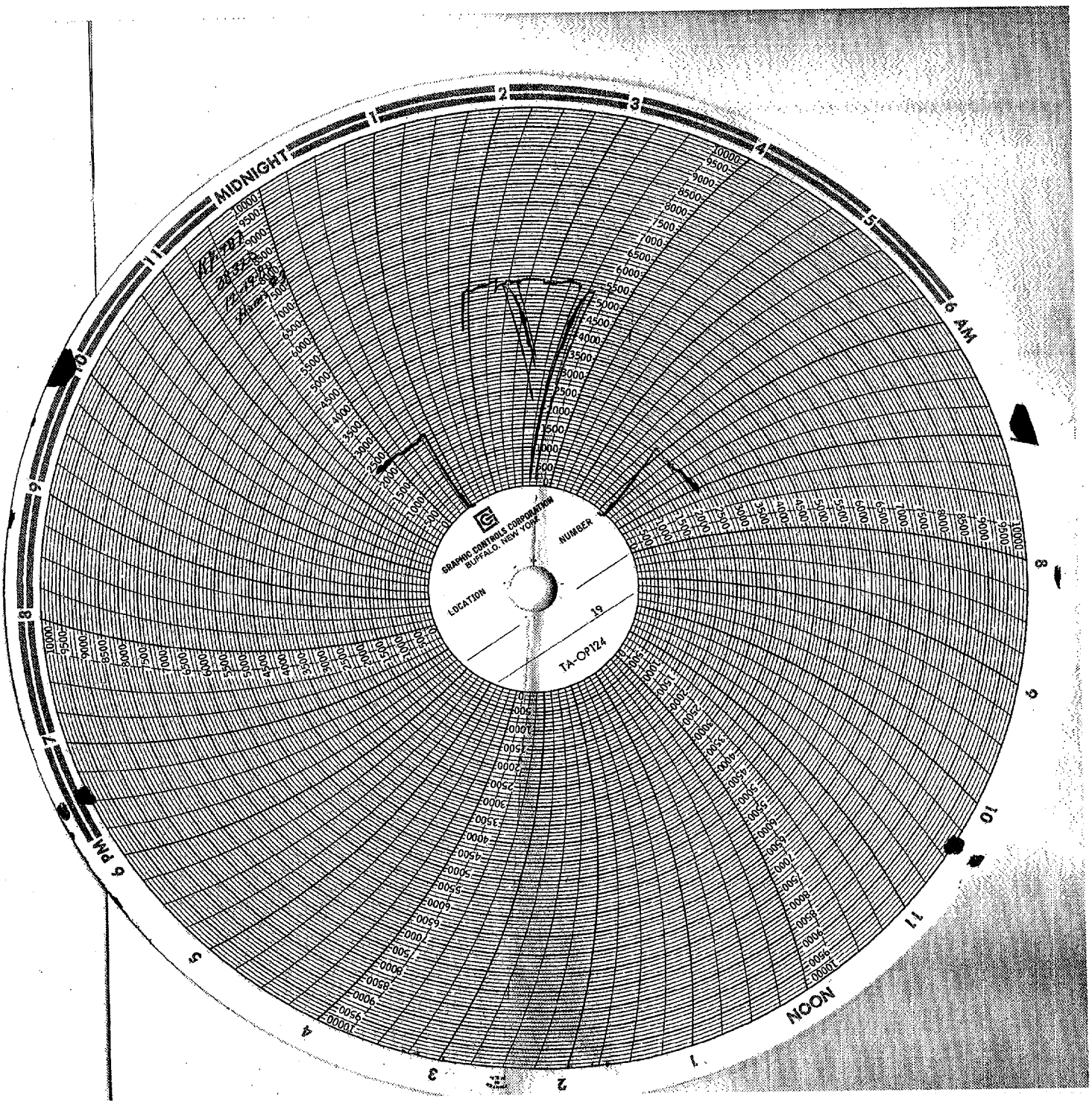

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