

S.V. 243

C.V.

D.V.

CG 03 CODE KY-787-D PKG
 LOT 38206 DATE 12-4-80
 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	13358	93	2000	14	YC002B		93	
14	YC002B	13371	93	200	14	YC002B		93	
14	YC002B	13677	93	200	14	YC002B		93	

TOTAL EST'D WGT 3332

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N-CODE	ACCT LBS
203	RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	WEIGH IN DRUM & POUR IN	245	983-D	245
263	DUMP IN AND STIR 5 MIN LOT	48X50	YC-2-B	2400
1	RECORD: START 12:55 PM FIN 1:25 PM			
1	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			
263	RECORD: V-205 VOL " & ADJ TO 60" (2100 G)			
8	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
263	PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
SV	RECORD: TIME START 6:25 AM TOTAL MINUTES 110			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3 WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
14	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
CP	PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
3	REMOTE (TEMP IS SET AT 190-194°F)			
14	RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 50% PRESET #1 80 GAL		15-A	160
	B. 13LG 34% 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			
	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			

PUNCHED & CHECKED
DEC 1 1980

N34774

V-243

14 OPERATOR STEP PB
 320 17 RECORD LEVEL 2LG 90% 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 9.9. 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 11.1. ASSUME 50% 40 7-D 20
 21 OPERATOR STEP PB

22 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9.
 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: 9:30/A.
 SP STEP
 V-243/V-244

	PH	RANGE	TIME
13/46 (30 MIN)	9.3	9.0-10.0	10:10A
14/47 (60 MIN)	9.6	9.0-10.0	10:30A
15/48 (2 HRS)	9.4	9.0-10.0	11:30A
16/49 (3 HRS)	9.4	9.0-10.0	12:30A
16/49 (4 HRS)	9.4	9.0-10.0	1:30A
17/50 (FINISH)	8.3	7.5-8.5	2:15A

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 52" & CALC 52" X 0.78 = 40.6 GAL
 34 SET PRESET #8 TO 40.6 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 12B-A 100
 SV 39 SP STEP 23/53. RECORD: PH 9.4 (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 9.4 (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 3:11P
 44 OPERATOR STEP PB
 45 SP STEP 60. BATCH COMPLETE.

START TIME SP STEP	FINISH TIME SP STEP	OPTR
7:11AM	3:11PM	54