

LOT
EST'D WGT 932 LBS
STANDARD HRS. 8.9 TIME 11 PM OK

() KY-787-D (Q) FWP 11/3/80
() (XOB-17: 25%
() LESS N-32-D
() & 240 MIN
() STRIKE)

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13180	93	2000	14	YC002B		93	
14	YC002B	13191	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 3332

NON-BLEEDING

USE FLAKE CUSTIC

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.			
203	2 WEIGH IN DRUM & POUR IN	240	983-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 6:30 LOT 13180	40		
	FIN 8:30 13191	8		
263	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 56" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
11	1 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
11	2 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 11:00 AM TOTAL MINUTES 195			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	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 54% PRESET #1 80 GAL	15-A	160
		B. 13LG 20% 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 0.49 GPM	983-D	1376
		3FC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM		
		3FC20 (N-32-D WATER) IN REMOTE		
		BER10 (N-32-D/WATER) RATIO 1.82		

V-244

LBS

CODE

LBS

16 OPERATOR STEP PB
320 17 RECORD LEVEL 2LG 85% IF BELOW 35% FOLLOW SOL'N
SV MAKE-UP PROCEDURE FOR N-27-D
SP 18 ADJUST SV TO 48" (2470 G)
CB 19 RECORD PH 10.21 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 11.1 ASSUME 50% 11 27-D 11
20 OPERATOR STEP PB

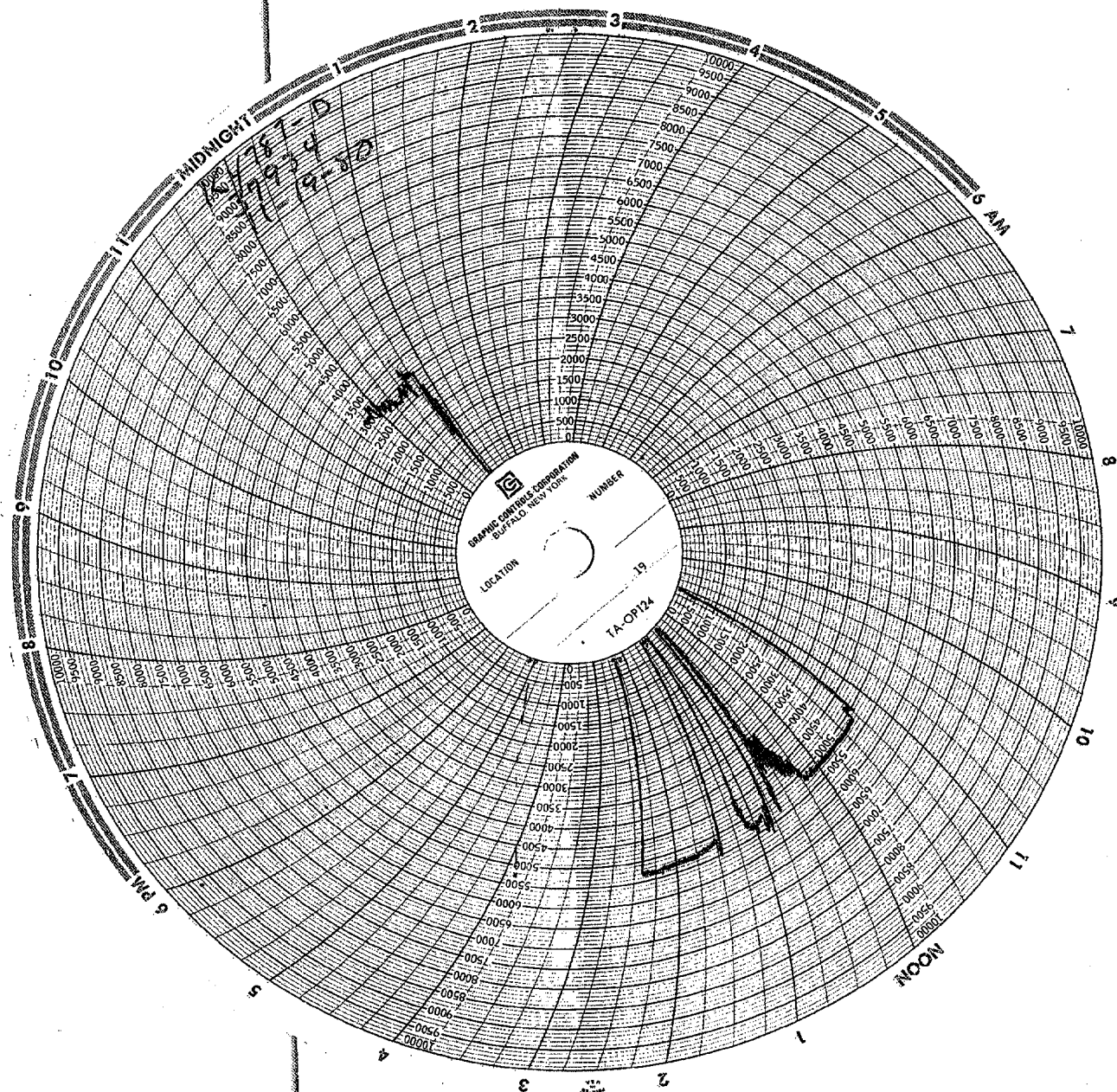
21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 10.9
SV 22 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
SP 23 OPERATOR STEP PB
24 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
5 25 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
LIMITS, SWITCH 3FC20 TO REMOTE
26 OPERATOR STEP PB
27 DURING STRIKE RECORD:
SP STEP
V-243/V-244
13/46 (30 MIN) 9.8 9.0-10.0 5:25
14/47 (60 MIN) 9.7 9.0-10.0 5:55
15/48 (2 HRS) 9.6 9.0-10.0 6:55
16/49 (3 HRS) 9.6 9.0-10.0 7:55
16/49 (4 HRS) 9.5 9.0-10.0 8:55
17/50 (FINISH) 9.6 7.5-8.5 9:40
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

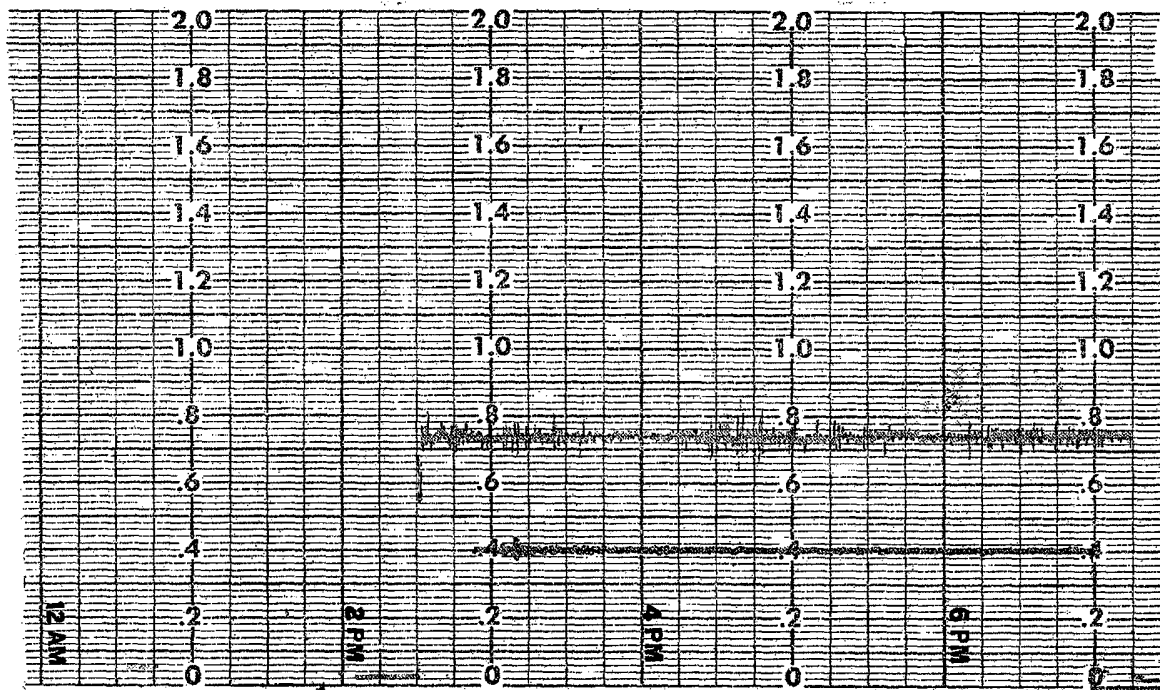
28 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
29 ADD IN 7-8 MIN 350 530-A 350
339 30 ADJ TO 49" (382 G) AT 80-100°F
6 31 STIR 5 MIN & RECORD: PH 10.1 (9.5-10.5)
32 STIR 15 MIN OR LONGER FOR SP STEP 26
33 RECORD: VOL 50" & CALC 50" X 0.78 = 39.0 GAL
34 SET PRESET #8 TO 39.0 GAL FROM S 33

302 35 RUN 30" (360 G) WATER INTO V-302
7 36 ADD & STIR 2 MIN FOR S 40 ASSUME 50% 80 72-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 (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 10.4 & TIME 10.40 PM
44 OPERATOR STEP PB
45 SP STEP 60. BATCH COMPLETE.

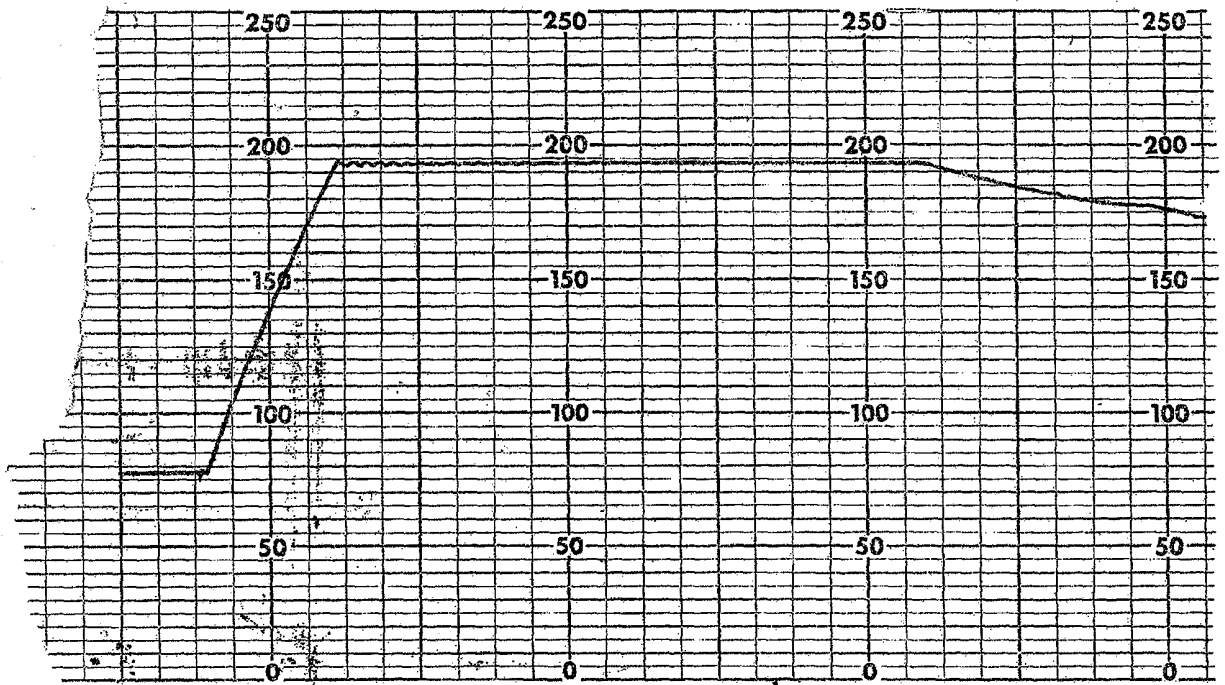
START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
8:30 AM	10:00 AM	322 310
11 PM	7 PM	282
11 AM	3 PM	54-303
3:00 PM	10:45 PM	144





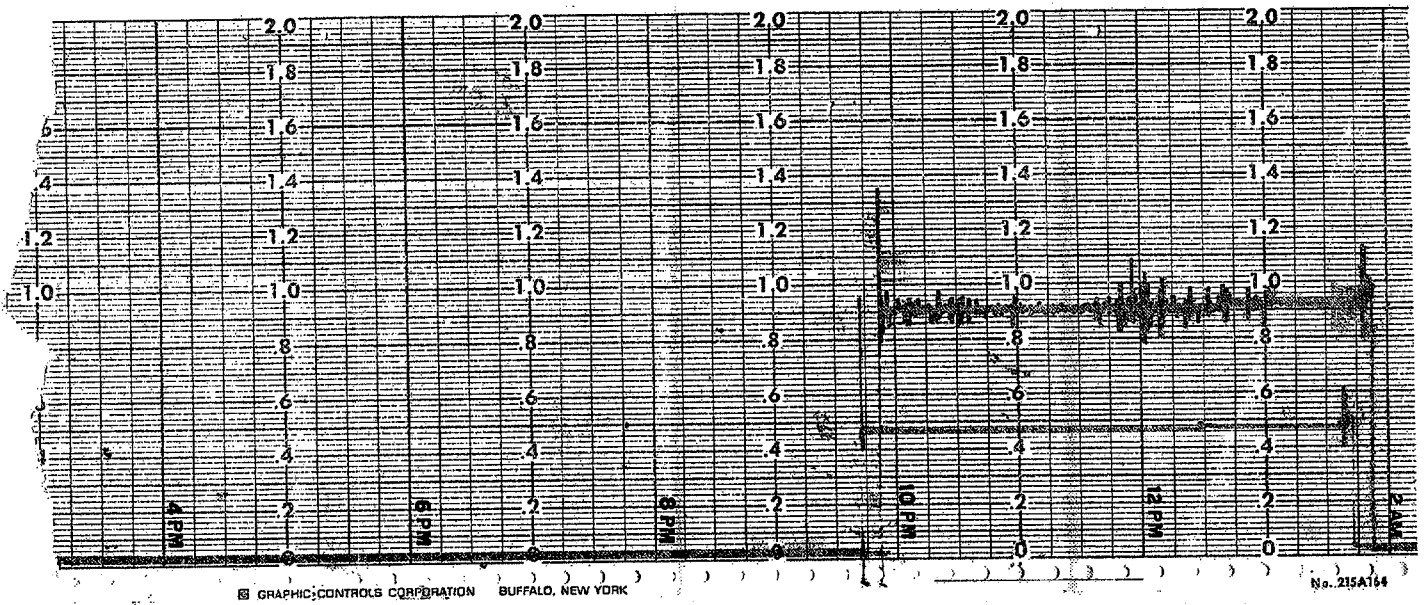
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