LOT

OCT·21 80 37518

OK / HP

STANDARD HRS. 8.2 TIME 1/2 M

( ) KY-795-D (H) FWP 10/14/80
( ) ( ) (XOB-17: 3/4
( ) ( ) N-32-D & 240
( ) ( ) MIN STRIKE)
( ) ( )
TYPED BY: FWP 10/14/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13177	93	2000	14	YC002B	13177	93	2000
14	YC002B	13128	93	1500	14	YC002B	13128	93	1500
14	YC002B		93		14	YC002B		93	

Homog #4 - 12T Plug

LEAVE ONE STUMP ONLY

TOTAL EST'D WGT 4380 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	475	32-D	475
	3	DUMP IN AND STIR 5 MIN LOT	70X50	YC-2-B	3500
		RECORD: START 7-Am 13177	2000		
1		FIN 8:30 Am 13128 the	1500		
	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 9:10Am TOTAL MINUTES 180			
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 5 (V-243) OR POSITION 10 (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 52 % PRESET #1 104 GAL	1653	15-A	208
	15	SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
		SFC10 (N-27-D CONTROLLER) IN MANUAL 0.56 GPM		27-D	296
		SFC20 (N-27-D WATER) IN MANUAL LOCAL 5.8 GPM			
		SFR10 (N-27-D/WATER) RATIO 1.04			
		SFC10 (N-32-D CONTROLLER) IN MANUAL 0.68 GPM		32-D	1885
		SFC20 (N-32-D WATER) IN MANUAL LOCAL 5.4 GPM			
		SFC20 (N-32-D WATER) IN REMOTE			
		SFR10 (N-32-D/WATER) RATIO 1.59 1096		JM	

N35027

EQUIP		PAGE 2 CG 03 KY-795-D EST WGT 4380# V-244	USE LBS	N- CODE	USE LBS
	16	OPERATOR STEP PB			
	17	RECORD LEVEL 2LG 39+. IF <35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
SV					
SP	18	ADJUST SV TO 58" (2980 G)			
CP	19	RECORD PH 10.3. 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%	20	721-D	20
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8			
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 9:50 P.M			
	27	DURING STRIKE RECORD: SP STEP V-243/V-244			

	PH	RANGE	TIME
13/46 (30 MIN)	9.55	9.0-10.0	10:20 P.M
14/47 (60 MIN)	9.55	9.0-10.0	10:50 P.M
15/48 (2 HRS)	9.55	9.0-10.0	11:50 P.M
16/49 (3 HRS)	9.55	9.0-10.0	12:50 A.M
16/49 (4 HRS)	8.93	9.0-10.0	1:50 A.M
17/50 (FINISH)	8.44	7.5-8.5	2:35 A.M

		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	____
DRUM 6	28	WEIGH INTO 55 GAL DRUM ASSUME 50%	28	721-D	28
	29	FILL WITH WATER & STIR 2 MIN			
	30	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR PB.			
SV	31	SP STEP 23/53 - RECORD: PH 3.4 (3.3-3.7)			
SP & CP 7	32	IF NECESSARY ADJ PH (DOWN ONLY) TO 3.3-3.7 RECORD: PH ___. NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140°F IN DRUM. USE 30 GAL WATER TO 50# N-15-A. STIR 5 MIN AFTER EACH ADDITION.	____	15-A	____
	33	SIFT IN	150	128-A	150 ✓
	34	SIPHON IN N-7-D FROM S 29 IN 10-12 MIN & STIR 5 MIN			
	35	RECORD: PH 4.9 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH 4.2 ASSUME 77%	6	27-D	5
		(DILUTE 10 TO 1 WITH WATER) ASSUME 50%	____	7-D	____
		SIPHON N-7-D INTO SV			
	36	OPERATOR STEP PB			
	37	SP STEP 24/54 - POUR IN &STIR 15 MIN	22	978-A	22 ✓
	38	OPERATOR STEP PB			
	39	SP STEP 60 - BATCH COMPLETE			
	40	OPERATOR STEP PB			

START TIME	SP STEP	FINISH TIME	SP STEP	OPTR
8:30 A	____	3:00 P	____	235-V244
3:00 PM	____	11:00 PM	____	201-381
11:00 P	____	5:15 A.M.	____	126

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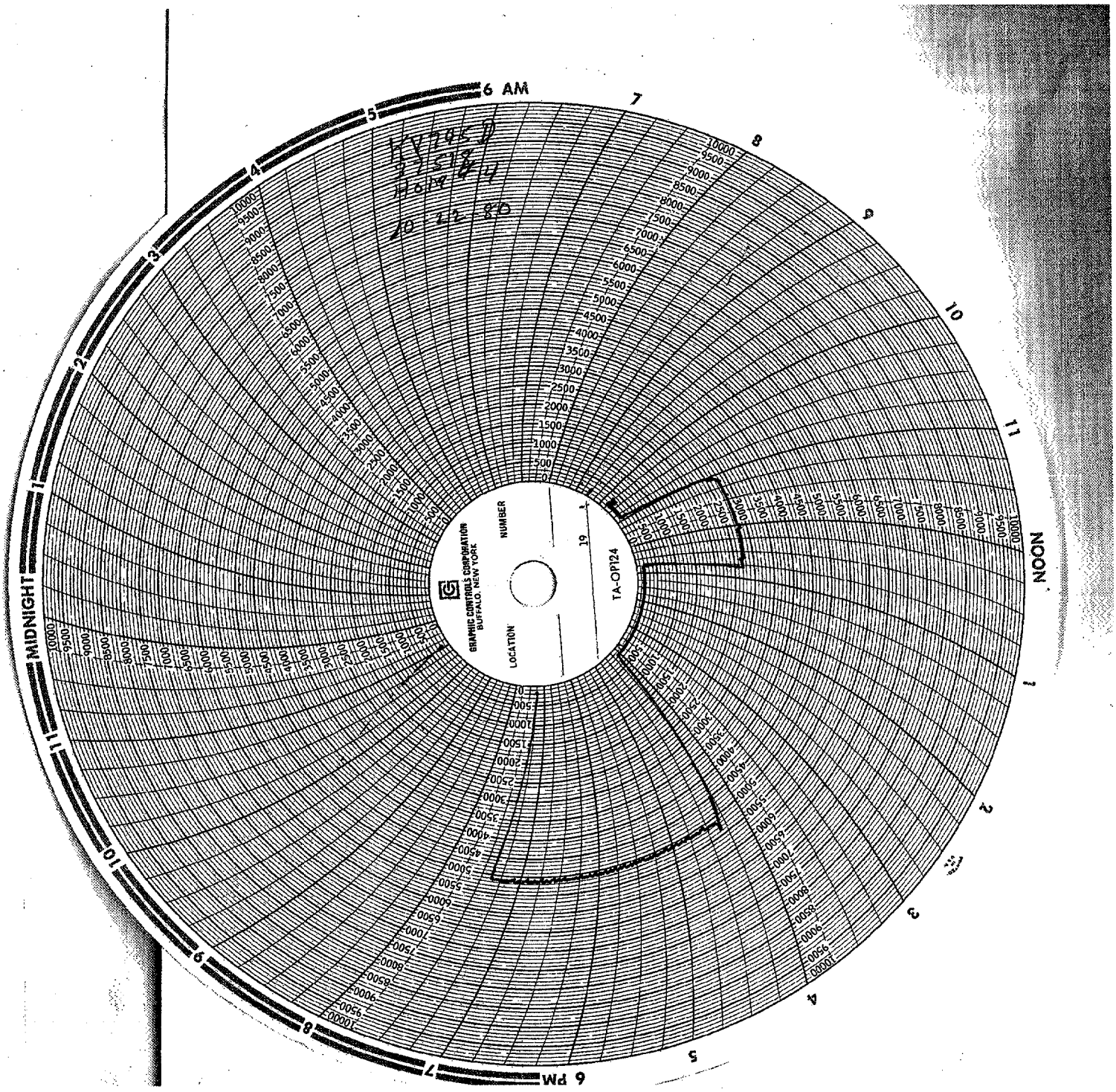

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