

LOT

NOV 21 80 37939

NOV 11 1980

KY-787-D

(Q) FWP 11/3/80

EST'D WGT 932

LBS

() (XOB-17: 25%

() LESS N-32-D

() & 240 MIN

() STRIKE)

STANDARD HRS. 8.9

TIME

3P M

TYPED BY: FP 11/3/80

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13189	93	2000	14	YC002B		93	
14	YC002B	1319X	93	400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	

use FLAKE
CAUTIC

TOTAL EST'D WGT 3332

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
203	11 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON			
&	HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	240	983-D	240
	3 DUMP IN AND STIR 5 MIN	48X50	YC-24B	2400
	RECORD: START <u>2:40</u> LOT <u>13189</u>	<u>2000</u>		
1	FIN <u>11:07</u> <u>13191</u>	<u>400</u>		
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	HOMOG AT 2400-2600 PSI INTO V-203 <u>263</u>			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	OF HOT WATER AT 2400-2600 PSI INTO V-205			
0263	7 RECORD: V-205 VOL <u>240</u> & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-205 & START			
	AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START <u>1:42</u> TOTAL MINUTES <u>200</u>			
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	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 TO IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	14 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG <u>70</u> % PRESET #1 80 GAL	15-A		160
	B. 13LG <u>65</u> % 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			
	✓ 3FR10 (N-32-D/WATER) RATIO 1.82			

N34896

320 16 OPERATOR STEP PB
 SV 17 RECORD LEVEL 2LG 84% IF BELOW 35% FOLLOW SOL'N
 SP 18 MAKE-UP PROCEDURE FOR N-27-D
 CP 19 ADJUST SV TO 48" (2470 G)
 19 RECORD PH 10.4. 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 11.2. ASSUME 50%
 20 OPERATOR STEP PB

SV 21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9
 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

	PH	RANGE	TIME
13/46 (30 MIN)	9.3	9.0-10.0	9:10
14/47 (60 MIN)	9.3	9.0-10.0	9:40
15/48 (2 HRS)	9.3	9.0-10.0	10:40
16/49 (3 HRS)	9.1	9.0-10.0	11:40
16/49 (4 HRS)	9.1	9.0-10.0	12:40
17/50 (FINISH)	6.3	7.5-8.5	1:23 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 ____ ASSUME 77%

128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 129 ADD IN 7-8 MIN
 339 130 ADJ TO 49" (382 G) AT 80-100°F
 6 131 STIR 5 MIN & RECORD: PH 10.2 (9.5-10.5)
 132 STIR 15 MIN OR LONGER FOR SP STEP 26
 133 RECORD: VOL 29" & CALC 29" X 0.78 = 38.2 GAL
 134 SET PRESET #8 TO 38.2 GAL FROM S 33

302 135 RUN 30" (360 G) WATER INTO V-302
 7 136 ADD & STIR 2 MIN FOR S 40 (2 DRUMS) ASSUME 50%

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 138 SIFT IN
 SV 139 SP STEP 23/53. RECORD: PH 3.6 (3.7-4.2)
 SP 140 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
 MIN
 8 141 RECORD: PH 8.2 (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH 9.1 ASSUME 77%
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%
 (SIPHON N-7-D INTO SV)
 142 OPERATOR STEP PB
 143 SP STEP 29/58. RECORD: PH 9.1 & TIME 2:35
 144 OPERATOR STEP PB
 145 SP STEP 60. BATCH COMPLETE.

2 START TIME SP STEP 3:00 PM 11:00 AM	3 FINISH TIME SP STEP 11:00 PM 3:25 AM	OPTR 120- 237-320 342
--	---	--------------------------------