

CG 03 CODE KY-787-D PKG

LOT

DATE

DEC 23 80 38379

PROCESSES

APPROVED BY

EST'D WGT 932

LBS

STANDARD HRS. 8.9

() KY-787-D (Q) FWP 12/04/80

() XOB-17: 25% LESS SILICA &

() A 240 MIN STRIKE

COMTYR JOB NAME: XOB17:787Q

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	13488	93	2000
14	YC002B	13179	93	400
14	YC002B		93	

CG	CODE	LOT	PQ	LBS
14	YC002B		93	
14	YC002B		93	
14	YC002B		93	

DEC 23 1980

(JN)

Homog #4 - 1st Pass

TOTAL EST'D WGT 3332

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	4000	YC-2-B	2400
	RECORD: START 1:15am			
	FIN 2:15	13488		
		13179		
	4 ADJUST TO 75" (1275 G)	2000		
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205	400		
	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 59" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 1:04PM TOTAL MINUTES 120			
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 20% PRESET #1 80 GAL		15-A	160
	B 13LG 60% 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			
	8FR10 (N-32-D/WATER) IN REMOTE			
	BFR10 (N-32-D/WATER) RATIO 1.82			

320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 5% IF BELOW 35% FOLLOW SOL'N			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CF	19	ADJUST SV TO 48" (2470 G)			
	20	RECORD PH 9.23 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 11.2 ASSUME 50%	410	7-D	20
	20	OPERATOR STEP PB			
	21	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.9			
SV	22	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	23	OPERATOR STEP PB 10 AM			
	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)	PH 9.5 RANGE 9.0-10.0 TIME 1:30		
		14/47 (60 MIN)	PH 9.5 RANGE 9.0-10.0 TIME 2:00		
		15/48 (2 HRS)	PH 9.5 RANGE 9.0-10.0 TIME 3:00		
		16/49 (3 HRS)	PH 9.5 RANGE 9.0-10.0 TIME 4:00		
		16/49 (4 HRS)	PH 9.5 RANGE 9.0-10.0 TIME 5:00		
		17/50 (FINISH)	PH 9.2 RANGE 7.5-8.5 TIME 5:45		
		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 9.8 (9.5-10.5)			
	32	STIR 15 MIN OR LONGER FOR SP STEP 26			
	33	RECORD: VOL 49" & CALC 49" X 0.78 = 38.2 GAL			
	34	SET PRESET #8 TO 38.2 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 3.5 (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 (9.0-9.5). 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 9.0 & TIME 6:30 PM			
	44	OPERATOR STEP PB			
	45	SP STEP 60. BATCH COMPLETE.			
		START TIME SP STEP	FINISH TIME SP STEP	OPTR	
		7:00 PM	3:00 PM	235	
		1:00 PM	6:00 PM	116	