

CG 03 CODE KY-787-D PKG
 LOT DATE DEC-29 80 38420
 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
 ()

CONTYP JOB NAME: XOB17:787Q

COMPONENT CONSUMPTION									
CG	CODE	LOT	PQ	LBS	CG	CODE	LOT	PQ	LBS
14	YC002B	13488	93	2400	14	YC002B		93	
14	YC002B		93		14	YC002B		93	
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 3332

DEC 30 1980

HOMOG 24-1ST PASS
 " 4-2ND "

NON-BLEEDING

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.			
205	2 WEIGH IN DRUM & POUR IN	245	983-D	245
	3 DUMP IN AND STIR 5 MIN	48X50	YC-2-B	2400
	RECORD: START 4:35 PM	48		
1	FIN 5:40 PM			
	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 4.4 " & 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 12:30 PM TOTAL MINUTES 105			
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	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 50% PRESET #1 80 GAL	15-A		160
	B. 13LG 40% 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			
	8FC20 (N-32-D WATER) IN REMOTE			
	8FR10 (N-32-D/WATER) RATIO 1.82			

PUNCHED & CHECKED
 DEC 30 1980

SA

V-244

LOG CODE 103

320 117 OPERATOR STEP PB
 SV 117 RECORD LEVEL 2LG ~~68%~~ IF BELOW 35% FOLLOW SOL'N
 SP 118 MAKE-UP PROCEDURE FOR N-27-D
 CP 118 ADJUST SV TO 48" (2470 G)
 119 RECORD PH ~~10.6~~ ADJ TO 11.1-11.3 WITH N-7-D AT
 5% (10 PARTS WATER TO 1 PART N-7-D)
 4 120 SIPHON INTO SV. RECORD: PH ~~11.3~~. ASSUME 50% 30 7-D 15
 120 OPERATOR STEP PB

SV 121 SP STEP 06/39. AFTER HEAT-UP RECORD: PH ~~9.8~~
 SP 122 SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO
 123 OPERATOR STEP PB
 124 SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS
 ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB
 5 125 SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN
 LIMITS, SWITCH 3FC20 TO REMOTE
 126 OPERATOR STEP PB
 127 DURING STRIKE RECORD: 4'10"
 SP STEP
 V-243/V-244

	PH	RANGE	TIME
13/46 (30 MIN)	9.5	9.0-10.0	4:40A
14/47 (60 MIN)	9.5	9.0-10.0	5:10A
15/48 (2 HRS)	9.5	9.0-10.0	6:10A
16/49 (3 HRS)	9.7	9.0-10.0	7:10A
16/49 (4 HRS)	9.0	9.0-10.0	8:10A
17/50 (FINISH)	7.9	7.5-8.5	8:55A

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 ____

128 WHILE STRIKING RUN 30" (234 G) WATER INTO V-339
 129 ADD IN 7-8 MIN 350 530-A 350
 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 ~~49~~ " & CALC ~~49~~ " 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 ASSUME 50% 160 7-D 80

137 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 138 SIFT IN ✓ 100 128-A 100
 SV 139 SP STEP 23/53. RECORD: PH ~~3.5~~ (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 ~~9.2~~ (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)
 142 OPERATOR STEP PB 9.15 9:20A
 143 SP STEP 29/58. RECORD: PH ____ & TIME ____
 144 OPERATOR STEP PB
 145 SP STEP 60. BATCH COMPLETE.

START
 TIME SP STEP
 6:00P
 FA

FINISH
 TIME SP STEP
 11:00P
 9:20 A

OPTR
 235
 120-126