

CG 03 CODE KY-787-D PKG

LOT DATE DEC-17 80 38291

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

()

COMTYP JOB NAME: XOB17:787Q

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	13411	93	2400
14	YC002B		93	
14	YC002B		93	

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

TOTAL EST'D WGT 3332

DEC 19, 1980

NON-BLEEDING

Homog #3 - 2nd Pass

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	245	983-D	245
263	3 DUMP IN AND STIR 5 MIN RECORD: START 2:45 PM FIN 2:50 PM	48X50 2400	YC-2-B	2400
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU			
	6 HOMOG AT 2400-2600 PSI INTO V-203			
	7 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN			
	8 OF HOT WATER AT 2400-2600 PSI INTO V-203			
	9 RECORD: V-203 VOL " & ADJ TO 60" (2100 G)			
	10 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	11 RUN 10" (514 G) WATER INTO V-243 & START			
263	12 AGITATOR			
SV	13 PUMP V-243 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	14 RECORD: TIME START 12:45A TOTAL MINUTES 130			
	15 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI,			
	16 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-203			
	17 WHEN V-203 MT, RUN IN 5" (240 G) WATER & PUMP			
	18 THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	19 SP STEP 01 - SET FORMULA SELECTOR TO POSITION			
&	20 2 (V-243) OR POSITION 7 (V-244)			
CP	21 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	22 REMOTE (TEMP IS SET AT 190-194°F)			
3	23 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	24 A. 11LG 43.2% PRESET #1 80 GAL		15-A	160
	25 B. 13LG 34% PRESET #6 135 GAL		20-A	135
	26 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	27 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM		27-D	206
	28 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	29 3FR10 (N-27-D/WATER) RATIO 1.35			
	30 8FC10 (N-32-D CONTROLLER) IN MANUAL 0.50 GPM		983-D	1405
	31 8FC20 (N-32-D WATER) IN MANUAL LOCAL 4.55 GPM			
	32 8FC20 (N-32-D WATER) IN REMOTE			
	33 8FR10 (N-32-D/WATER) RATIO 1.82			

PUNCHED & CHECKED
DEC 30 1980

V-243

LBS CODE LBS

16 OPERATOR STEP PB
 320 17 RECORD LEVEL 2LG 53% IF BELOW 35% FOLLOW SOL'N
 SV MAKE-UP PROCEDURE FOR N-27-D
 SP 18 ADJUST SV TO 48" (2470 G)
 CP 19 RECORD PH 9.9 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 11.1 ASSUME 50% 30 7-D 15
 120 OPERATOR STEP PB

21 SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.7
 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

	PH	RANGE	TIME
13/46 (30 MIN)	<u>9.5</u>	9.0-10.0	<u>7:05</u>
14/47 (60 MIN)	<u>9.5</u>	9.0-10.0	<u>7:35</u>
15/48 (2 HRS)	<u>9.5</u>	9.0-10.0	<u>8:35</u>
16/49 (3 HRS)	<u>9.4</u>	9.0-10.0	<u>9:35</u>
16/49 (4 HRS)	<u>9.4</u>	9.0-10.0	<u>10:35</u>
17/50 (FINISH)	<u>7.0</u>	7.5-8.5	<u>11:20</u>

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

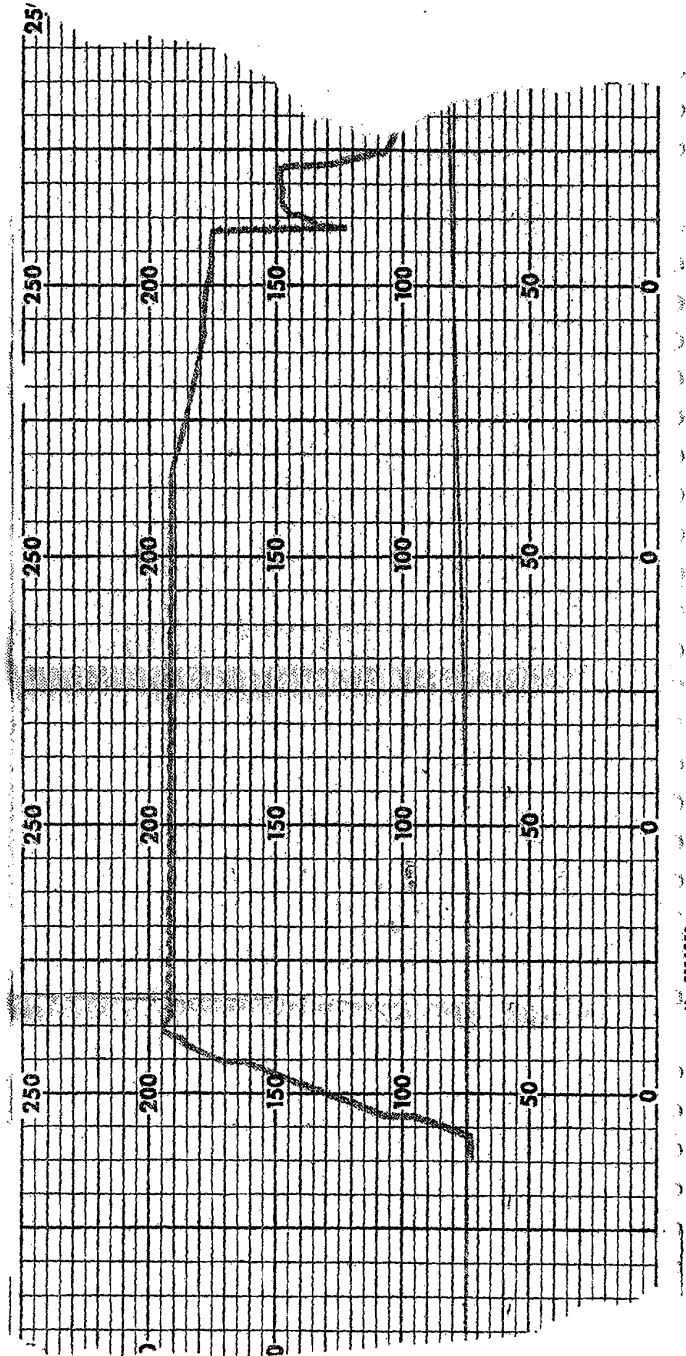
6:25 AM

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 10.2 (9.5-10.5)
 32 STIR 15 MIN OR LONGER FOR SP STEP 26
 33 RECORD: VOL 51 * & CALC 51 * X 0.78 = 39.8 GAL
 34 SET PRESET #8 TO 39.8 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

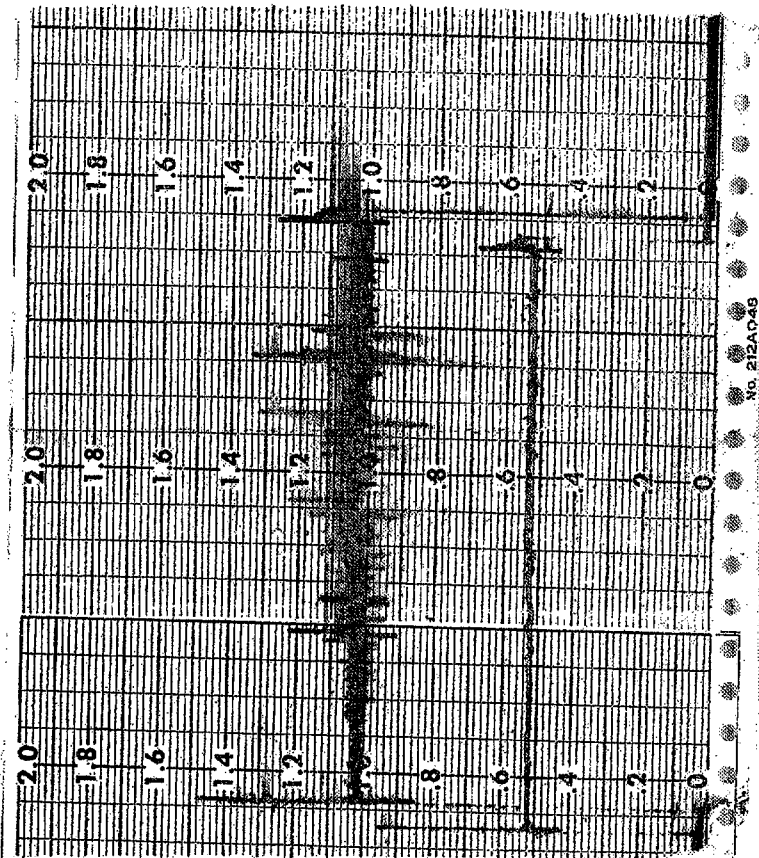
37 SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.
 38 SIFT IN ✓ 100 128-A 100
 SV 39 SP STEP 23/53. RECORD: PH 3.2 (3.7-4.2)
 SP 40 RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5
 MIN
 8 41 RECORD: PH 9.25 (9.0-9.5). ADJ IF NECESSARY &
 RECORD: PH ____ ASSUME 77%
 (DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%
 (SIPHON N-7-D INTO SV)
 42 OPERATOR STEP PB
 43 SP STEP 29/58. RECORD: PH 9.1 & TIME 11:50 AM
 44 OPERATOR STEP PB
 45 SP STEP 60. BATCH COMPLETE. Pump to V-240

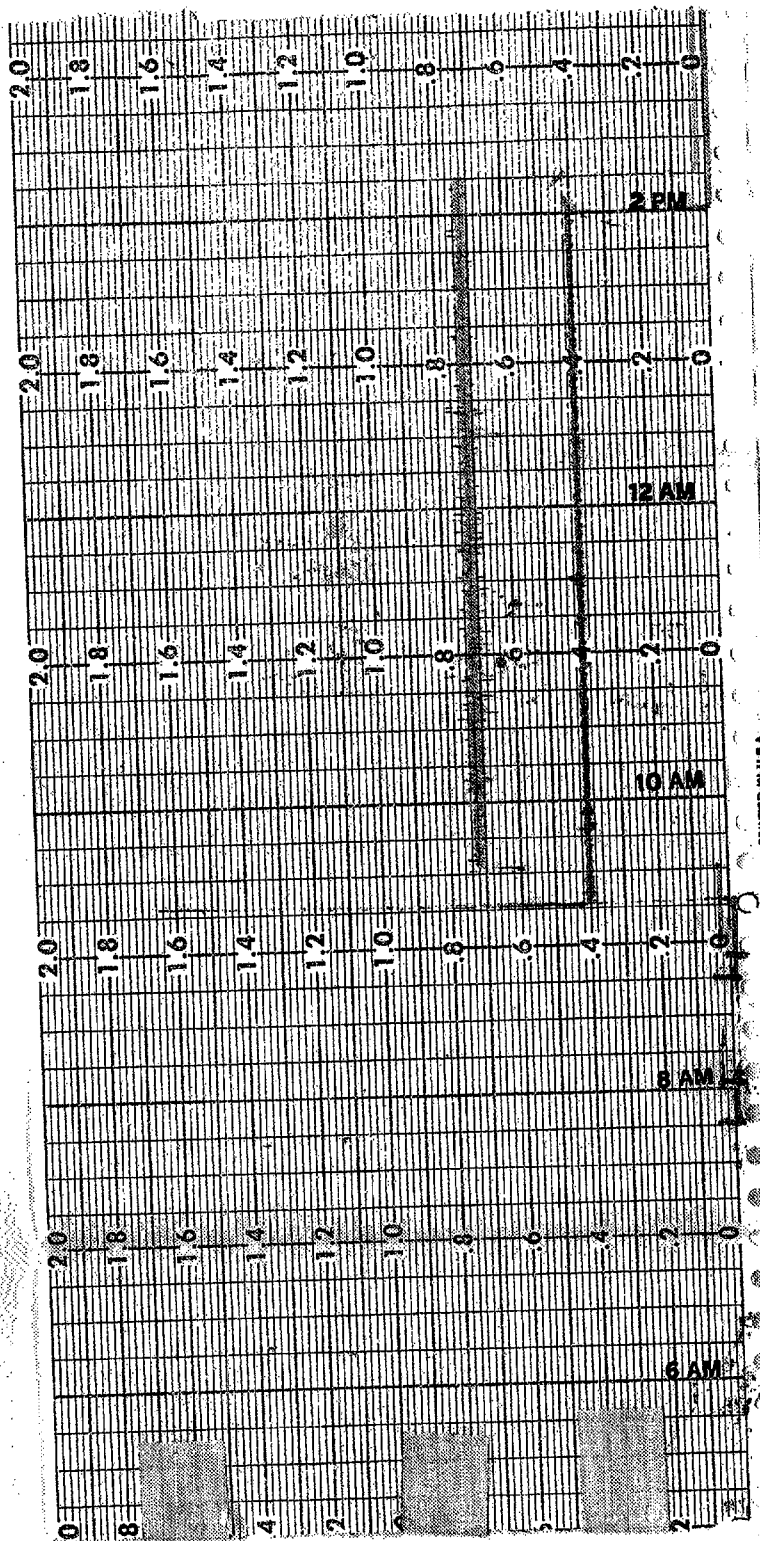
START	FINISH	OPTR
TIME SP STEP	TIME SP STEP	
<u>3:00 P</u>	<u>11:00 P</u>	<u>209-100</u>
<u>11:00 P</u>	<u>7:00 A</u>	<u>2:35 - 137</u>
<u>7:00 AM</u>	<u>11:55 AM</u>	<u>201-223</u>



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