

CG 03 CODE KY-787-D PKG
LOT 38185 DATE 12/10/80
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
()
COMTYP JOB NAME: XOB17:787Q

COMPONENT CONSUMPTION				
CG	CODE	LOT	PQ	LBS
14	YC002B	<u>13371</u>	93	<u>2400</u>
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 11 1980

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ACCT LBS
203 & 205 263	1/ RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
263	2/ WEIGH IN DRUM & POUR IN	245	9B3-D	245
1	3/ DUMP IN AND STIR 5 MIN RECORD: START <u>11:20 AM</u> FIN <u>12:20 PM</u>	48X50 <u>2400</u>	YC-2-B	2400
	4/ ADJUST TO 75" (1275 G)			
	5/ WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205 263			
	6/ WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-203			
	7/ RECORD: V-203 VOL <u>4.8</u> & ADJ TO 60" (2100 G)			
	8/ INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203 263 SV	9/ RUN 10" (514 G) WATER INTO V-203 START AGITATOR.			
2	10/ PUMP V-203 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START <u>12:30 PM</u> TOTAL MINUTES <u>240</u>			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	11/ WHEN V-203 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 <u>28</u> % PRESET #1 80 GAL B. 13LG <u>4.8</u> % PRESET #6 135 GAL		15-A 20-A	160 135
	15/ SET STRIKE FLOW CONTROLLERS AS FOLLOWS: 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.39 GPM 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 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		27-D 9B3-D	206 1405

320	16	OPERATOR STEP PB	243			
SV	17	RECORD LEVEL 2LG 76% IF BELOW 35% FOLLOW SOL'N				
SP	18	MAKE-UP PROCEDURE FOR N-27-D				
CP	18	ADJUST SV TO 48" (2470 G)				
	19	RECORD PH 10.1. 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 11.4. ASSUME 50%		30	7-D	18
	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				
	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 9.6	RANGE 9.0-10.0	TIME 1:00	12:30
		14/47 (60 MIN)	9.5	9.0-10.0	1:30	
		15/48 (2 HRS)	9.5	9.0-10.0	2:30	
		16/49 (3 HRS)	9.4	9.0-10.0	3:30	
		16/49 (4 HRS)	9.5	9.0-10.0	4:30	
		17/50 (FINISH)	9.7	7.5-8.5	5:15	
		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				
339	30	ADJ TO 49" (382 G) AT 80-100°F			350	530-A 350
6	31	STIR 5 MIN & RECORD: PH 10.8 (9.5-10.5)				
	32	STIR 15 MIN OR LONGER FOR SP STEP 26				
	33	RECORD: VOL 47" & CALC 47" X 0.78 = 38.4 GAL				
	34	SET PRESET #8 TO 37.2 GAL FROM S 33				
302	35	RUN 30" (360 G) WATER INTO V-302				
7	36	ADD & STIR 2 MIN FOR S 40			160	7-D 80
	37	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.				
	38	SIFT IN			100	12B-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 9.4 (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 9.2 & TIME ____				
	44	OPERATOR STEP PB				
	45	SP STEP 60. BATCH COMPLETE.				
	46	PUMP TO VAT 240				
		START TIME SP STEP				
		FINISH TIME SP STEP				
		OPTR				
		2:00 PM			32	
		1:15 PM			182	