

CG 03 CODE KY-787-D PKG
 LOT DATE DEC-15 80 38253
 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	CG	CODE	LOT	PQ	LBS
14	YC002B	13371	93	400	14	YC002B	13371	93	400
14	YC002B	13411	93	2000	14	YC002B	13411	93	2000
14	YC002B		93		14	YC002B		93	

TOTAL EST'D WGT 3332

NON-BLEEDING

EQUIP	NAME : "KROLOR" YELLOW-MEDIUM	USE LBS	N- CODE	ADCT LBS
203	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN DUMP IN AND STIR 5 MIN	245	983-D	245
	RECORD: START 2:45 PM	48X50	YC-2-B	2400
	FIN 3: PM	400		
		2000		
	ADJUST TO 75" (1275 G)			
	WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	RECORD: V-205 VOL 43" & ADJ TO 60" (2100 G)			
	INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	7 RUN 10" (514 G) WATER INTO V-243 & START AGITATOR			
SV	110 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 3:45 PM TOTAL MINUTES 115			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
SP	112 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 2 (V-243) OR POSITION 7 (V-244)			
CP	113 PRESS SV CAM RESET PB - SET 22 TC IN AUTO			
	REMOTE (TEMP IS SET AT 190-194°F)			
3	114 RECORD LEVELS & SET R/M COUNTER #1 AS FOLLOWS:			
	A. 11LG 36% PRESET #1 80 GAL	15-A		160
	B. 13LG 22% PRESET #6 135 GAL	20-A		135
	115 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			

Homog #4 - 2nd Pass

N34771

			LBS	CODE	LBS
	V-243				
320	16	OPERATOR STEP PB			
SV	17	RECORD LEVEL 2LG 86% IF BELOW 35% FOLLOW SOL'N			
SP	18	MAKE-UP PROCEDURE FOR N-27-D			
CP	19	ADJUST SV TO 48" (2470 G)			
	20	RECORD PH 9.5. ADJ TO 11.1-11.3 WITH N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4	21	SIPHON INTO SV. RECORD: PH 11.2 ASSUME 50%	26	7-D	13
	22	OPERATOR STEP PB			
	23	SP STEP 06/39. AFTER HEAT-UP RECORD: PH 9.8			
SV	24	SWITCH 3FC20, 8FC10, & 8FC20 TO AUTO			
SP	25	OPERATOR STEP PB			
	26	SP STEP 10/43. WHEN 3FC20, 8FC10 & 8FC20 FLOWS ARE IN LIMITS, SWITCH 3FC10 TO AUTO & PB			
5	27	SP STEP 11/44. WHEN 3FC10 & 3FC20 FLOWS ARE IN LIMITS, SWITCH 3FC20 TO REMOTE			
	28	OPERATOR STEP PB			
	29	DURING STRIKE RECORD:			
		SP STEP			
		V-243/V-244			
		PH RANGE TIME			
		13/46 (30 MIN) 9.5 9.0-10.0 7:10			
		14/47 (60 MIN) 9.5 9.0-10.0 7:40			
		15/48 (2 HRS) 9.5 9.0-10.0 8:40			
		16/49 (3 HRS) 9.5 9.0-10.0 9:40			
		16/49 (4 HRS) 9.4 9.0-10.0 10:40			
		17/50 (FINISH) 9.2 7.5-8.5 11:25			
		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	
	30	WHILE STRIKING RUN 30" (234 G) WATER INTO V-339			
	31	ADD IN 7-8 MIN	350	530-A	350
339	32	ADJ TO 49" (382 G) AT 80-100°F			
6	33	STIR 5 MIN & RECORD: PH 9.1 (9.5-10.5)			
	34	STIR 15 MIN OR LONGER FOR SP STEP 26			
	35	RECORD: VOL 4.9" & CALC 4.9" X 0.78 = 38.2 GAL			
	36	SET PRESET #8 TO 38.2 GAL FROM S 33			
302	37	RUN 30" (360 G) WATER INTO V-302			
7	38	ADD & STIR 2 MIN FOR S 40 ASSUME 50%	160	7-D	80
	39	SP STEP 17/50 AFTER CHECKING PH, OPERATOR PB.			
	40	SIFT IN	100	128-A	100
SV	41	SP STEP 23/53. RECORD: PH 3.7 (3.7-4.2)			
SP	42	RUN IN N-7-D FROM S 36 IN 10-12 MIN & STIR 5 MIN			
8	43	RECORD: PH 9.5 (9.0-9.5). ADJ IF NECESSARY & RECORD: PH ____ ASSUME 77%		27-D	
	44	(DILUTE 10 PARTS WATER TO 1 PART) ASSUME 50%		7-D	
	45	(SIPHON N-7-D INTO SV)			
	46	OPERATOR STEP PB			
	47	SP STEP 29/58. RECORD: PH 9.2 & TIME 12:15 PM			
	48	OPERATOR STEP PB			
	49	SP STEP 60. BATCH COMPLETE. Pump To V-240			
		START TIME SP STEP	FINISH TIME SP STEP	OPTR	
		9:00 AM	11:00 AM	120-54	
			7:00 AM	235	