

244 (Automated)

CG 03 CODE KY-795-D PKG.

C.V.

PUNCHED & CHECKED

D.V.

EST. WGT. 1162 LBS. 34723

MAR - 1980

STD. HRS. 8.2

TIME

14 YC-2-B 93 4 Lot 24478

14 YC-2-B 93 4 Lot

14 YC-2-B 93 4 Lot

MAR - 7 1980

PROCESSES		APPROVED B
() KY-795-D (H)		EWK 10-05-76
()	()	DCG 10-07-76
()	()	MTW 10-11-76
()	()	FWP 12-22-78
TYPED BY		
CHRW122278		

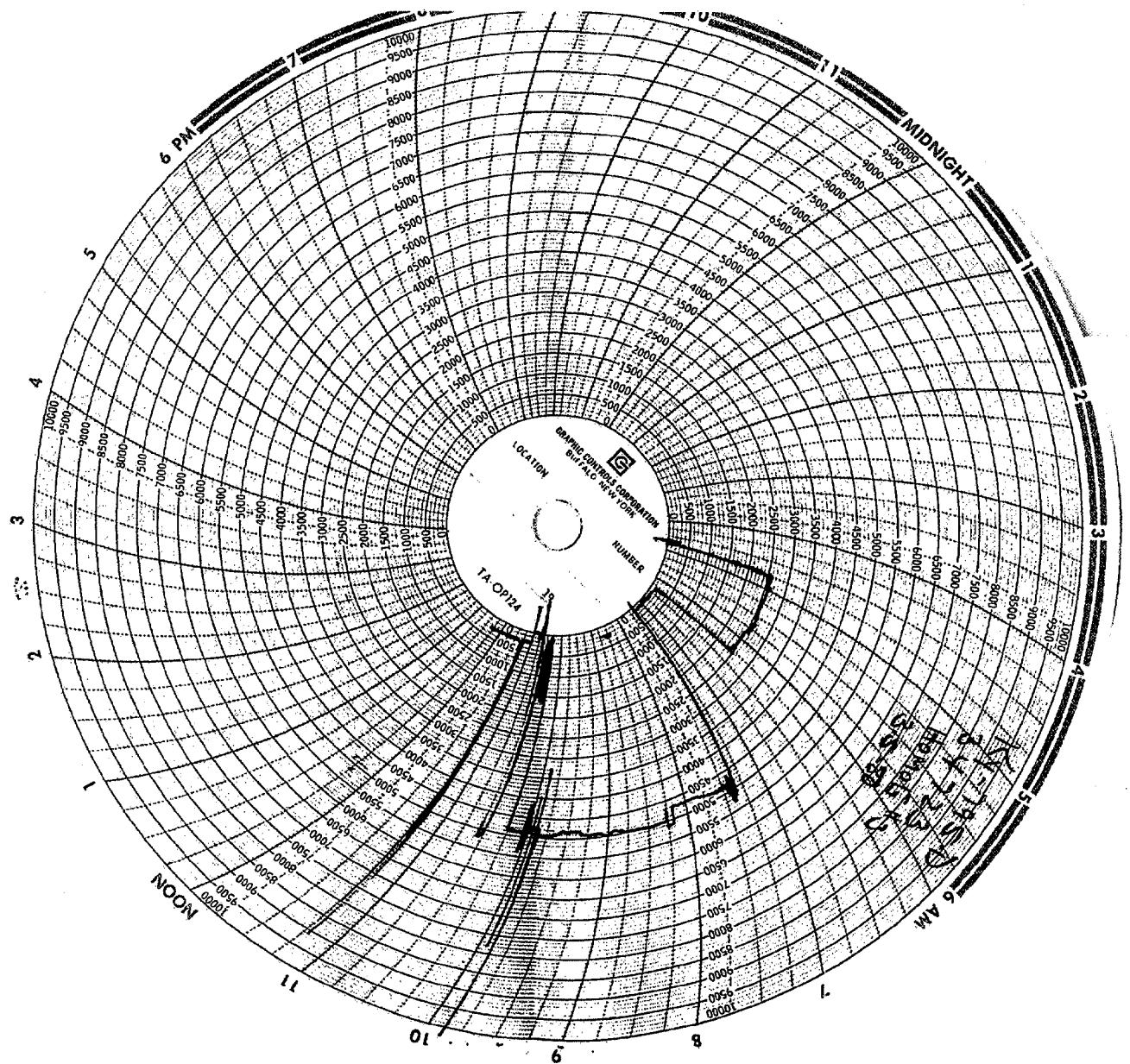
PUNCHED & CHECKED 3-1ST PASS

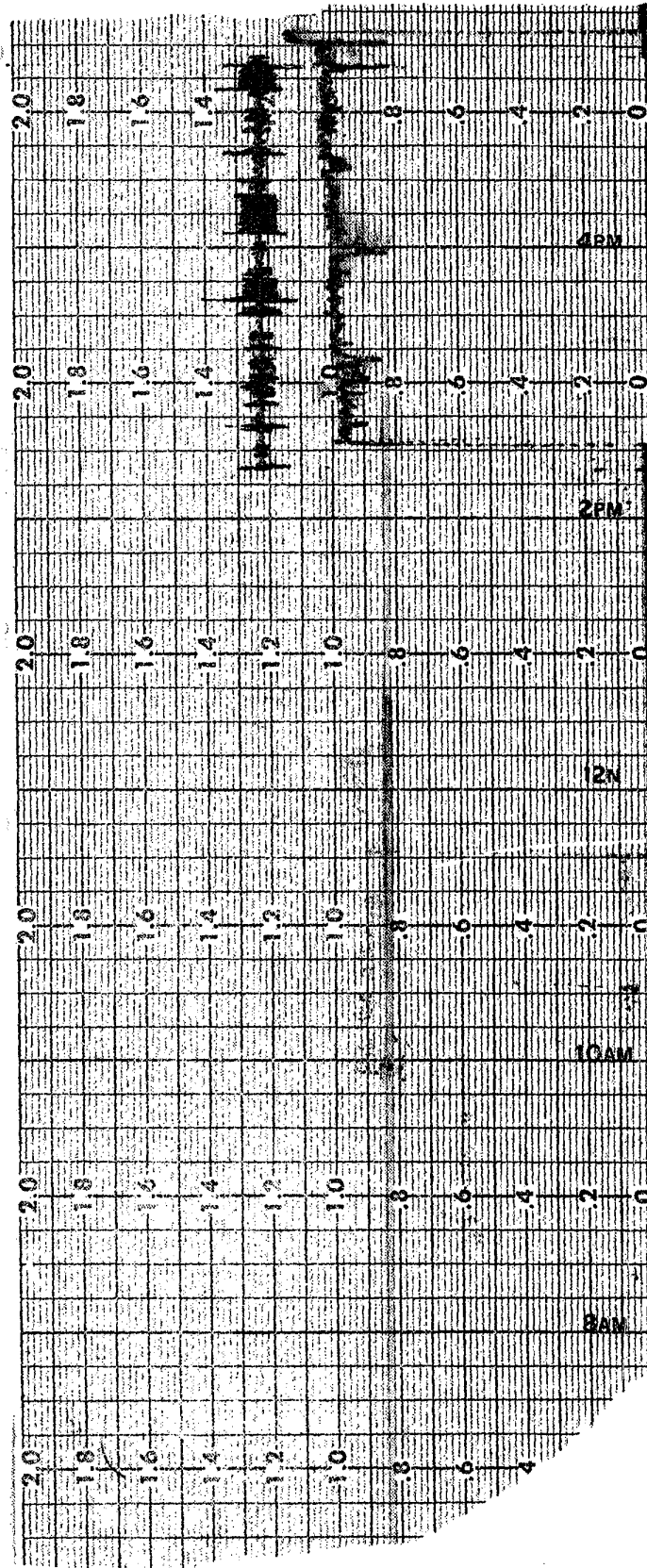
Total Wgt. 4612#

NON-BLEEDING

IPMENT	NAME: KROLOR® YELLOW MEDIUM	USE LBS.	N CODE	ACC1 LBS.
203	Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED			
&	Weigh in drum & pour in	475	32-D	475
205	Dump in & stir 5 min	78 x 50	YC-2-B	3500
1	Record: Start 2:35-AM.			3450
	Fin 3:20 AM			
	Adj to 78" (1328 G)			
	Pump V-203 thru Homog at 2400-2600 psi into V-205			
	When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water - Use Hot Water			
	Record: V-205 Vol 140 " & adj to 51" (1874 G)			
	Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205	Run 10" (514 G) water into V-205 & start agitator			
&	Pump V-205 thru Homog at 4800-5200 psi into V-203			
SV	Record: Time Start 7:20 Total Min 1:25			
2	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
	When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi. Rinse in using Hot Water			
SP & CP	SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (V-244)			
3	Press SV Cam Reset PB set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
	Record levels and set Raw Material Counter #1 as follows:			
	a. 11 LG 34 % - preset #1 104 Gal		15-A	208
	Set stroke flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.95 GPM		27-D	394
	b. 3FC20 (N-27-D Water) in Manual Local 7.7 GPM			
	c. 3FR10 (N-27-D / Water Ratio) 0.8			
	d. 3FC10 (N-32-D Controller) in Manual 1.27 GPM		32-D	2675
	e. 3FC20 (N-32-D Water) in Manual Local 6.2 GPM			
	f. 3FC20 (N-32-D Water) in Remote			
	g. 3FR10 (N-32-D / Water) Ratio 1.0			
SV	Operator Step PB			
SP & CP	Record Level 2 LG 92% if below 35% follow solution make-up procedure for N-27-D			
4	Adj SV to 68" (3495 G)			
	Record: pH 10.7 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D) Assume 50%	2.5	1-D	
	Siphon N-7-D into SV & Record: pH 11.4			
	Operator Step PB			

INSTRUMENT	PAGE 2	CG 03 CODE	KY-795-D (H) EST. WGT.	4612 LBS.	USE LBS.	N CODE	ACC LBS
SV	21	SP Step 06/39 - After heat up Record: pH <u>10.1</u> (9.5-10.0)					
SP	22	Switch 3FC20, 8FC10, 8FC20, to Auto					
&	23	Operator Step PB					
CP	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits switch 3FC10 to Auto, Operator Step PB					
5	25	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote					
	26	Operator Step PB					
	27	During Strike, Record pH & Time as follows: <u>1:50 PM</u>					
		SP Step					
		V-243/V-244	pH	Range	Time		
		13/46 (30 min)	<u>9.9</u>	9.0-10.0	<u>8:20 PM</u>		
		14/47 (60 min)	<u>9.9</u>	9.0-10.0	<u>2:30 PM</u>		
		15/48 (2 hrs)	<u>9.8</u>	9.0-10.0	<u>3:30 PM</u>		
		16/49 (3 hrs)	<u>9.8</u>	9.0-10.0	<u>4:50 PM</u>		
		17/50 (Final)	<u>8.9</u>	7.5- 8.5	<u>5:35 PM</u>		
		NOTE: If not as specified notify Supervisor & note in log					
		If final pH above 8.5 adj to 7.5-8.5					
		& Record: pH			Assume 77%	27-D	
Drum	28	Wtgh into 55 Gal Drum			Assume 50%	56	7-D 28
7	29	Fill with water & stir 2 min					
SV	30	SP Step 17/50 - After checking pH, Operator Step PB					
SP	31	Step 23/53 - Record: pH <u>3.7</u> (3.3-3.7)					
&	32	If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH				15-A	
CP	33	Sift in 3 bags			200 150	128-A	150
8	34	Siphon in N-7-D from S 29 in 10-12 min & stir 5 min					200
	35	Record: pH <u>4.2</u> (4.0-4.2) & if necessary adj to pH 4.0-4.2					
		& Record: pH			Assume 77%	27-D	
		(Dilute 10 parts water to 1 part N-7-D)			Assume 50%	7-D	
		Siphon N-7-D into SV					
	36	Operator Step PB					
	37	SP Step 24/54 - Pour in & stir 15 min			22	978-A	22
	38	Operator Step PB					
	39	SP Step 60 - Batch complete					



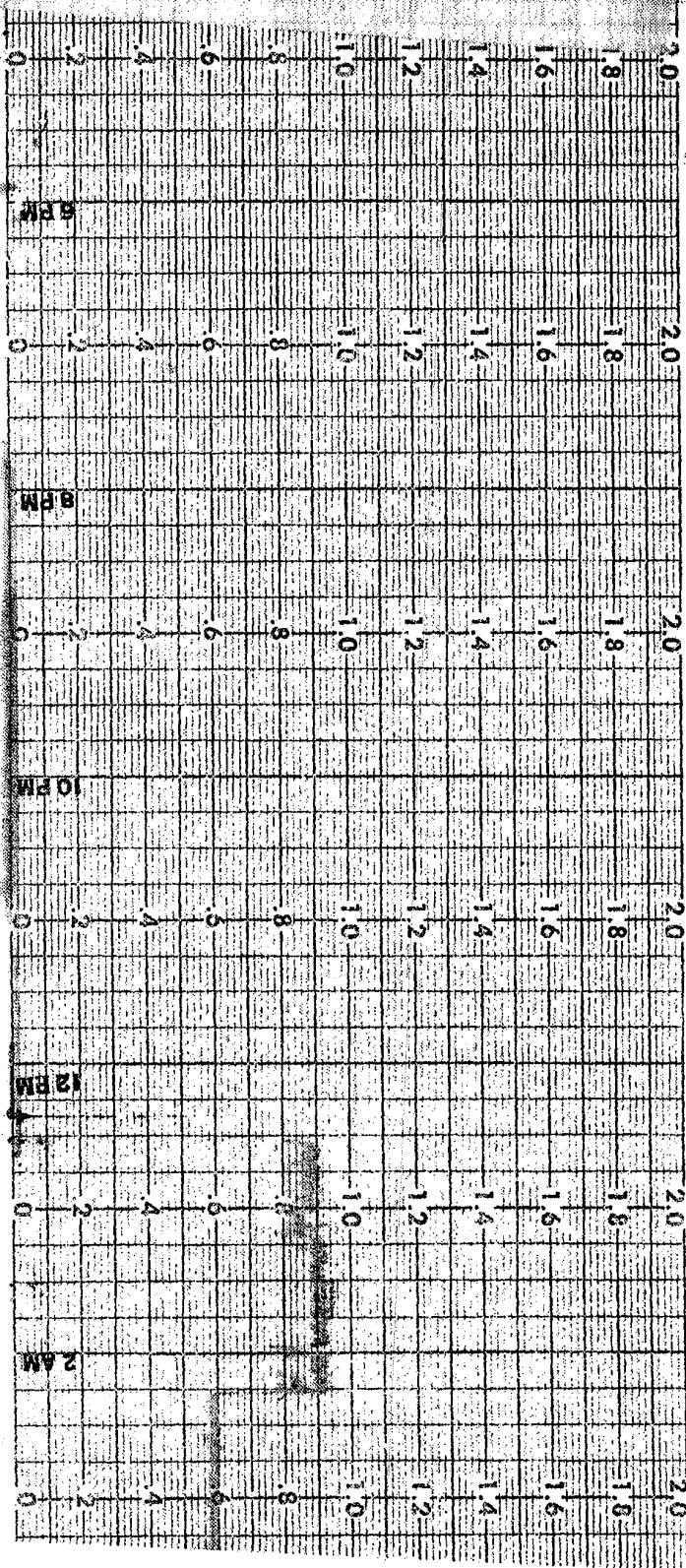


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