

243 (Automated) C.V.

D.V.

CG 03 CODE KY-787-D PKG.

MAR-3 34638

EST. WGT. 1090 990 LBS.

STD. HRS. 8.9 TIME

14 - YC-2-B 98 4 Lot 24480. 22 APPROACHED & CHECKED
Lot 24079. 200
Lot #

MAR - 4 1980

PROCESSES	APPROVED BY
() KY-787-D	() EWK 9/22/76
()	() DCG 9/27/76
()	() MTW 9/30/76
()	()
TYPED BY	
N.E. 2/12/77	

Total Wgt. - 3490# 3390

NON-BLEEDING

INPIMENT	NAME:	USE LBS.	N CODE	ACCT LBS.
	"KROLOR" - YELLOW MEDIUM			
203	1 Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED			
8	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start 5:40 - A.M. 24480 (4V)			
	End 6:10 - A.M. 24079 (4)			
	15" (1275 G)			
	4 Adj to 30" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water			
	7 Record V-205 Vol 44 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205	9 Run 10" (514 G) water into SV & start agitator			
8	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time start 7:35 PM Total Min 150			
2	NOTE: "If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205"			
	11 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
SP	12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
8	13 Press SV Cam Reset PB-set 22TC in Auto Remote			
CP	(Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 6.5% - preset #1 80 Gal 15-A 160			
	b. 13LG 2.5% - preset #6 135 Gal 20-A 135			
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.83 GPM 27-D 275			
	b. 3FC20 (N-27-D Water) in Manual Local 5.28 GPM			
	c. 3FR10 (N-27-D/Water Ratio) 0.64			
	d. 8FC10 (N-32-D Controller) in Manual 1.08 GPM 32-D 1840			
	e. 8FC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water Ratio) 0.83			
SV	16 Operator Step PB			
SP	17 Record Level 2 LG 44 %. If below 35% follow solution make-up procedure for N-27-D			
8	18 Adj to 48" (2470 G)			
CP	19 Record pH 10.4			
4	20 Adj to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% 70 7-D 10			
	(10 parts water to 1 part N-7-D)			
	Siphon into SV. Record pH 11.3			
	21 Operator Step PB			

JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACC LBS.
SV SP & CP 5	22	SP Step 06/39 - After heat up Record: pH <u>10.0</u> (9.5-10.0)						
	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
	24	Operator Step PB						
	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits Switch 3FC10 to Auto. Operator Step PB						
	26	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote.						
	27	Operator Step PB						
	28	During strike, record pH & time as follows: <u>10:45 PM</u>						
		SP STEP						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	<u>9.8</u>	9.0-10.0	<u>11:15 PM</u>			
		14/47 (60 min)	<u>9.8</u>	9.0-10.0	<u>11:45 PM</u>			
		15/48 (2 hrs)	<u>9.8</u>	9.0-10.0	<u>12:45 PM</u>			
		16/49 (2 hrs 25 min)	<u>9.8</u>	9.0-10.0	<u>1:10 PM</u>			
		17/50 (3 hrs Final)	<u>8.4</u>	7.5-8.5	<u>1:45 PM</u>			
		NOTE: If not as specified notify Supervisor & note in log						
		If final pH is Above 8.5, add pH to 7.5-8.5 &						
		Record: pH Assume 77%					27-D	
339 6	29	White striking, run 30" (234 G) water into V-339						
	30	Add in 7-8 min				350	530-A	350
	31	Add to 49" (382 G) at 80 - 100°F						
	32	Stir 5 min & record pH <u>10.0</u> (9.5-10.5)						
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol. <u>4.9</u> & calculate <u>4.9</u> (Vol) x 0.78 = <u>3.822</u>						
	35	Set preset #8 to <u>38.2</u> G from S 34						
302 7	36	Add 30" (360 G) water to V-302						
	37	Add & stir 2 min For S 41 Assume 50%				160	7-D	80
243 SP & CP 8	38	SP Step 17/50 - After checking pH, Operator Step PB						
	39	Add in 2 Bags				100	128-A	100
	40	SP Step 23/53 - Record: pH <u>4.1</u> (3.7-4.2)						
	41	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
	42	Record: pH <u>9.1</u> (9.0-9.5) & if necessary add pH 9.0-9.5 & 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						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.2</u> (9.0-10.0) Time <u>3:00 AM</u>						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time SP Step	Time SP Step					
		<u>7:45 AM</u>				<u>27-126</u>		
		<u>5:00 PM</u>	<u>11:00 AM</u>			<u>27</u>		
		<u>11:00 PM</u>	<u>3:00 AM</u>			<u>409-381</u>		





