

CG 03 CODE KY-908-D PKG. _____

→ JAN 25 34004

EST. WGT. 949 LBS.

STD. HRS. _____ TIME 7 A M

14 YC-3-B 93 4 Lot 2441, 2600#
 14 YC-3-B 93 4 Lot _____, _____#
 14 YC-3-B 93 4 Lot _____, _____#

PROCESSES		APPROVED BY	
() KY-908-D	(D)	EWK	12/12/77
()	()	DCG	12/14/77
()	()	MW	12/19/77
()	()		
TYPED BY			
ri 1/31/78			

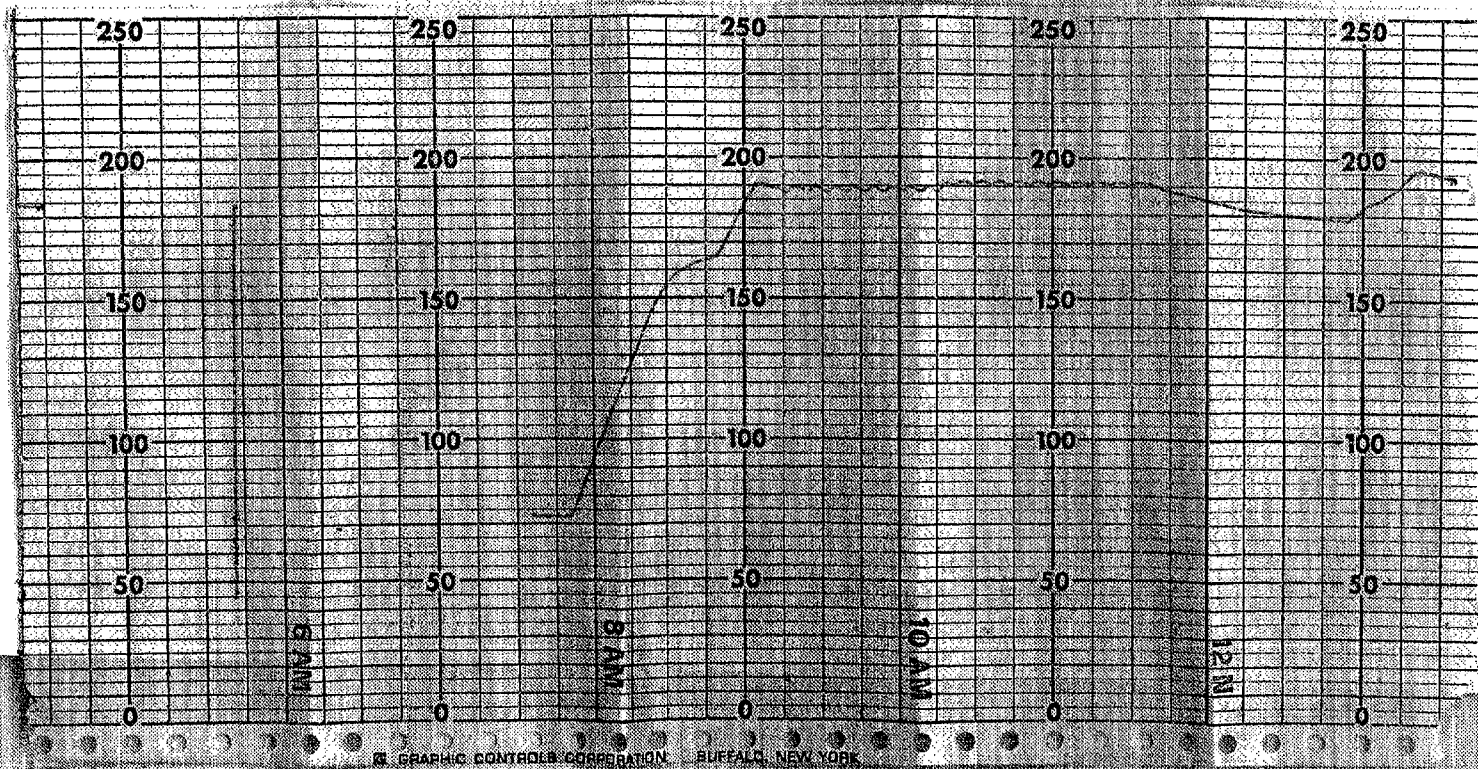
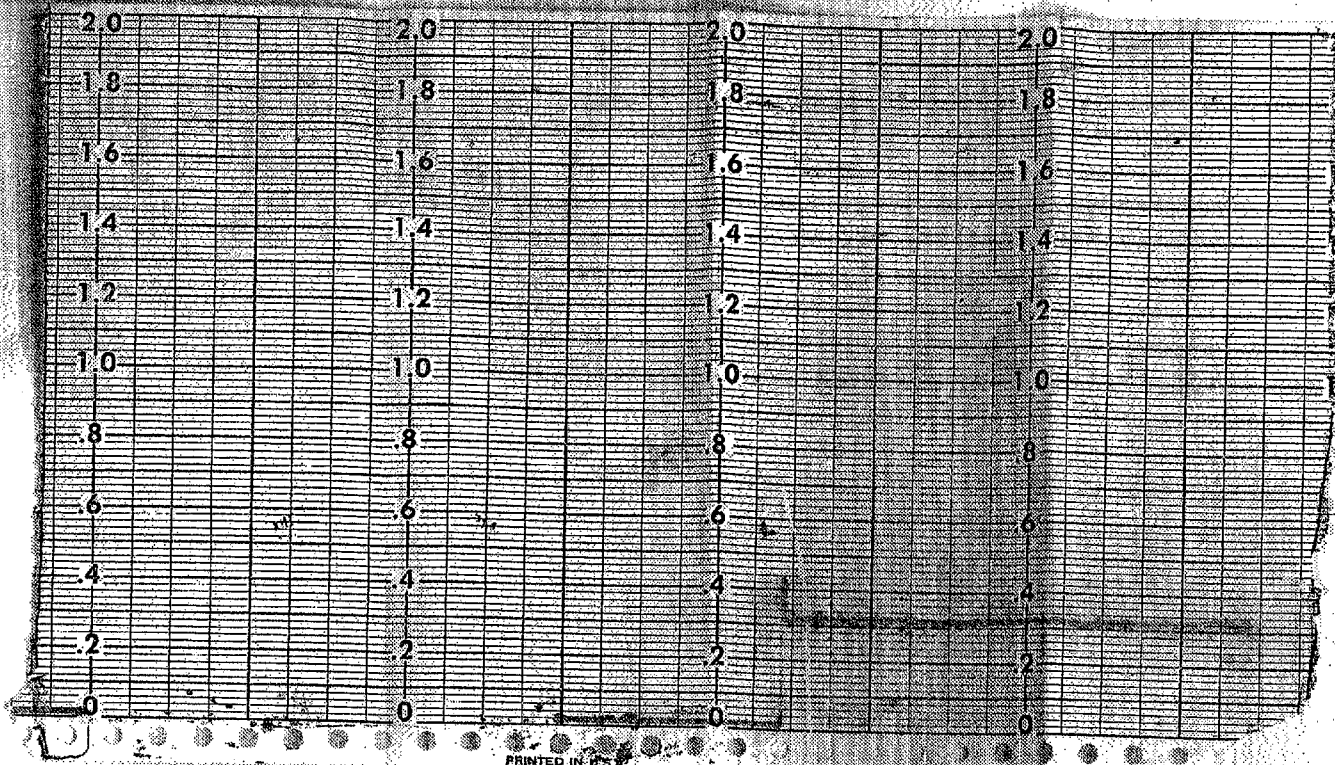
Total Wgt. 3549#

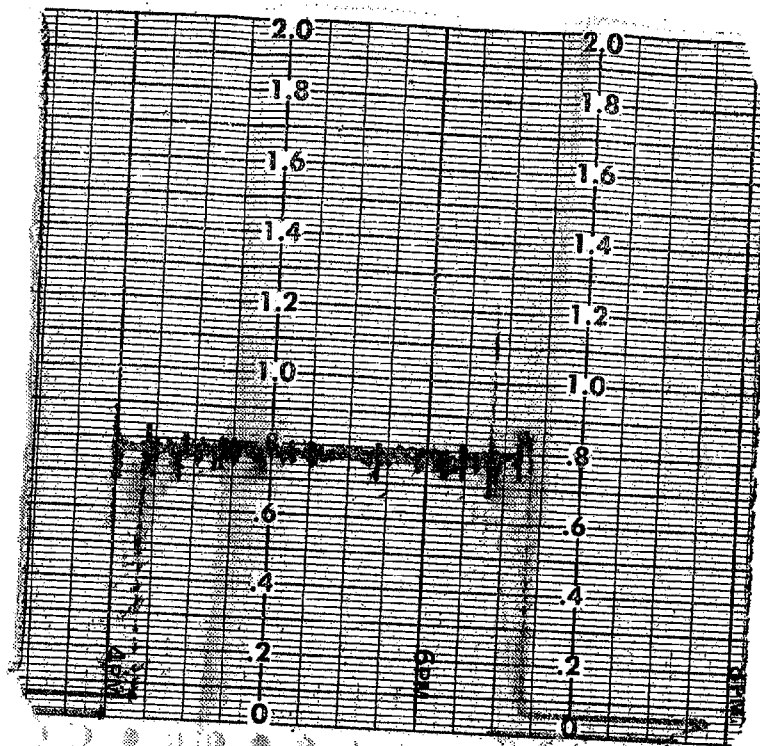
NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203 & 205	60" (9500) KROLORE® YELLOW - LIGHT			
1	Run 23" (360 G) water into V-203			
	2 Pour in	345	32-D	345
	3 Dump in	52 x 50	YC-3-B	2600
	Record: Start 4:30 AM	2641		
	Fin 5 AM			
75 (12756)	80" (1360 G)			
	4 Adj to 70" (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 1800-2200 psi using Minimum water			
	7 Record: V-205 Vol 42" & adj to 60" (2100-G)			
	8 Inspect Homog, strainer & clean if necessary			
205 & SV	9 Run 10" (514 G) water into V-204 & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into V-204			
	Record: Time Start 4:35 PM Total Min 150			
	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 & CP	12 Sp Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
3	13 Press SV Cam Reset PB - Set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
	14 Record levels and set Raw Material Counter #1 as follows			
	11LG 60% - preset #2 208 Gal		15-A	416
	15 Set strike flow controllers as follows			
	a. 3EC10 (N-27-D Controller) In Manual 0.54 GPM		27-D	180
	b. 3FC20 (N-27-D water) in Manual Local 4.4 GPM			
	c. 3FR20 (N-27-D/Water) Ratio 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1215
	e. 8FC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water) Ratio 1.1			
SV SP & CP	16 Operator Step PB			
4	17 Record level 21G-39%. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.8. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	40	7-D	20
	Siphon into SV & Record: pH 11.4			
	20 Operator Step PB			

V-244

EQUIPMENT		PAGE 2 CG 03 CODE KY-908-D (D) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	21	SP Step 06/39 - After heat up Record: pH <u>9.7</u> (9.5-10.0)			
SP	22	Switch 3FC20, 8FC10, 8FC20 to auto			
5	23	Operator Step PB			
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits Switch 3FC10 to Auto. Operator Step PB			
	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:			
		SP Step			
		V-243/V-244			
		13/46 (30 min) pH <u>9.7</u> Range 9.3-10.0 Time <u>9:40</u>			
		14/47 (60 min) pH <u>9.7</u> Range 9.3-10.0 Time <u>10:10</u>			
		15/48 (2 hrs) pH <u>9.7</u> Range 9.3-10.0 Time <u>11:10</u>			
		16/49 (2 hrs 25 min) pH <u>9.7</u> Range 9.3-10.0 Time <u>11:35</u>			
		17/50 (Final 3 hrs) pH <u>9.3</u> Range 7.5- 8.5 Time <u>12:10</u>			
		Note: (1) If pH not as specified notify Supervisor & note in Log (2) If final pH is above 8.5 adj to 7.5-8.5 & Record: pH <u>7.7</u> Assume 78%			
	28	Sift in	<u>12</u> 50	27-D 128-A	8 50
302	29	Add 17" (208G) water to V-302			
6	30	Add & stir 2 min for S57 <u>2-D</u> Assume 50%	100	7-D	50
PT	31	During Strike pump into PT	312	169-A	312
7	32	Pump in	36	155-A	36
	33	Pump in	36	160-A	36
	34	Stir 10 min with lightning mixer for S38			
356	35	During strike Run <u>14"</u> (244G) water into V-356			
8	36	Turn on steam			
	37	Adj to 265° (317G) at 178-182°F <u>81-82°C</u>			
	38	Pump PT mixture from S34 thru undersurface distributor AFAP			
	39	Rinse PT with hot water from hot water mixer & pump in			
	40	Shut off pump <u>81-82°C</u>			
	41	Stir 30 min at 178-182°F for S48			
	42	Do not shut off Agitator			
SV & SP	43	When S28 complete, heat SV to 198-200°F in 5-10 min			
9	44	Close water line & Discharge valves at stearate pump			
	45	Open V-356 Discharge valves to stearate pump inlet			
	46	Open water valve at stearate pump & run water thru Homog at 2900-3100PSI to sewer			
	47	While Homog water at 2900-3100 PSI, open Homog Discharge valve to SV & close Valve to sewer			
	48	Immediately open stearate pump Discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 PSI maintain SV at 198-200°F			
	49	While Homog V-356 to SV, shut off water valve at stearate pump ASAP			
	50	When Homog complete, Rinse in V-356 with hot water from hot water mixer			
	51	When S50 complete turn off Homog & stearate pump			
	52	Stir 5 min at 198-200°F			
	53	Shut off steam			





GRAPHIC CONTROLS CORPORATION - BUFFALO, NEW YORK

