

(244-244) (Automated) C.V.

D.V.

CG 03 CODE KY-787-D

PKG.

DEC 27 33503

EST. WGT. 1090 LBS.

STD. HRS. 8.9 TIME

14 - YC-2-B 98 - 4 Lot 24167 1.200

Lot 24170 1.50

Lot 24081 1.00

24073 950

Total Wgt. - 3490#

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

NON-BLEEDING

MENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
03	6" "KROLOR" - YELLOW MEDIUM			
03	1 Run 10" (992 G) water into V-203 AND ADD	28	7-D	14
05	2 Weigh in drum & pour in	320	32-D	320
1	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 3.30 Lot 24167 1.200			
	Fin 5.35 Lot 24170 1.50			
	Lot 24081 1.00			
	4 Adj. to 70" (1200 G) 2400-2600 24073 950			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 2400			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water			
	7 Record V-205 Vol 40" & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
03	9 Run 10" (514G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V- 244			
2	Record: Time start 3:05 PM Total Min 1.35			
	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 #1 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
CP	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 29% - preset #1 80 Gal 15-A 160			
	b. 13LG 25% - 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. 3ER10 (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. 8ER10 (N-32-D/Water Ratio) 0.83			
SV	16 Operator Step PB			
SP	17 Record Level 2.LG 86%. If below 35% follow solution make-up procedure for N-27-D			
CP	18 Adj to 48" (2470 G)			
4	19 Record pH 10.4			
	20 Adj. to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% 20 7-D 10			
	(10 parts water to 1 part N-7-D)			
	Siphon into SV. Record pH 11.3			
	21 Operator Step PB			

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IPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	AC L
SV	22	SP Step 06/39 - After heat up Record: pH	9.8	(9.5-10.0)				
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
5	26	Switch 3FC10 to Auto. Operator Step PB						
	27	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote.						
	28	Operator Step PB						
	29	During strike, record pH & time as follows:						
		SP STEP						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	9.8	9.0-10.0	8:15 A.M.			
		14/47 (60 min)	9.8	9.0-10.0	8:45 A.M.			
		15/48 (2 hrs)	9.8	9.0-10.0	9:45 A.M.			
		16/49 (2 hrs 25 min)	9.8	9.0-10.0	10:10 A.M.			
		17/50 (3 hrs Final)	9.6	7.5-8.5	10:45 A.M.			
		NOTE: If not as spec. 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	29	While striking, run 30" (234 G) water into V-339						
6	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	10.3	(9.5-10.5)				
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol. 49" & calculate 49" (Vol) x 0.78 = 38.28						
	35	Set preset #8 to 38.28 G from S 34						
302	36	Add 30" (360 G) water to V-302						
7	37	Add & stir 2 min For S 41		Assume 50%		160	7-D	80
243	38	SP Step 17/50 - After checking pH, Operator Step PB						
	39	SIFT in 2 Bags				100	128-A	100
SP	40	SP Step 23/53 - Record: pH	4.1	(3.7-4.2)				
&	41	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
CP	42	Record: pH	9.1	(9.0-9.5) & if necessary add pH 9.0-9.5				
8		& 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	9.2	(9.0-10.0)	Time 11:50 A.M.			
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish		Optr			
		Time	SP Step	Time	SP Step			
		7:00 AM		11:00 AM		438-450		
		11:00 AM		7:00 AM		201-322		
		7:00 AM		11:50 AM		381		



