

CG 03 CODE KY-787-D PKG. _____

FEE 26 34560

EST. WGT. 1090 990 LBS.

STD. HRS. 8.9 TIME 3 P M

14 - YC-2-B 98 4 Lot 24479, 2400#
Lot _____ #
Lot _____ #

PROCESSES		APPROVED BY	
()	KY-787-D	()	FWK 9/22/76
()		()	DCG 9/27/76
()		()	MTW 9/30/76
()		()	
TYPED BY			
CHECKED BY			

PUNCHED & CHECKED
FFR 29 153

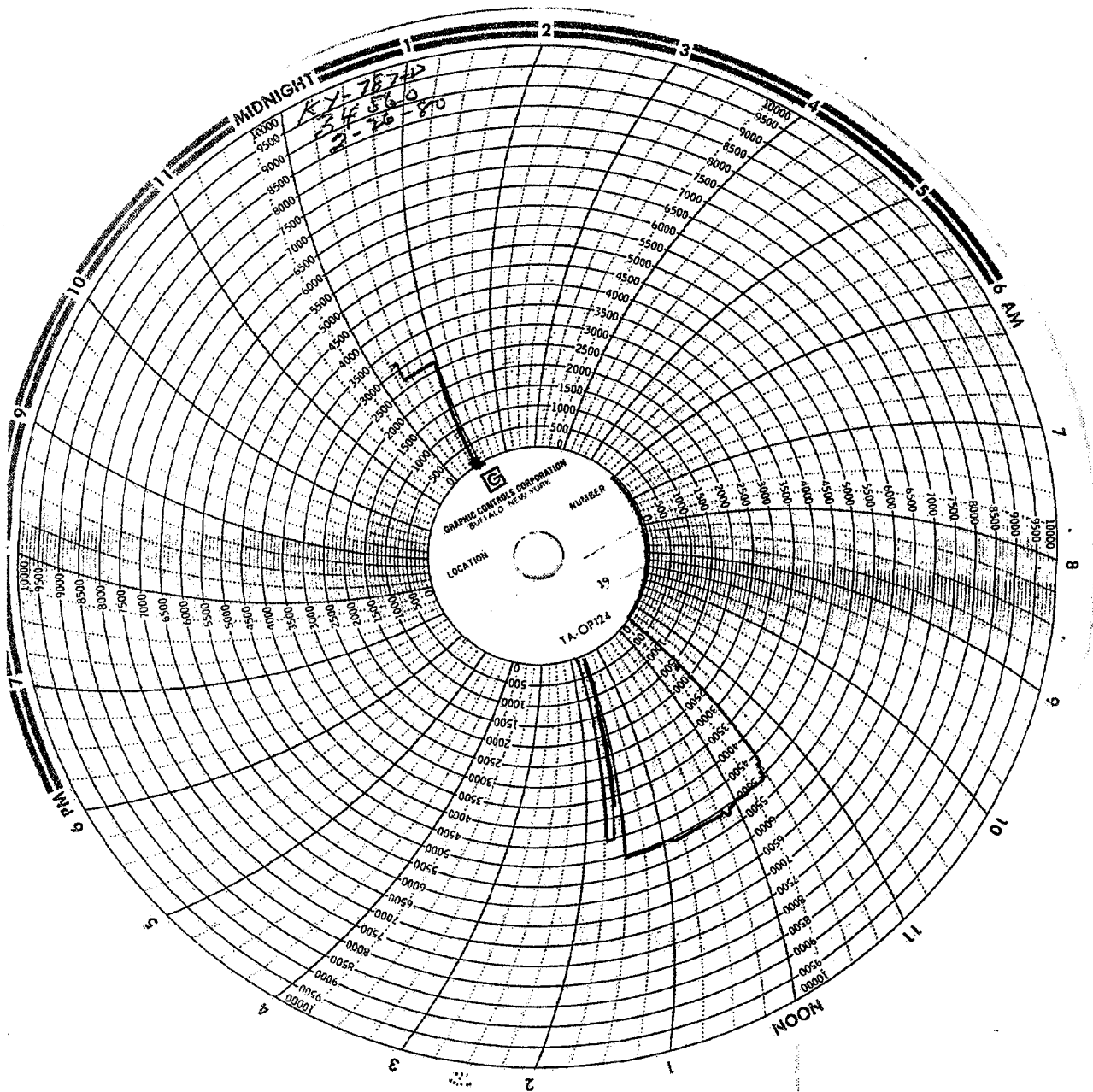
Total Wgt. - 3490# 3390.

NON-BLEEDING

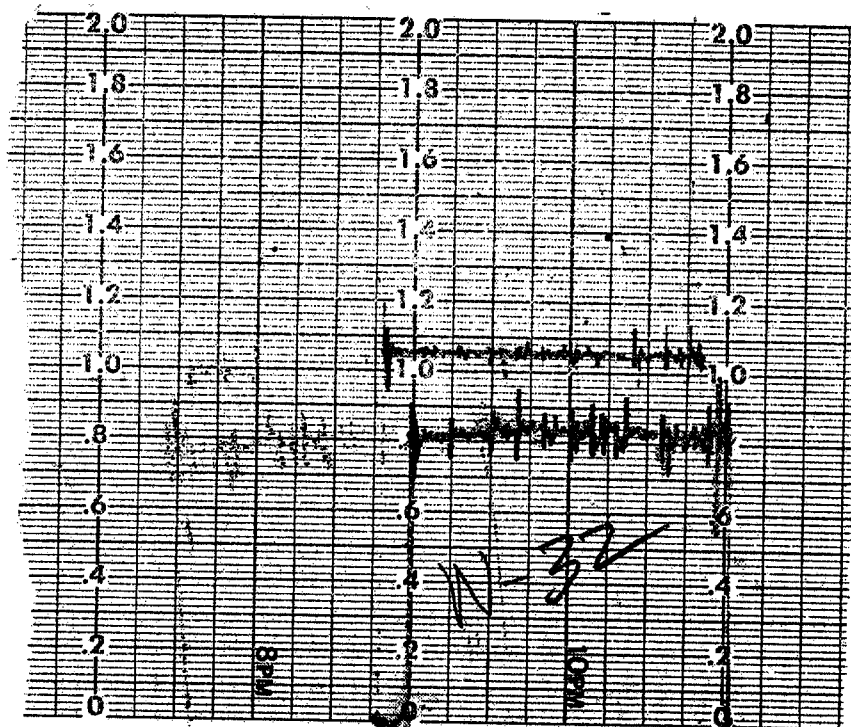
IPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	"KROLOR" - YELLOW MEDIUM			
203	1 Run 60" (992 G) water into V-203. Set agitator on high speed.			
&	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start 11:00 P.M. Fin 12:10 P.M.	24479	2400	
	4 Adj to 70" (1200 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 1800-2000 psi using minimum water			
	7 Record V-205 Vol. 46 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 Run 10" (514 G) water into SV & start agitator			
205	10 Pump V-205 thru Homog at 4800-5200 psi into V- 243			
&	Record: Time start 11:30 AM Total Min 1:25			
SV	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
2	11 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
	12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
SP	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
&	14 Record levels and set Raw Materials Counter #1 as follows:			
CP	a. 11LG 84 % - preset #1 80 Gal		15-A	160
3	b. 13LG 54 % - 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 90 %. If below 35% follow solution make-up procedure for N-27-D			
&	18 Adj to 48" (2470 G)			
CP	19 Record pH 10.6			
4	20 Adj to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% (10 parts water to 1 part N-7-D)	20	7-D	10
	Siphon into SV. Record pH 11.2			
	21 Operator Step PB			

V-243

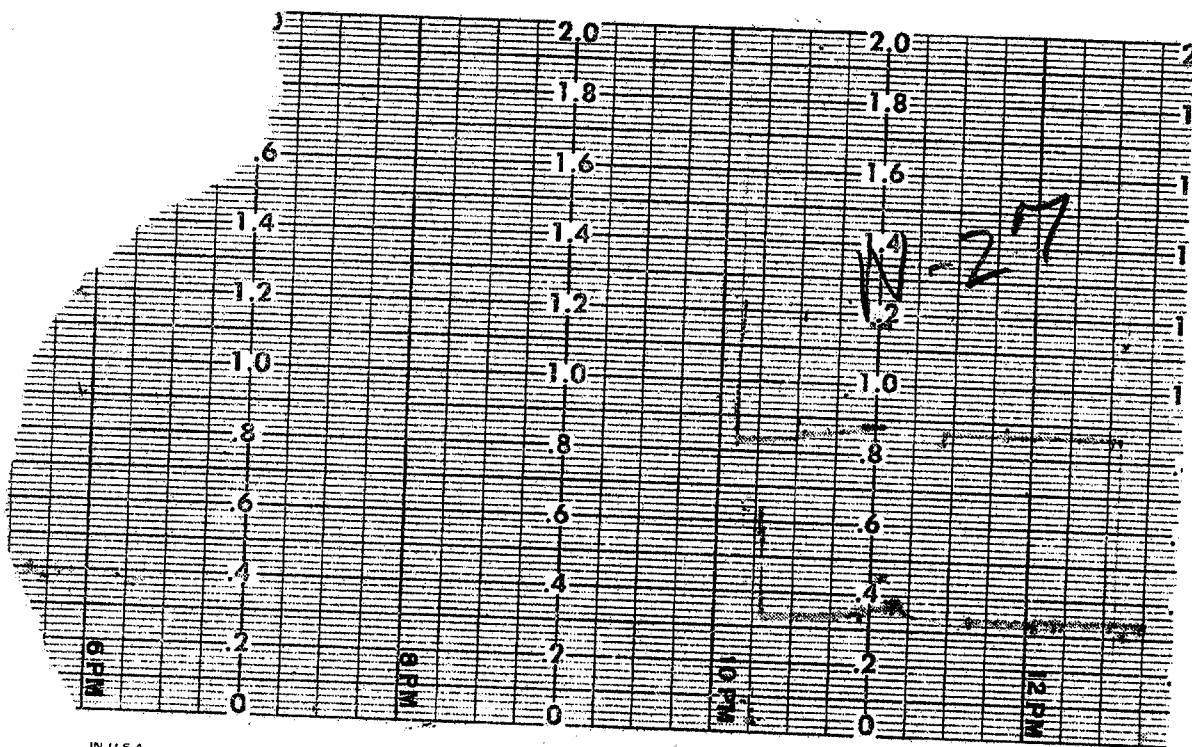
JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP Step 06/39 - After heat up Record: pH <u>10.0</u> (9.5-10.0)						
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
5		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>2:50 PM</u>						
		SP STEP						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	<u>9.8</u>	9.0-10.0	<u>3:15 PM</u>			
		14/47 (60 min)	<u>9.85</u>	9.0-10.0	<u>3:45 PM</u>			
		15/48 (2 hrs)	<u>9.8</u>	9.0-10.0	<u>4:45 PM</u>			
		16/49 (2 hrs 25 min)	<u>9.8</u>	9.0-10.0	<u>5:10 PM</u>			
		17/50 (3 hrs Final)	<u>7.4</u>	7.5-8.5	<u>5:45 PM</u>			
		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 <u>10.2</u> (9.5-10.5)						
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol <u>49</u> " & calculate <u>49</u> " (Vol) x 0.78 = <u>38.2 G</u>						
	35	Set preset #8 to <u>38.2</u> 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 <u>3.3</u> (3.7-4.2)						
&	41	Run in N-7-D from 27 in 10-12 min & stir 5 min						
CP	42	Record: pH <u>8.7</u> (9.0-9.5) & if necessary add pH 9.0-9.5						
8		& Record: pH <u>9.4</u> Assume 77%					27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%				12	7-D	6
		Siphon N-7-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.25</u> (9.0-10.0) Time <u>6:55 PM</u>						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
	47	PUMP V-243 TO V-240						
		Start	Finish	Optr				
		Time	SP Step	Time	SP Step			
		<u>12 MID</u>		<u>7:00 PM</u>		<u>126</u>		
		<u>7:00 AM</u>		<u>3:00 PM</u>		<u>145</u>		
		<u>3:00 PM</u>		<u>7:25 PM</u>		<u>235</u>		



V-243

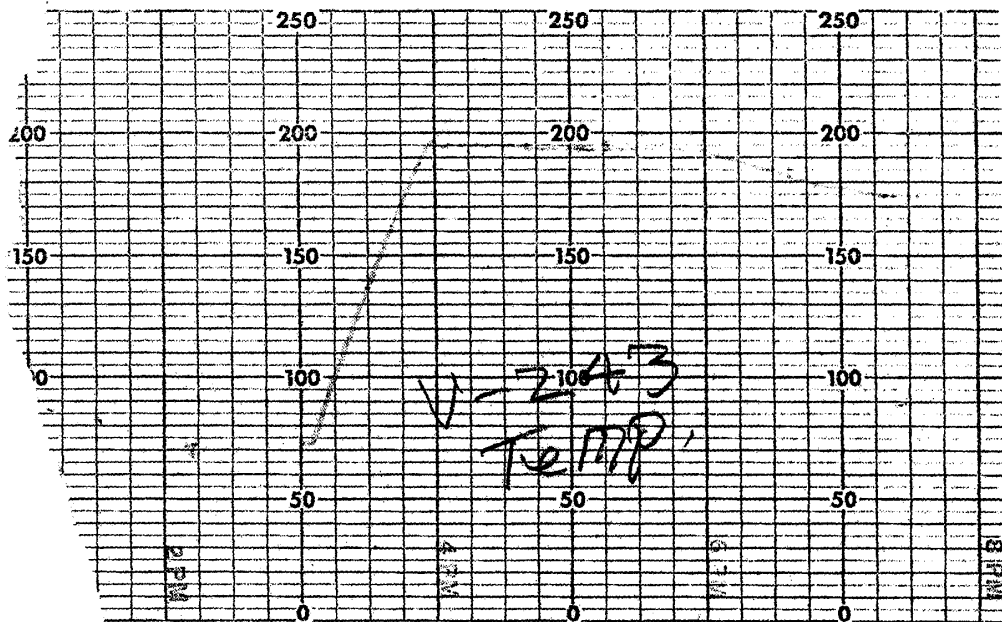


BUFFALO, NEW YORK



IN U.S.A.

GRAPH



PRINTED IN U.S.A.

DUP050093909