V. ~~244~~ 244 (Automated) C.V. D.V.

PUNCHED & CHECKED

CG 03 CODE KY-788-D PKG.

→ MAR-19 - 34963 MAR 20 1980

EST. WGT. ~~960~~ 860 LBS.

PROCESSES		APPROVED
( )KY-788-D	(J)	EWK 9/28/7
( )	( )	MTW 9/30/7
( )	( )	DCG 9/30/7
( )	( )	
TYPED BY		
NE 2-18-77		

STD. HRS. 8.8 TIME 7-AM

14 YC-3-B 98 4 Lot 24698 ; 2000

14 YC-3-B 98 4 Lot 24699 ; 600

14 YC-3-B 98 4 Lot ; 2600

V-244 'M' T 12:00 PM

Homog #3 - 2nd Pass

Total Wgt. ~~3560#~~ 3460

NON-BLEEDING

IPMENT		NAME: "KROLOR" YELLOW - LIGHT	USE LBS.	N CODE	AC LB
203	1	Run ~~23"~~ (360 G) water into V-203. SET AGITATOR ON HIGH SPEED		~~345~~	
&	2	Weigh in drum & pour in	345	32-D	34
205	3	Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
1		Record: Start 3:20 P.M. 24698	2000	2600	
		Fin 4:10 P.M. 24699	600		
		75" (1275 G)	2600		
	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 washcolor thru Homog at 1800-2200 psi using minimun water.			
	7	Record: V-205 Vol 43 "& 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 V- 244 & startagitator			
&	10	Pump V-205 thru Homog at 4800-5200 psi into V- 244			
SV		Record: Time Start 2:10 PM, otal min 120			
2		Note: If Homog pressure falls below 4800 ps , 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 #3 (V-243) or #8 (V-244)			
&	13	Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
CP	14	Record levels and set Raw Material Counter #1 as follows			
3		a. 11LG 24 % - preset #2 208 Gal		15-A	416
		b. 13LG 49 % - preset #6 135 Gal		20-A	135
	15	Set strike flow controllers as follows:			
		a. 3FC10 (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. 3FR10 (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			
320	16	Operator Step PB			
243	17	Record Level 21G 43 %. If below 35% follow solution make-up procedure for N-27-D			
SP	18	Adj SV to 47" (2400 G)			
&	19	Record pH 12.8 . Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.3	30	7-D	15
CP	20	Operator Step PB			
4					
9 REV.					

N26555

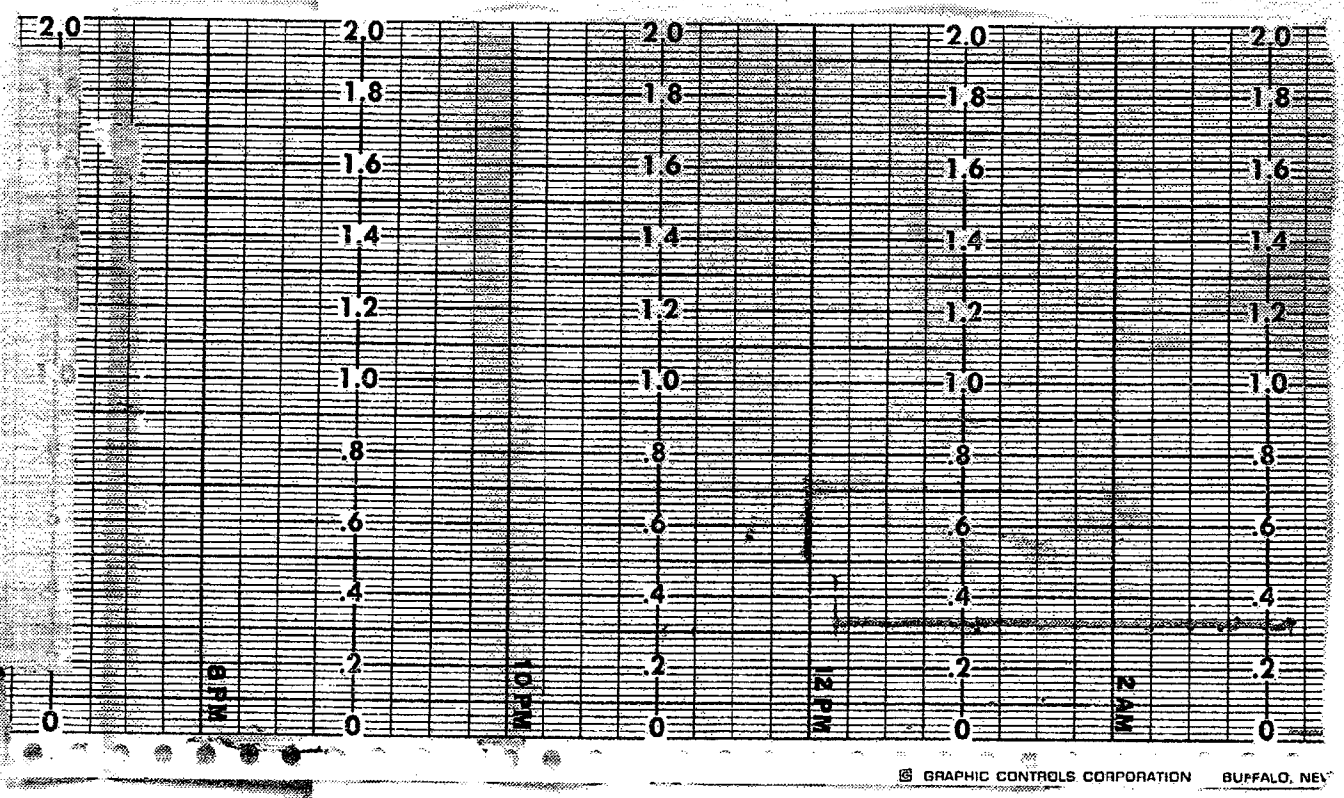
V-244

UIPMENT		PAGE 2 CG 03 CODE KY-788-D EST. WGT. 3560 LBS.	USE LBS.	N CODE	ACC Le
SV	21	SP Step 06/39 - After heat up Record: pH 10.0 (9.5-10.0)			
SP	22	Switch 3FC20. 8FC10. 8FC20 to Auto			
	23	Operator Step PB			
	24	SP Step 10/43 - When 3FC20. 8FC10. 8FC20 water flows is limits.			
5		Switch 3FC10 to Auto. Operator Step PB			
	26	SP Step 11/44 - When 3FC10. 3FC20 flows in limits. switch 3FC20			
		to Remote			
	28	Operator Step PB			
	27	During strike. record pH & time as follows:			
		SP Step			
		V-243/V-244 pH Range Time			
		13/45 (30 min) 9.8 9.3-10.0 8:10			
		14/47 (60 min) 9.8 9.3-10.0 8:40			
		15/48 (2 hrs) 9.8 9.3-10.0 9:40			
		16/49 (2 hrs 25 min) 9.8 9.3-10.0 10:05			
		17/50 (Final 3 hrs) 8.5 7.5-8.5 10:40			
		Note: If not as specified notify Supervisor & Note in log			
		If final pH is above 8.5. adj 7.5-8.5			
		& Record: pH ____ Assume 77%	____	27-D	____
339	28	While striking run 30" (234 G) water into V-339			
6	29	Add in 7-8 min	350	530-A	~~350~~
	30	Adj to 49" (382 G) at 80-100 °F			350
	31	Stir 5 min & record pH 10.2 (9.5-10.5)			
	32	Stir 15 min or longer to dissolve for SP Step 26/56			
	33	Record Vol 49 " & Calculate 49 " (Vol X 0.78= 38.2 G)			
	34	Set preset #8 to 38.2 G from S 33			
302	35	Run 40" (440 G) water into V-302			180
7	36	Add & stir 2 min for S 40 Assume 50%	360	7-D	~~18~~
SV	37	SP Step 17/50 After checking pH. Operator Step PB			
SP	38	~~Sift in 2 bags~~	~~100~~	~~128-A~~	10
	39	SP Step 23/53 Record: pH 3.9 (3.7-4.2			
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min			
	41	Record: pH 9.5 (9.0-9.5) & if necessary adj to 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			
	42	Operator Step PB			
	43	SP Step 29 - Record: pH 9.3 (9.0-10.0) Time 12:30 PM			
	44	Operator Step PB			
	45	SP Step 60 - Batch complete			

Start Time	SP Step	Finish Time	SP Step	Optr
7:00 A		3:00 P		235
0 PM		11:00 PM		438
11:00 PM		12:30 AM		320

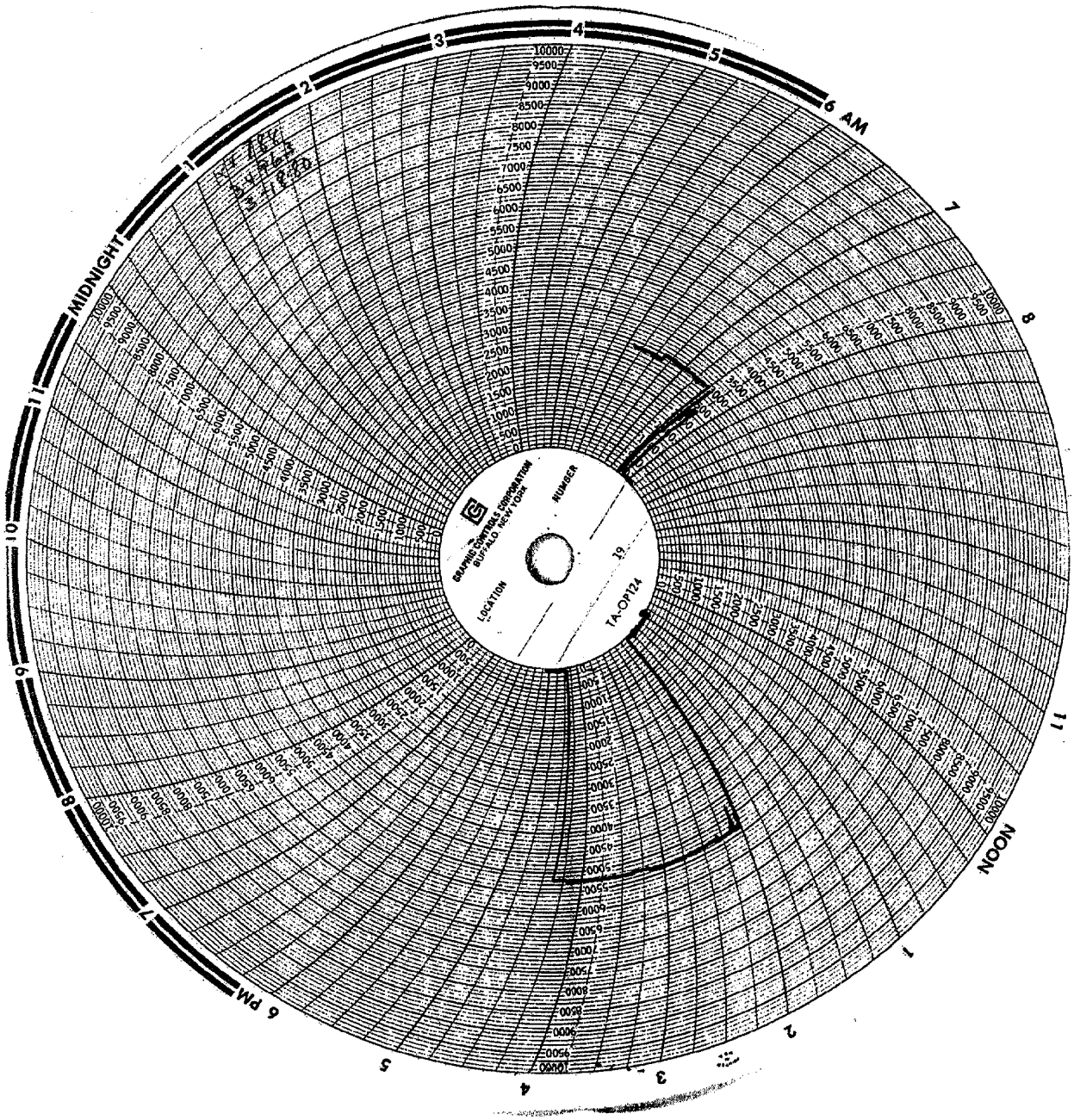
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