MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, ~~244~~ (Automated_ C.V. D.V.

CG 03 CODE KY-907-D PKG. _____

→ JAN-4 33621

EST. WGT. 1080 LBS.

STD. HRS. _____ TIME 7A M

14 YC-2-B 93 4 Lot 24063, 2000#
14 YC-2-B 93 4 Lot 24062, 400#
14 YC-2-B 93 4 Lot _____, _____#

PROCESSES		APPROVED BY
( ) KY-907-D	(D)	EWK 12/12/77
( )	( )	DCG 12/13/77
( )	( )	MW 12/15/77
( )	( )	
TYPED BY		
rj 2/3/78		

Homo #3 1st Pass

Total Weight - 3480# Note Step :-26

NON-BLEEDING

EQUIPMENT		NAME: ~~60" (990 G)~~ KROLOR® - YELLOW MEDIUM		USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1	~~Run 83" (560 G)~~ water into V-203		20	7-D	10
	2	~~Pour in~~		320	32-D	320
	3	Dump in	Lot 24063	48 x 50	YC-2-B	2400
		Record: Start 8:30 P/M		2000		
		Fin 10:00 P/M				
		~~80" (1320 G)~~	24062	400		
75"(1275G)	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 46 " & adj to 60" (2100 G)				
	8	Inspect Homog strainer & clean if necessary				
205 & SV 2	9	Run 10" (514 G) water into SV & start agitator				
	10	Pump V-205 thru Homog at 4800-5200 psi into V-				
		Record: Time Start 11:00A Total Min 180				
		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 3	12	SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)				
	13	Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194°F)				
	14	Record levels and set Raw Materials Counter #1 as follows:				
		11LG 61 % - preset #1 80 Gal			15-A	160
	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	4.4 GPM			
		f. 8FC20 (N-32-D Water) in Remote				
		g. 8FR10 (N-32-D/Water Ratio)	0.83			
SV SP & CP 4	16	Operator Step PB				
	17	Record Level 2 LG 57 %. If below 35% follow solution make-up procedure for N-27-D				
	18	Adj to 48" (2470 G)				
	19	Record: pH 10.6				
	20	Adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Siphon into SV Record: pH 11.15	Assume 50%	12	7-D	6
	21	Operator Step PB				

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2453

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EQUIPMENT			USE LBS.	N CODE	ACCT. LBS.
SV SP & CP 5	22	SP Step 06/39 - After heat up Record: pH 9.95 (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:	3:50 PM		
		SP Step V-243/V-244 pH Range Time			
		13/46 (30 min) 9.9 9.0-10.0 4:38			
		→ 14/47 (60 min) 9.9 9.0-10.0 4:50			
		15/48 (2 hrs) 9.65 9.0-10.0 5:20			
		16/49 (2 hrs 25 min) 9.5 9.0-10.0 6:15	SHUT N-27 OFF 10 MIN EARLY		
		17/50 (3 hrs Final) 7.7 7.5-8.5 6:50 ←			
		NOTE: (1) If pH not as specified notify Supervisor & note in log (2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH Assume 78%		27-D	
	29	Sift in	✓ 50	128-A	50
302 6	30	Add 17" (208 G) water to V-302			
	31	Add & stir 2 min for S58 Assume 50%	✓ 100	7-D	50
PT 7	32	During strike pump into PT	318	169-A	318
	33	Pump in	36	155-A	36
	34	Pump in	36	160-A	36
	35	Stir 10 min with lightning mixer for S39			
356 8	36	During strike run ~~20"~~ 14" (244 G) water into V-356			
	37	Turn on steam			
	38	Adj to ~~26"~~ (317 G) at ~~178-182°F~~ 81-82°C			
	39	Pump PT mixture from S35 thru undersurface Distributor AFAP			
	40	Rinse PT with hot water from hot water mixer & pump in			
	41	Shut off pump 81-82°C			
	42	Stir 30 min at ~~178-182°F~~ for S49			
	43	Do not shut off agitator			
V & P 9	44	When S29 complete, heat SV to 198-200°F in 5-10 min			
	45	Close water line & discharge valves at stearate pump			
	46	Open V-356 Discharge valves to stearate pump inlet			
	47	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer			
	48	While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & close valve to sewer			
	49	Immediately open stearate pump discharge valve, Turn on pump & Homog V-356 to SV at 2900-3100 psi Maintain SV at 198-200°F			
	50	While Homog V-356 to SV, shut off water valve at Stearate pump ASAP			
	51	When Homog complete, rinse in V-356 with hot water From hot water mixer			

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V-243

EQUIPMENT		PAGE 3 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV & SP 9 Con'T	52	When S51 complete turn off Homog & stearate pump			
	53	Stir 5 min at 198-200°F			
	54	Shut off steam			
	55	When S54 complete, Operator PB			
	56	SP Step 23/53 Record pH 3.7 (3.3-3.7)			
	57	If necessary adj pH to (3.3-3.7) (DOWN ONLY) Record: pH ____		15-A	
		NOTE: Dissolve extra N-15-A in water at 110-120°F in drum Use ± 30 gal of water to 50# N-15-A. Stir SV 5 min after each addition			
	58	Run in N-7-D from S31 in 10-12 min & stir 5 min			
	59	Record: pH 5.7 (4.2-4.4) & if necessary adj pH 4.2-4.4			
		& Record: pH 4.4 Assume 50%		7-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 78%	2-0	27-D	
		Siphon N-7-D into SV			
	60	Operator Step PB			
	61	Operator Step PB			
	62	SP Step 60 - Batch complete			

START Time	START SP Step	FINISH Time	FINISH SP Step	OPTR
11:00PM		7:00AM		409-223
11 PM		3rd P		120-126
3:00P		7:55PM		

5:20PM - 9.75
5:50PM - 9.65
6:15 P.M - 9.5

Note → STEP-26, N-27 + N-32 METERED O.K. FOR 60 MINS. LOST WATER FLOW AT 4:50PM, N-32 FLOW ± 0.84, SHUT PUMP OFF AND ON, NO WATER CONTINUED TO JOG PUMP TO KEEP P.H. IN LINE SEE N-32 CHART + LOG

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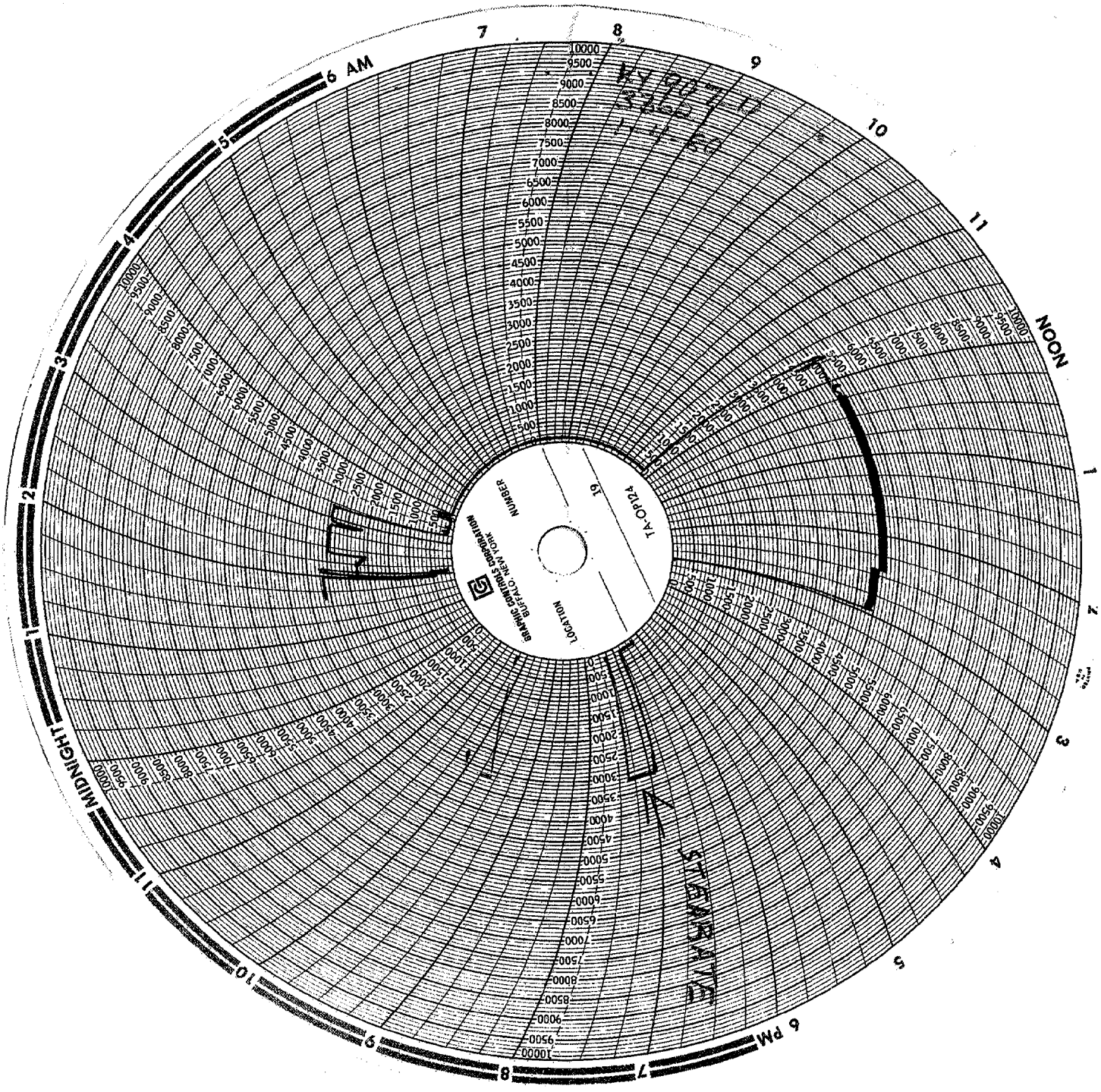

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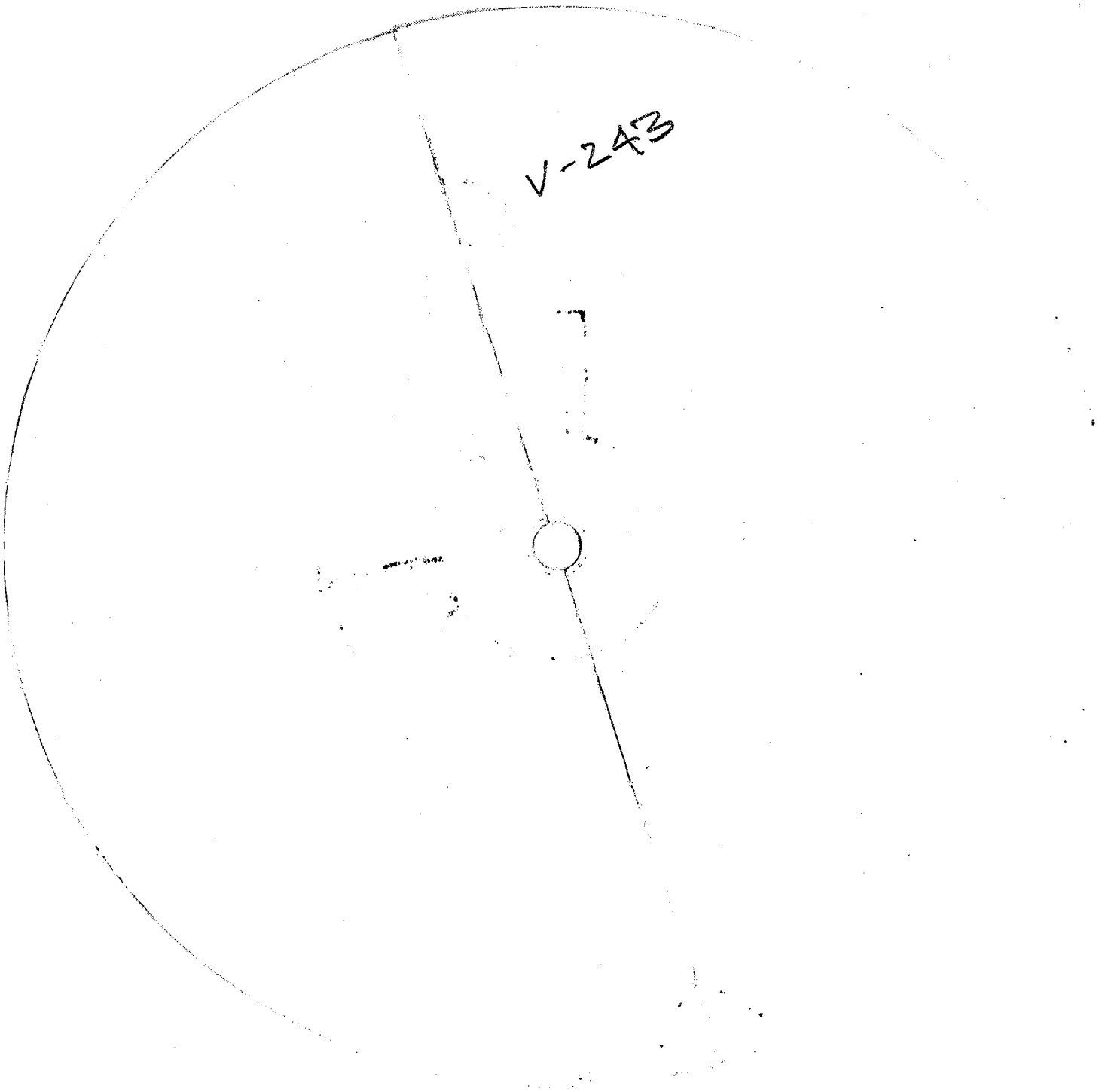
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