

Automated

C.V.

D.V.

CG 03 CODE KY-788-D

PKG.

PUNCHED & CHECKED

MAR 11 34837

EST. WGT. 960 860 LBS.

MAR 19 1980

STD. MRS. 8.8

TIME

14 YC-3-B 98 4

Lot

14 YC-3-B 98 4

Lot

14 YC-3-B 98 4

Lot

PROCESSES		APPROVED BY	
() KY-788-D	(J)	EWK	9/28/76
()	()	MTW	9/30/76
()	()	DCG	9/30/76
TYPED BY			
NE 2-18-77			

Total Wgt. 3560# 3460

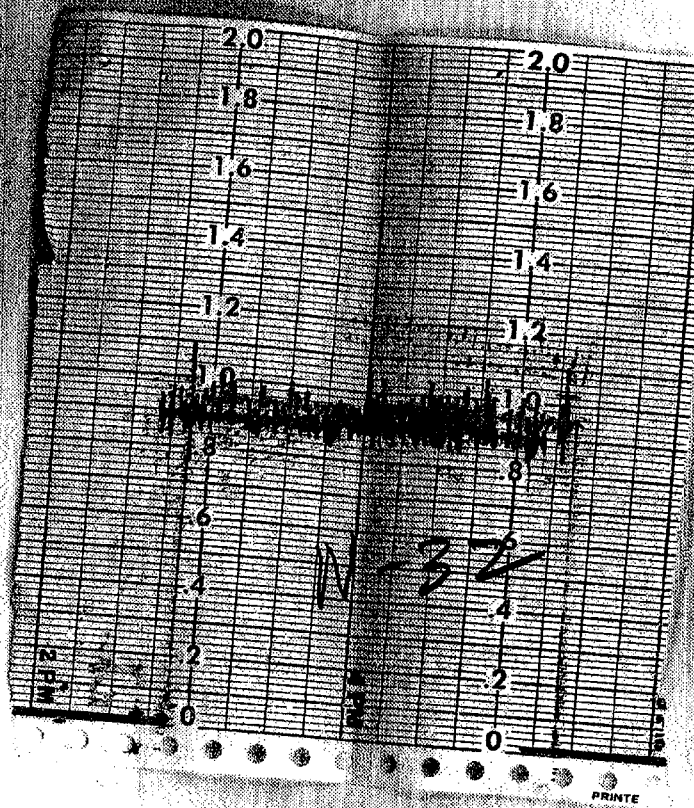
NON-BLEEDING

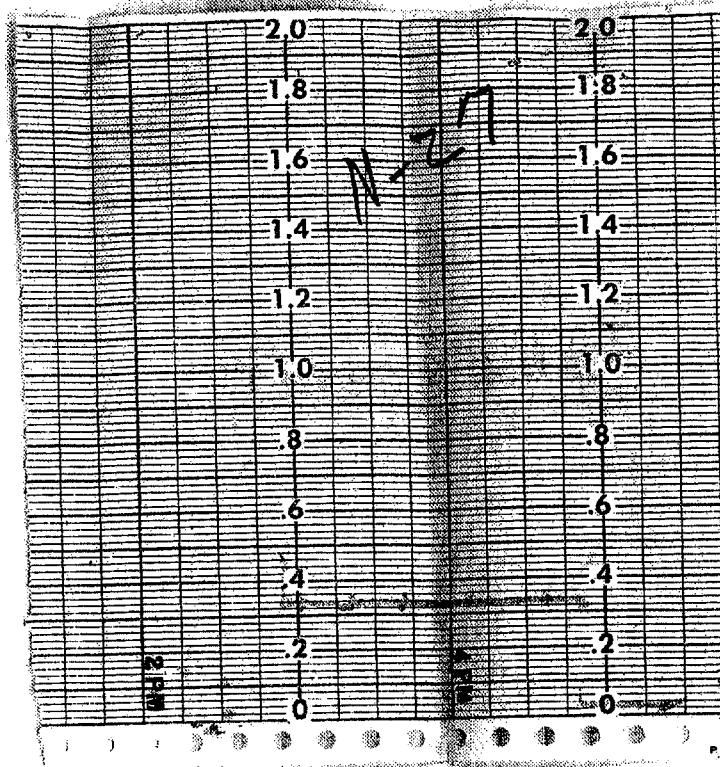
SHIPMENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	1 Run 23" (360 G) water into V-203. RUN AGITATOR ON HIGH SPEED			
&	2 Weigh in drum & pour in	345	32-D	345
205	3 Dump in & stir 5 min	52 x 50	YC-3-B	2600
1	Record: Start 3:30 PM 24406 2600			
	Fin 5:00 PM			
	Adj to 70" (1200 G) 2400-2600			
	4 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	5 When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water			
	6 Record: V-205 Vol 40 " & adj to 60" (2100 G)			
	7 Inspect homog. strainer & clean if necessary			
	DURING HOMOG. RUN V-203 AGITATOR ON LOW SPEED			
205	8 Run 10" (514 G) water into V-243 & start agitator			
&	9 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	10 Record: Time Start 12:00 PM Total min 150			
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 38 % - preset #2 208 Gal 15-A 416			
	b. 13LG 58 % - 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 2LG 70 %. If below 35% follow solution make-up procedure for N-27-D			
SP	18 Adj SV to 47" (2400 G)			
&	19 Record pH 140 . 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
CP	Siphon into SV & Record: pH 11.2			
4	20 Operator Step PB			

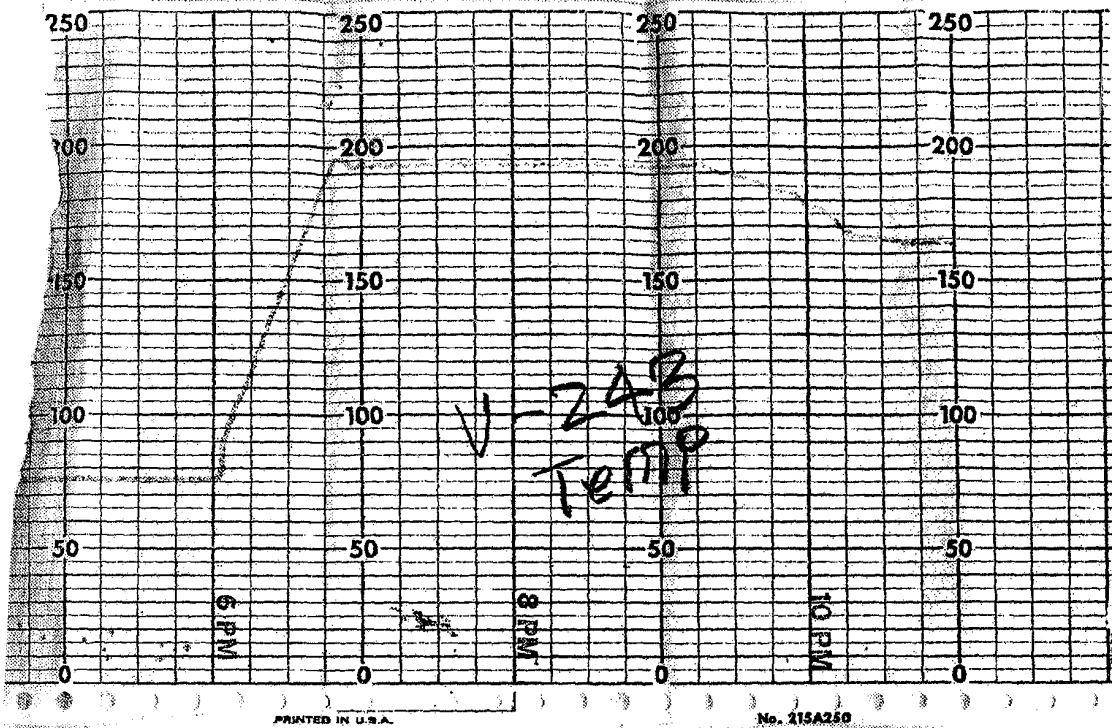
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UIPMENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS.	
SV	21	SP Step 06/39 - After heat up Record: pH 9.9 (9.5-10.0)							
SP	22	Switch 3FC20. 8FC10. 8FC20 to Auto							
	23	Operator Step PB							
5	24	SP Step 10/43 - When 3FC20. 8FC10. 8FC20 water flows is 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-442/V-284	pH	Range	Time	3:35 AM			
		13/45 (30 min)	9.8	9.3-10.0	4:05				
		14/47 (60 min)	9.7	9.3-10.0	4:35				
		15/48 (2 hrs)	9.8	9.3-10.0	5:35				
		16/49 (2 hrs 25 min)	9.8	9.3-10.0	6:00				
		17/50 (Final 3 hrs)	9.3	7.5-8.5	6:35	AM			
		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							
	30	Adj to 49" (382 G) at 80-100 °F					350	530-A	350
	31	Stir 5 min & record pH 9.9 (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							
7	36	Add & stir 2 min for S 40					Assume 50%	360	7-D 180
SV	37	SP Step 17/50 After checking pH. Operator Step PB							
SP	38	Sift in 2 bags					100	120-A	100
	39	SP Step 23/53 Record: pH 3.0 (3.7-4.2)							
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min							
	41	Record: pH 9.4 (9.0-9.5) & if necessary adj to pH 9.0-9.5							
		& Record: pH Assume 77%							
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%							
		Siphon N-7-D into SV							
	42	Operator Step PB							
	43	SP Step 29 - Record: pH 9.3 (9.0-10.0) Time 7:40							
	44	Operator Step PB							
	45	SP Step 60 - Batch complete							
		Start		Finish		Optr			
		Time	SP Step	Time	SP Step				
		11:00 AM		1:00 AM		320			
		7:00 AM		7:45 AM		235			







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