

MAKING INSTRUCTIONS BATCH UNIT

V (243) (AUTOMATED)

C.V.

D.V.

CG 03 CODE KY-787-D

PKG

EST WGT 1090 LBS

STD HRS 8.9 TIME 3:10 PM

14 YC-2-B 93 4 LOT 24425, 24400

LOT

LOT

PUNCHED & CHECKED

APR 1 1980 MAR 29 1980

PROCESSES	APPROVED BY
() KY-787-D	() EWK 9-22-76
()	() DCG 9-27-76
()	() MTW 9-30-76
RE-TYPED BY	
CJH 2-8-80	

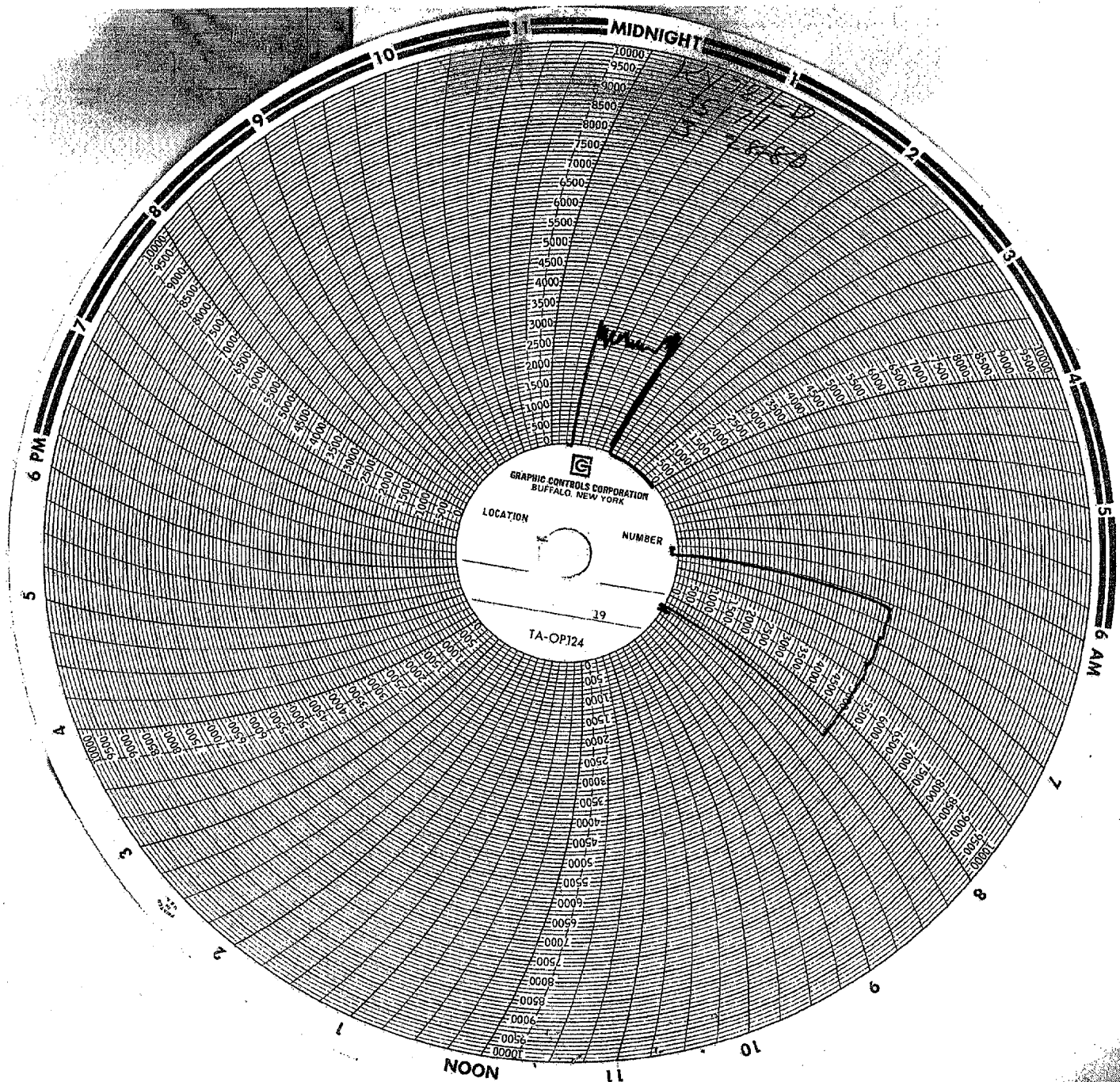
TOTAL WGT 3490#

NON-BLEEDING

IPMENT	NAME	USE LBS	N CODE	ACCT LBS
203 & 205 1	"KROLOR" YELLOW MEDIUM			
	1. RUN 60" (992 G) WATER INTO V-203. SET AGITATOR ON HIGH SPEED			
	2. WEIGH IN DRUM & POUR IN	320	32-D	320
	3. DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
	RECORD: START 11:20			
	FIN 12:30			
	4. ADD TO 70" (1200 G)			
	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 52" & ADJ TO 60" (2100 G)			
	8. INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
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-243			
	RECORD: TIME START 10:15 AM TOTAL MIN 1:20			
	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 190-194F)			
	14. RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 32% - PRESET #1	80 GAL	15-A	160
	B. 13LG 50% - 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	275
	B. 3FC20 (N-27-D WATER) IN MANUAL LOCAL	5.28 GPM		
	C. 3FC10 (N-27-D/WATER RATIO)	0.64		
	D. 3FC10 (N-32-D CONTROLLER) IN MANUAL	1.08 GPM	32-D	1840
	E. 3FC20 (N-32-D WATER) IN MANUAL LOCAL	4.47 GPM		
	F. 3FC20 (N-32-D WATER) IN REMOTE			
	G. 3FC10 (N-32-D/WATER RATIO)	0.83		
SV SP & CP 4	16. OPERATOR STEP PB			
	17. RECORD LEVEL 2 LG 70%. IF BELOW 35% FOLLOW SOLUTION			
	18. MAKE UP PROCEDURE FOR N-27-D			
	19. ADJ TO 48" (2470 G)			
	RECORD: PH 11.8			
	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	1-D	10
	SIPHON INTO SV. RECORD PH 11.15			
	21. OPERATOR STEP PB			

EQUIPMENT	PAGE	CG	03	CODE	KY-787-D	EST WGT	3490	LBS	USE LBS	N CODE	ACC LBS
SV	22	SP	STEP	06/39	- AFTER HEAT UP RECORD: PH	9.9	(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				
	26	SP	STEP	11/44	- WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH						
	27	3FC20	TO REMOTE								
	27	OPERATOR	STEP	PB							
	28	DURING	STRIKE, RECORD	PH & TIME AS FOLLOWS:							
		SP	STEP								
		V-243/V-244			PH	RANGE	TIME				
		13/46 (30 MIN)			9.7	9.0-10.0	10:00 Am				
		14/47 (60 MIN)			9.7	9.0-10.0	10:30 Am				
		15/48 (2 HRS)			9.7	9.0-10.0	11:30 Am				
		16/49 (2 HRS 25 MIN)			9.7	9.0-10.0	11:55 Am				
		17/50 (3 HRS FINAL)			7.2	7.5-8.5	12:30 Pm				
		NOTE:	IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG								
			IF FINAL PH IS ABOVE 8.5, ADJ PH TO 7.5-8.5 &								
		RECORD:	PH					ASSUME 77%		27-D	
339	29	WHILE	STRIKING, RUN	30" (234 G) WATER INTO V-339				350		530-A	350
6	30	ADD	IN 7-8 MIN								
	31	ADD	TO 49" (382 G) AT 80 - 100°F								
	32	STIR	5 MIN & RECORD	PH 10.5 (9.5-10.5)							
	33	STIR	15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26								
	34	RECORD	VOL 50" & CALCULATE 50" (VOL) X 0.78 = 39.0 G								
	35	SET	PRESET 78 TO 39.0 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 3.9 (3.7-4.2)						
&	41	RUN	IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
CP	42	RECORD:	PH 9.2 (9.0-9.5) & IF NECESSARY ADJ 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 INTO SV								
	43	OPERATOR	STEP	PB							
	44	SP	STEP	29/58 RECORD: PH 9.0 (9.0-10.0) TIME 2 AM							
	45	OPERATOR	STEP	PB							
	46	SP	STEP	60 - BATCH COMPLETE							

TIME	START	FINISH	SP STEP	OPTR
1230		2 AM		
2:00		2:00		287
				207-27



N32462.01

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