S.V. 243 (Automated) C.V. D.V.

CG 03 CODE KY-908-D PKG. _____

→ JAN 20 33929

EST. WGT. 949 LBS.

STD. HRS. _____ TIME ____ M 7AM

PROCESSES		APPROVED BY
( ) KY-908-D	(D)	EWK 12/12/77
( )	( )	DCG 12/14/77
( )	( )	MW 12/19/77
( )	( )	
TYPED BY		
rj 1/31/78		

OK
KP

14 YC-3-B 93 4 Lot 24426, 2600#
14 YC-3-B 93 4 Lot _____, _____#
14 YC-3-B 93 4 Lot _____, _____#

Homog #4 — 1ST Pass

Total Wgt. 3549#

80

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® YELLOW - LIGHT	USE LBS.	N CODE	ACCT. LBS.
203 & ~~205~~ 263 1	80" (990 G)	~~1 Run 23" (360 G)~~ water into V-203			
	~~2~~	Pour in	345	32-D	345
	~~3~~	Dump in Lot	52 x 50	YC-3-B	2600
		Record: Start 5:45 A.M. 24426	2600		
		Fin 6:30 A.M.			
75" (1275 G)		~~80" (1360 G)~~			
	~~4~~	Adj to ~~70" (1200 G)~~ 2400-2600			
	~~5~~	Pump V-203 thru Homog #3 at ~~1800-2200~~ psi into V-~~205~~ 263			
	~~6~~	When V-203 MTY, wash color thru Homog at 1800-2200 psi using Minimum water 263			
	~~7~~	Record: V-~~205~~ Vol " & adj to 60" (2100-G)			
	~~8~~	Inspect Homog, strainer & clean if necessary			
~~205~~ 263 & SV 2	~~9~~	Run 10" (514 G) water into V-244 & start agitator			
	~~10~~	Pump V-205 thru Homog at 4800-5200 psi into V-244			
		Record: Time Start 10:30 P Total Min 160			
		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 #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)			
	~~14~~	Record levels and set Raw Material Counter #1 as follows 11LG 35 % - preset #2 208 Gal		15-A	416
	~~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			
SV SP & CP 4	~~16~~	Operator Step PB			
	~~17~~	Record Level 2LG 50 %. If below 35% follow solution make-up procedure for N-27-D	V.M.		
	~~18~~	Adj SV to 47" (2400 G)			
	~~19~~	Record pH 10.0. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	50	7-D	25
		Siphon into SV & Record: pH 11.0			
	~~20~~	Operator Step PB			

V-244

EQUIPMENT		PAGE 2 CG 03 CODE KY-908-D (D) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	21	SP Step 06/39 - After heat up Record: pH 9.8 (9.5-10.0)			
SP	22	Switch 3FC20, 8FC10, ~~8FC20~~ to auto			
5	23	Operator Step PB			
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in 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-243/V-244 pH Range Time 3:55AM			
		13/46 (30 min) 9.6 9.3-10.0 4:25 AM			
		14/47 (60 min) 9.6 9.3-10.0 4:55			
		15/48 (2 hrs) 9.8 9.3-10.0 5:55			
		16/49 (2 hrs 25 min) 9.8 9.3-10.0 6:20			
		17/50 (Final 3 hrs) 9.1 7.5- 8.5 6:55 AM			
		Note:(1) If pH not as specified notify Supervisor & note in Log (2) If final pH is above 8.5 adj to 7.5-8.5 & Record: pH 8.3 Assume 78%	16	27-D	
	28	Sift in	50	128-A	50
	29	Add 17" (208G) water to V-~~302~~ 314			
314 6	30	Add & stir 2 min for S57 Assume 50%	100	7-D	50
PT	31	During Strike pump into PT	312	169-A	312
7	32	Pump in	36	155-A	36
	33	Pump in	36	160-A	36
	34	Stir 10 min with lightning mixer for S38			
356	35	During strike Run ~~20"~~ 14" (244G) water into V-356			
8	36	Turn on steam			
	37	Adj to ~~25/8~~"(317G) at ~~178-182°F~~ 81-82°C			
	38	Pump PT mixture from S34 thru undersurface Distributor AFAP			
	39	Rinse PT with hot water from hot water mixer & pump in			
	40	Shutoff pump 81-82°C			
	41	Stir 30 min at ~~178-182°F~~ for S48			
	42	Do not shut off Agitator			
SV	43	When S28 complete, heat SV to 198-200°F in 5-10 min			
&	44	Close water line & Discharge valves at stearate pump			
SP	45	Open V-356 Discharge valves to stearate pump inlet			
9	46	Open water valve at stearate pump & run water thru Homog at 2900-3100PSI to sewer			
	47	While Homog water at 2900-3100 PSI, open Homog Discharge valve to SV & close valve to sewer			
	48	Immediately open stearate pump Discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 PSI maintain SV at 198-200°F			
	49	While Homog V-356 to SV, shut off water valve at stearate pump ASAP			
	50	When Homog complete, Rinse in V-356 with hot water from hot water mixer			
	51	When S50 complete turn off Homog & stearate pump			
	52	Stir 5 min at 198-200°F			
	53	Shut off steam			

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V-244

EQUIPMENT		PAGE 3 CG 03 CODE KY-908-D (D) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV & SP 9 Con't	54	When S53 complete, Operator PB			
	55	SP Step 23/53 Record pH 3.1 (3.3-3.7)			
	56	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			
	57	Run in N-7-D from S30 in 10-12 min & stir 5 min			
	58	Record: pH 3.5 (4.2-4.4) & if necessary adj to pH 4.2-4.4			
		& Record: pH 4.2 Assume 50%	80	7-D	40
		(Dilute 10 parts water to 1 part N-7-D) Assume 78%		27-D	
		Siphon N-7-D into SV			
	59	Operator Step PB			
	60	Operator Step PB			
	61	SP Step 60 - Batch complete			

START Time	START SP Step	FINISH Time	FINISH SP Step	OPTR
7:00A		3:00P		235-342
1030P		11:00P		151-126
11:00PM		7:00AM		320-144
7:00A		9:20AM		235

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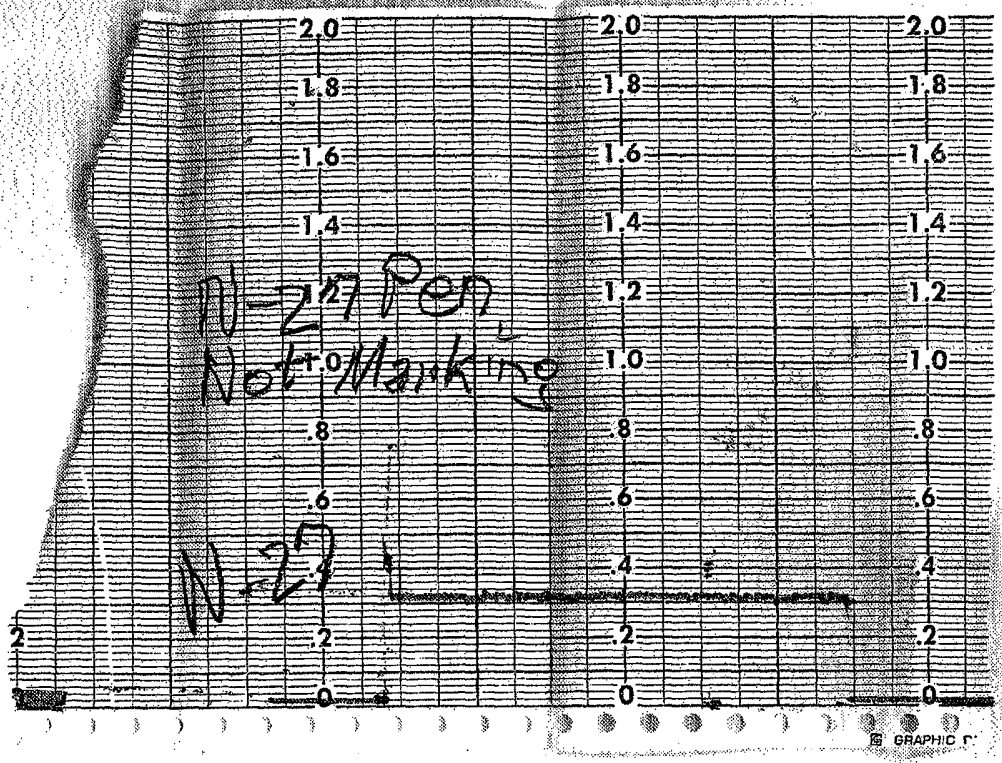

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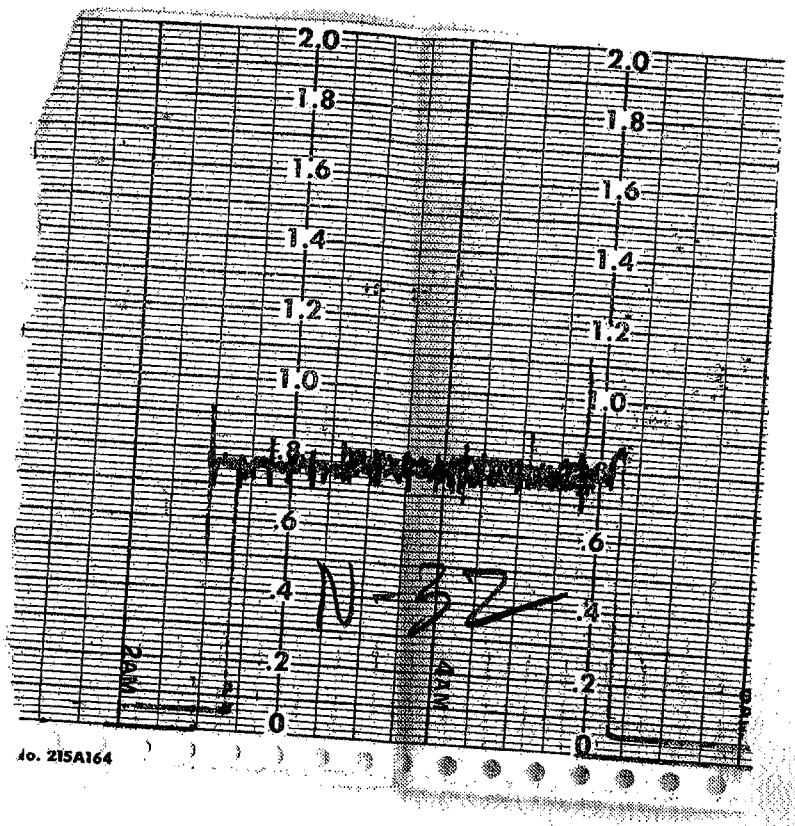

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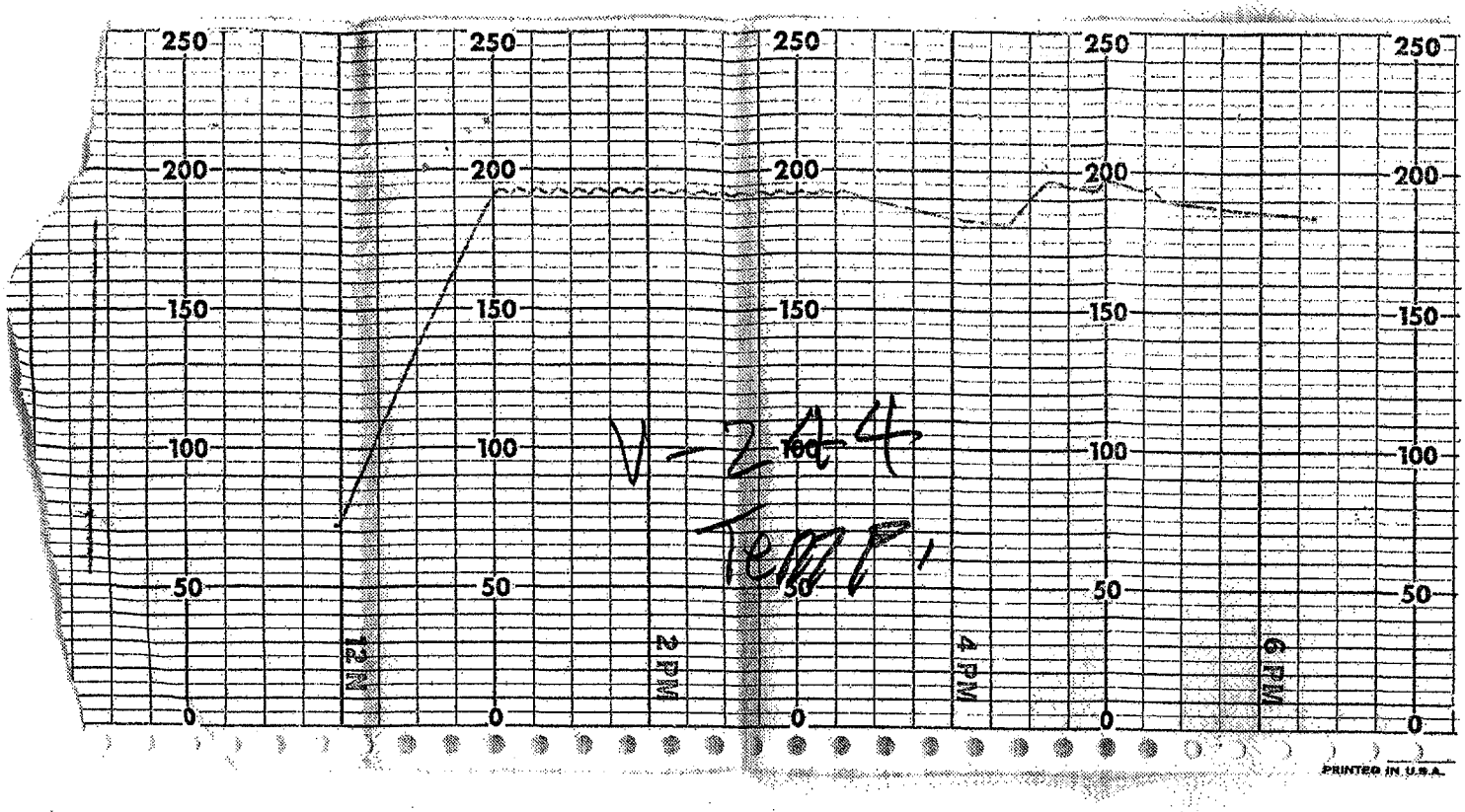
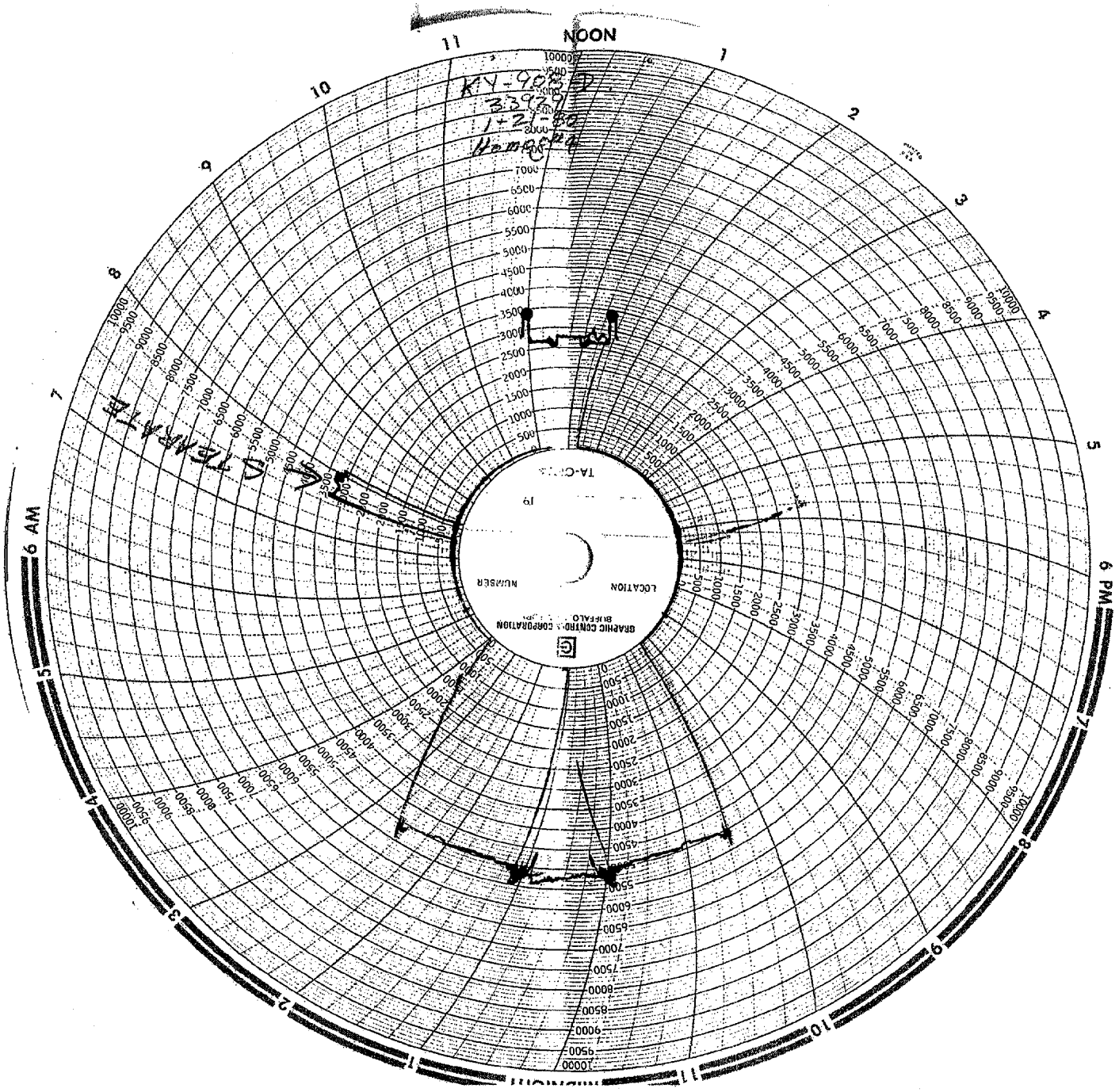


V-244
Temp



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