

JAN - 8 1980

243 244 (Automated)

C.V.

D.V.

CG 03 CODE KY-787-D PKG.
JAN 10 33722
EST. WGT. 1090 LBS.
STD. HRS. 8.9 TIME 3 P M

PROCESSES	APPROVED BY
() KY-787-D	() FWK 9/22/76
()	() DCG 9/27/76
()	() MTW 9/30/76
()	()
TYPED BY	
N.E. 2/12/77	

14 - YC-2-B 98 4 Lot 24201, 50#
Lot 24078, 600#
Lot 24080, 1750#

012
S.H.

Homog #4 - 1st Pass
2nd Pass

Total Wgt. - 3490#

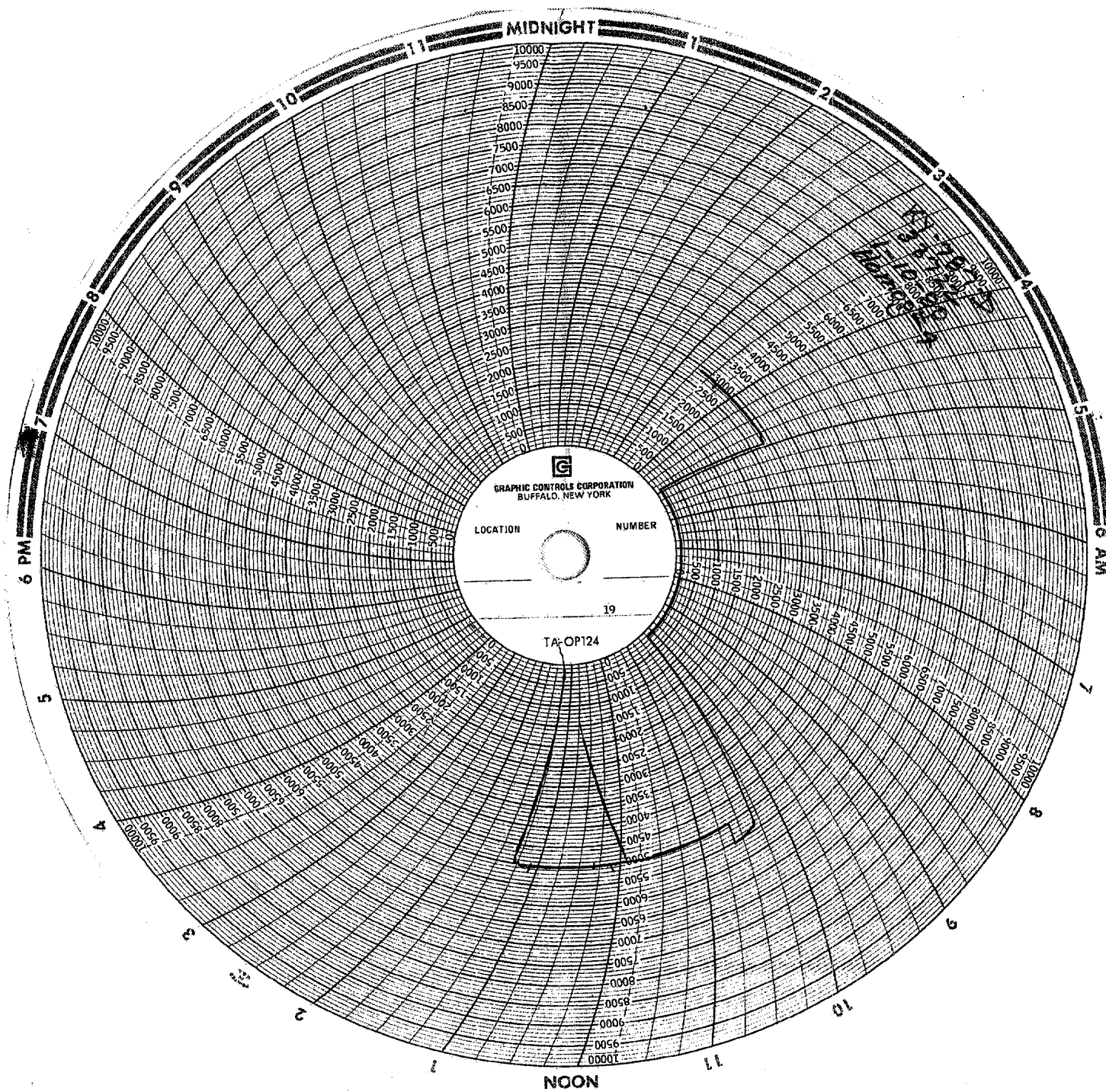
NON-BLEEDING

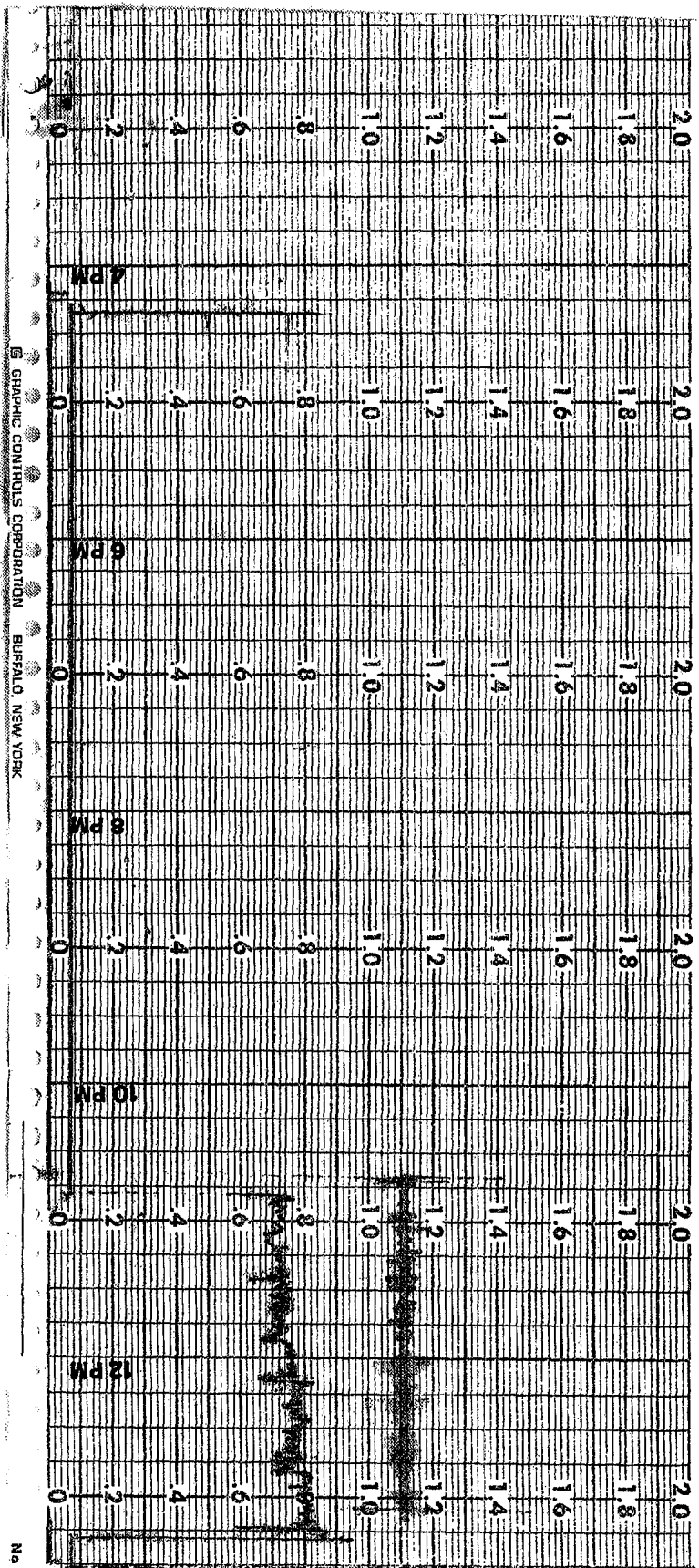
SHIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	10" "KROLOR" - YELLOW MEDIUM			
203 & 205	1 Run 10" (992 G) water into V-203 AND ADD	30	7-D	15
263	2 Weigh in drum & pour in	320	32-D	320
	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 11:00 PM	24201		
	Fin 12:30 AM	24078		
		24080		
	4 Adj to 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 1800-2000 psi using minimum water	263		
	7 Record V-205 Vol 54" & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
263	9 Run 10" (514G) water into SV & start agitator			
263	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time start 10:15 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 190-194F)			
	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 54% - preset #1 80 Gal		15-A	160
	b. 13LG 53% - preset #6 135 Gal		20-A	135
	15 Set strike flow controllers as follows:			
	a. 3EC10 (N-27-D Controller) in Manual 0.83 GPM		27-D	275
	b. 3EC20 (N-27-D Water) in Manual Local 5.28 GPM			
	c. 3ER10 (N-27-D/Water Ratio) 0.64			
	d. 8PC10 (N-32-D Controller) in Manual 1.08 GPM		32-D	1840
	e. 8EC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8PC20 (N-32-D Water) in Remote			
	g. 8ER10 (N-32-D/Water Ratio) 0.83			
SV & CP 4	16 Operator Step PB			
	17 Record Level 2 LG 88% If below 35% follow solution make-up procedure for N-27-D			
	18 Adj to 48" (2470 G)			
	19 Record pH 10.2			
	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	7-D	10
	Siphon into SV, Record pH 11.3			
	22 Operator Step PB			

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V-243

NT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACC LBS
	22	SP Step 06/40	After heat up Record: pH <u>10.0</u> (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:						
		SP STEP						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	<u>9.8</u>	9.0-10.0	<u>3:25 Pm</u>			
		14/47 (60 min)	<u>9.8</u>	9.0-10.0	<u>3:55 Pm</u>			
		15/48 (2 hrs)	<u>9.7</u>	9.0-10.0	<u>4:55 Pm</u>			
		16/49 (2 hrs 25 min)	<u>9.7</u>	9.0-10.0	<u>5:20 Pm</u>			
		17/50 (3 hrs Final)	<u>7.2</u>	7.5-8.5	<u>6:55 Pm</u>			
		NOTE: If not as specified notify Supervisor & note in log						
		If final pH is above 8.5, add pH to 7.5-8.5 &						
		Record: pH		Assume 77%			27-D	
9	29	While striking, run 30" (234 G) water into V-339						
	30	Add in 7-8 min				350	530-A	350
	31	Add to 49" (382 G) at 80 - 100°F						
	32	Stir 5 min & record pH <u>10.2</u> (9.5-10.5)						
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol <u>49</u> & calculate <u>49</u> (Vol) x 0.78 = <u>38.26</u>						
	35	Set preset #8 to <u>38.26</u> G from S 34						
	36	Add 30" (360 G) water to V-302						
102	37	Add & stir 2 min For S 41		Assume 50%		160	7-D	80
3	38	SP Step 17/50 - After checking pH, Operator Step PB						
	39	SIFT in 2 Bags				100	128-A	100
P	40	SP Step 23/53 - Record: pH <u>3.4</u> (3.7-4.2)						
&	41	Run in N-7-D from <u>537</u> in 10-12 min & stir 5 min						
P	42	Record: pH <u>9.2</u> (9.0-9.5) & if necessary add 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-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.1</u> (9.0-10.0) Time <u>6:35 Pm</u>						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish					
		Time SP Step	Time SP Step					
		<u>12:30A</u>	<u>7:00A</u>			<u>235-259</u>		
		<u>2:1A</u>	<u>3:1Pm</u>			<u>223-282</u>		
		<u>6:00Pm</u>	<u>6:40Pm</u>			<u>32-37</u>		





No. 315A164

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