

PUNCHED &amp; CHECKED

EST. WGT.

FEB 27

34537

1090 98

LBS.

STD. HRS.

8.9

TIME

11P M

14 - YC-2-B 98 4

Lot

24064

Lot

Lot

OK  
FP

| 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 |                 |

JH. Homog #4 - 1st Pass  
" #4 - 2nd "

Total Wgt. - 3490# 3370

NON-BLEEDING

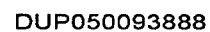
| UIPMENT | NAME:                                                                                       | USE LBS. | N CODE | ACCT. LBS. |
|---------|---------------------------------------------------------------------------------------------|----------|--------|------------|
| 203     | "KROLOR" - YELLOW MEDIUM                                                                    |          |        |            |
| 8       | 1 Run 60" (992 G) water into V-203. <i>Set agitator on high speed.</i>                      |          |        |            |
| 205     | 2 Weigh in drum & pour in                                                                   | 320      | 32-D   | 320        |
| 1       | 3 Dump in and stir 5 min                                                                    | 48 x 50  | YC-2-B | 2400       |
| 203     | Record: Start 3:00                                                                          | 24064    |        |            |
| 263     | Fin 3:30 AM                                                                                 |          |        |            |
|         | 25" (1275 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 1800-2000 psi using minimum water                |          |        |            |
|         | 7 Record V-205 Vol 263 " & adj to 60" (2100 G)                                              |          |        |            |
|         | 8 Inspect Homog strainer & clean if necessary                                               |          |        |            |
|         | <i>DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.</i>                                       |          |        |            |
| 203     | 9 Run 10" (514 G) water into SV & start agitator                                            |          |        |            |
| 263     | 10 Pump V-205 thru Homog at 4800-5200 psi into V- 243                                       |          |        |            |
| SV      | Record: Time start 2:15 PM Total Min 130                                                    |          |        |            |
| 2       | 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      | 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                                            |          |        |            |
| CP      | (Temperature is set at 190-194F)                                                            |          |        |            |
| 3       | 14 Record levels and set Raw Materials Counter #1 as follows:                               |          |        |            |
|         | a. 11LG 32% - preset #1 80 Gal                                                              |          | 15-A   | 160        |
|         | b. 13LG 59% - 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-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 4.47 GPM                                            |          |        |            |
|         | f. 8FC20 (N-32-D Water) in Remote                                                           |          |        |            |
|         | g. 8FR10 (N-32-D/Water Ratio) 0.83                                                          |          |        |            |
| SV      | 16 Operator Step PB                                                                         |          |        |            |
| SP      | 17 Record Level 2 LG 71 %. If below 35% follow solution make-up procedure for N-27-D        |          |        |            |
| &       | 18 Adj to 48" (2470 G)                                                                      |          |        |            |
| CP      | 19 Record pH 10.4                                                                           |          |        |            |
| 4       | 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       | 10     | 10         |
|         | Siphon into SV. Record pH 11.1                                                              |          |        |            |
|         | 21 Operator Step PB                                                                         |          |        |            |

V - 243

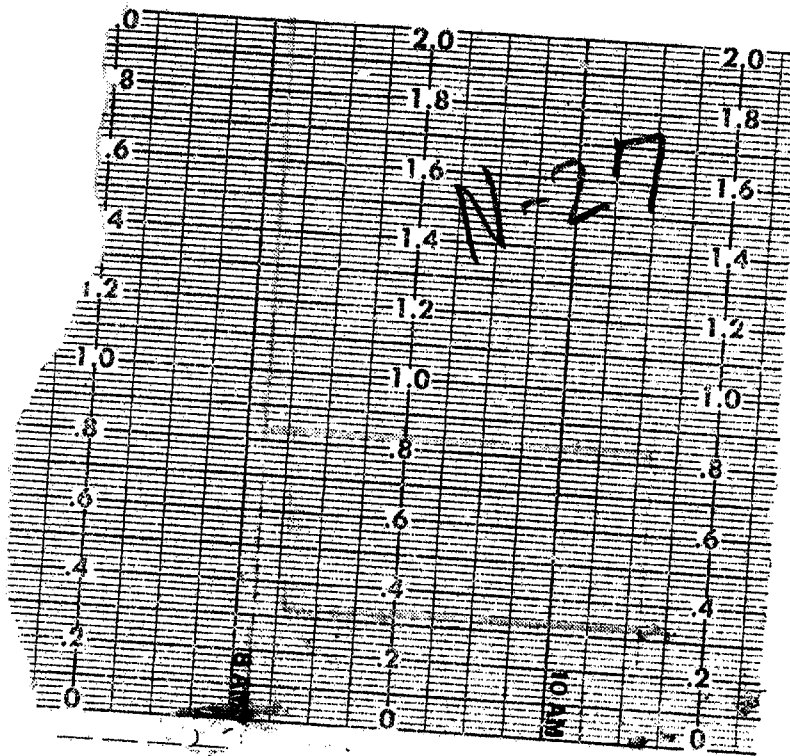
| JIPMENT | PAGE 2 | CG 03                                                                      | CODE KY-787-D  | EST. WGT. 3490 | LBS.        | USE LBS. | N CODE | ACCT LBS. |
|---------|--------|----------------------------------------------------------------------------|----------------|----------------|-------------|----------|--------|-----------|
| SV      | 22     | SP Step 06/39 - After heat up Record: pH <u>9.7</u> (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       |        | 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>9.5</u>     | 9.0-10.0       | <u>6:30</u> |          |        |           |
|         |        | 14/47 (60 min)                                                             | <u>9.5</u>     | 9.0-10.0       | <u>7:00</u> |          |        |           |
|         |        | 15/48 (2 hrs)                                                              | <u>9.6</u>     | 9.0-10.0       | <u>8:00</u> |          |        |           |
|         |        | 16/49 (2 hrs 25 min)                                                       | <u>9.65</u>    | 9.0-10.0       | <u>8:25</u> |          |        |           |
|         |        | 17/50 (3 hrs Final)                                                        | <u>7.55</u>    | 7.5-8.5        | <u>9:00</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   |           |
| 339     | 29     | While striking, run 30" (234 G) water into V-339                           |                |                |             |          |        |           |
| 6       | 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>38.2</u> G    |                |                |             |          |        |           |
|         | 35     | Set preset #8 to <u>38.2</u> 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     | Stir in 2 Bags                                                             |                |                |             | 100      | 128-A  | 100       |
| SP      | 40     | SP Step 23/53 - Record: pH <u>3.5</u> (3.7-4.2)                            |                |                |             |          |        |           |
| &       | 41     | Run in N-7-D from S 37 in 10-12 min & stir 5 min.                          |                |                |             |          |        |           |
| CP      | 42     | Record: pH <u>8.6</u> (9.0-9.5) & if necessary add pH 9.0-9.5              |                |                |             |          |        |           |
| 8       |        | & Record: pH <u>9.5</u> Assume 77%                                         |                |                |             |          | 27-D   |           |
|         |        | (Dilute 10 parts water to 1 part N-7-D) Assume 50%                         |                |                |             | 10       | 7-D    | 5         |
|         |        | Siphon N-7-D into SV                                                       |                |                |             |          |        |           |
|         | 43     | Operator Step PB                                                           |                |                |             |          |        |           |
|         | 44     | SP Step 29/58 Record: pH <u>9.6</u> (9.0-10.0) Time                        |                |                |             |          |        |           |
|         | 45     | Operator Step PB                                                           |                |                |             |          |        |           |
|         | 46     | SP Step 60 - Batch complete                                                |                |                |             |          |        |           |
|         |        | Start                                                                      | Finish         | Optr           |             |          |        |           |
|         |        | Time SP Step                                                               | Time SP Step   |                |             |          |        |           |
|         |        | <u>3:00 P</u>                                                              | <u>11:00 P</u> | <u>235-301</u> |             |          |        |           |
|         |        | <u>3:00 P</u>                                                              | <u>9:00 P</u>  | <u>235-342</u> |             |          |        |           |

V-243

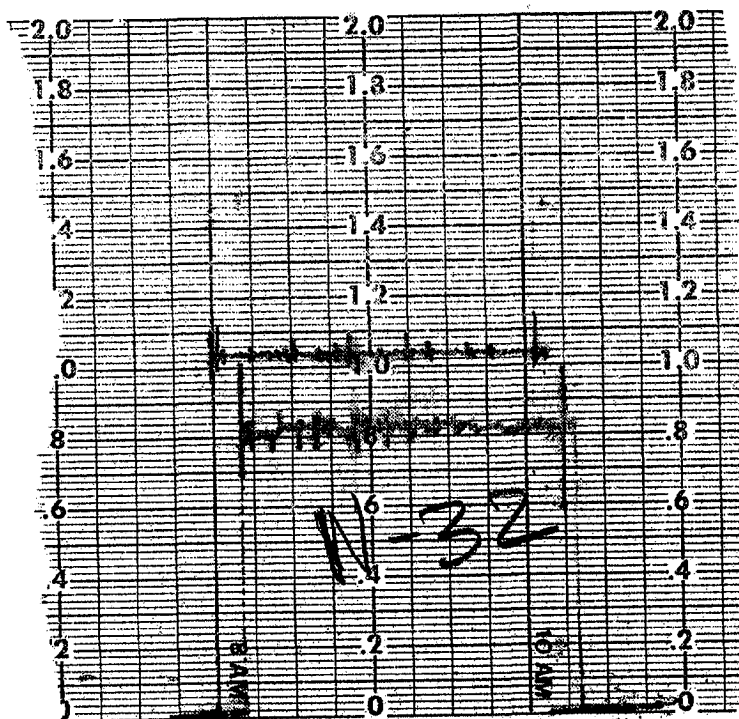
| JIPMENT | PAGE 2 CG 03 CODE KY-787-D                                                    | EST. WGT. 3490 | LBS. | USE LBS. | N CODE | ACCT LBS. |
|---------|-------------------------------------------------------------------------------|----------------|------|----------|--------|-----------|
| SV      | 22 SP Step 06/39 - After heat up Record: pH <u>10.0</u> (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       | 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) 9.9 9.0-10.0 11:55                                             |                |      |          |        |           |
|         | 14/47 (60 min) 9.9 9.0-10.0 12:25                                             |                |      |          |        |           |
|         | 15/48 (2 hrs) 9.9 9.0-10.0 1:25                                               |                |      |          |        |           |
|         | 16/49 (2 hrs 25 min) 9.9 9.0-10.0 1:50                                        |                |      |          |        |           |
|         | 17/50 (3 hrs Final) 8.5 7.5-8.5 2:25                                          |                |      |          |        |           |
|         | NOTE: If not as spec. notify Supervisor & note in log                         |                |      |          |        |           |
|         | If final pH is above 8.5, adj pH to 7.5-8.5 &                                 |                |      |          |        |           |
|         | Record: pH <u>✓</u> Assume 77%                                                |                |      |          | 27-D   |           |
| 339     | 29 While striking, run 30" (234 G) water into V-339                           |                |      |          |        |           |
| 6       | 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>10.1</u> (9.5-10.5)                              |                |      |          |        |           |
|         | 33 Stir 15 min or longer to dissolve for SP Step 26                           |                |      |          |        |           |
|         | 34 Record Vol <u>50</u> & calculate <u>50</u> (Vol) x 0.78 = <u>39.06</u>     |                |      |          |        |           |
|         | 35 Set preset #8 to <u>37.0</u> 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 <u>3.7</u> (3.7-4.2)                            |                |      |          |        |           |
| &       | 41 Run in N-7-D from <u>27</u> in 10-12 min & stir 5 min.                     |                |      |          |        |           |
| CP      | 42 Record: pH <u>10.2</u> (9.0-9.5) & if necessary adj pH 9.0-9.5             |                |      |          |        |           |
| 8       | & Record: pH <u>7.3</u> Assume 77%                                            |                |      | 18       | 27-D   | 14        |
|         | (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>9.3</u> (9.0-10.0) Time <u>4:15 AM</u>         |                |      |          |        |           |
|         | 45 Operator Step PB                                                           |                |      |          |        |           |
|         | 46 SP Step 60 - Batch complete                                                |                |      |          |        |           |
|         | Start Finish Optr                                                             |                |      |          |        |           |
|         | Time SP Step Time SP Step                                                     |                |      |          |        |           |
|         | <u>6:00 AM</u> <u>7:00 PM</u> <u>12:15</u>                                    |                |      |          |        |           |
|         | <u>7:00 AM</u> <u>3:00 PM</u> <u>145</u>                                      |                |      |          |        |           |
|         | <u>3:00 PM</u> <u>11:00 PM</u> <u>235</u>                                     |                |      |          |        |           |
|         | <u>4:00 PM</u> <u>4:00 PM</u> <u>727</u>                                      |                |      |          |        |           |



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