MAKING INSTRUCTIONS BATCH CR

243, 244 (Automated) C.V. D.V.

1/2/80

CG 03 CODE KY-795-D PKG. _____

DEP 33506

EST. WGT. 1162 ~~1110~~ LBS.

STD. HRS. 8.2 TIME _____ M 3 PM

OK / AP

PROCESSES		APPROVED BY
( ) KY-795-D	(H)	EWK 10-05-76
( )	( )	DCG 10-07-76
( )	( )	MTW 10-11-76
( )	( )	FWP 12-22-78
TYPED BY		
emw122278		

14 YC-2-B 93 4 Lot 24071, 2000 # JW

14 YC-2-B 93 4 Lot 24073, 1500 #

14 YC-2-B 93 4 Lot _____, _____ #

(1)

Total Wgt. ~~4612#~~ 4662

Homog # 3 - 2nd Pass

NON-BLEEDING

SHIPMENT		NAME: KROLOR® YELLOW MEDIUM	USE LBS.	N CODE	ACC LBS.
203 & 205 1	1	Run 60" (992 G) water into V-203			
	2	Weigh in drum & pour in	475	32-D	475
	3	Dump in & stir 5 min Lot	70 x 50	YC-2-B	3500
		Record: Start 7:32 A.M. 24071	2000		
		Fin 9 A.M. 24073	1500		
		75" (1275 G)	3500		
	4	Adj to ~~78" (1328 G)~~			
	5	Pump V-203 thru Homog at 2400-2600 psi into V-205			
	6	When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7	Record: V-205 Vol 51 " & adj to 51" (1874 G)			
	8	Inspect Homog strainer & clean if necessary			
205 & 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 2:30 Pm Total Min 130			
		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. Rinse in using Hot Water			
SP & CP 3	12	SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (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:			
		a. 11 LG 56 % - preset #1 104 Gal		15-A	208
	15	Set strike flow controllers as follows:			
		a. 3FC10 (N-27-D Controller) in Manual 0.95 GPM		27-D	394
		b. 3FC20 (N-27-D Water) in Manual Local 7.7 GPM			
		c. 3FR10 (N-27-D / Water Ratio) 0.8			
		d. 8FC10 (N-32-D Controller) in Manual 1.27 GPM		32-D	2675
		e. 8FC20 (N-32-D Water) in Manual Local 6.2 GPM			
		f. 8FC20 (N-32-D Water) in Remote			
		g. 8FR10 (N-32-D / Water) Ratio 1.0	E-6		
SV SP & CP 4	16	Operator Step PB			
	17	Record Level 2LG 66 % if below 35% follow solution make-up procedure for N-27-D			
	18	Adj SV to 68" (3495 G)			
	19	Record: pH 10.7 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
		Siphon N-7-D into SV & Record: pH 11.1			
	20	Operator Step PB			

20 REV.

V-244

UIPMENT		PAGE 2 CG 03 CODE KY-795-D (H) EST. WGT. 4612 LBS	USE LBS.	N CODE	ACCT LBS.
SV	21	SP Step 06/39 - After heat up Record: pH 9.7 (9.5-10.0)			
SP	22	Switch 3FC20, 8FC10, 8FC20, to Auto			
&	23	Operator Step PB			
CP	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits			
5		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:	6	6:55 Min	
		SP Step			
		V-243/V-244 pH Range Time			
		13/46 (30 min) 9.6 9.0-10.0 7:25			
		14/47 (60 min) 9.65 9.0-10.0 7:55	Increased		N-27
		15/48 (2 hrs) 9.7 9.0-10.0 8:55 ← 0.9#			
		16/49 (3 hrs) 9.7 9.0-10.0 9:55			
		17/50 (Final) 7.4 7.5- 8.5 10:40			
		NOTE: If not as specified notify Supervisor & note in log			
		If final pH above 8.5 adj to 7.5-8.5			
		& Record: pH Assume 77%		27-D	
Drum	28	Weigh into 55 Gal Drum Assume 50%	56	7-D	28
7	29	Fill with water & stir 2 min			
SV	30	SP Step 17/50 - After checking pH, Operator Step PB			
SP	31	Step 23/53 - Record: pH 3.4 (3.3-3.7)			
&	32	If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH		15-A	
CP	33	Sift in ~~9 bags~~	200 ~~150~~	128-A	~~150~~ 200
8	34	Siphon in N-7-D from S 29 in 10-12 min & stir 5 min			
	35	Record: pH 4.0 (4.0-4.2) & if necessary adj to pH 4.0-4.2			
		& 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			
	36	Operator Step PB			
	37	SP Step 24/54 - Pour in & stir 15 min	22	978-A	22
	38	Operator Step PB			
	39	SP Step 60 - Batch complete			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
7:30 AM		3:00 PM		320-141 064
3:00 P		11:60 PM		235 - 259

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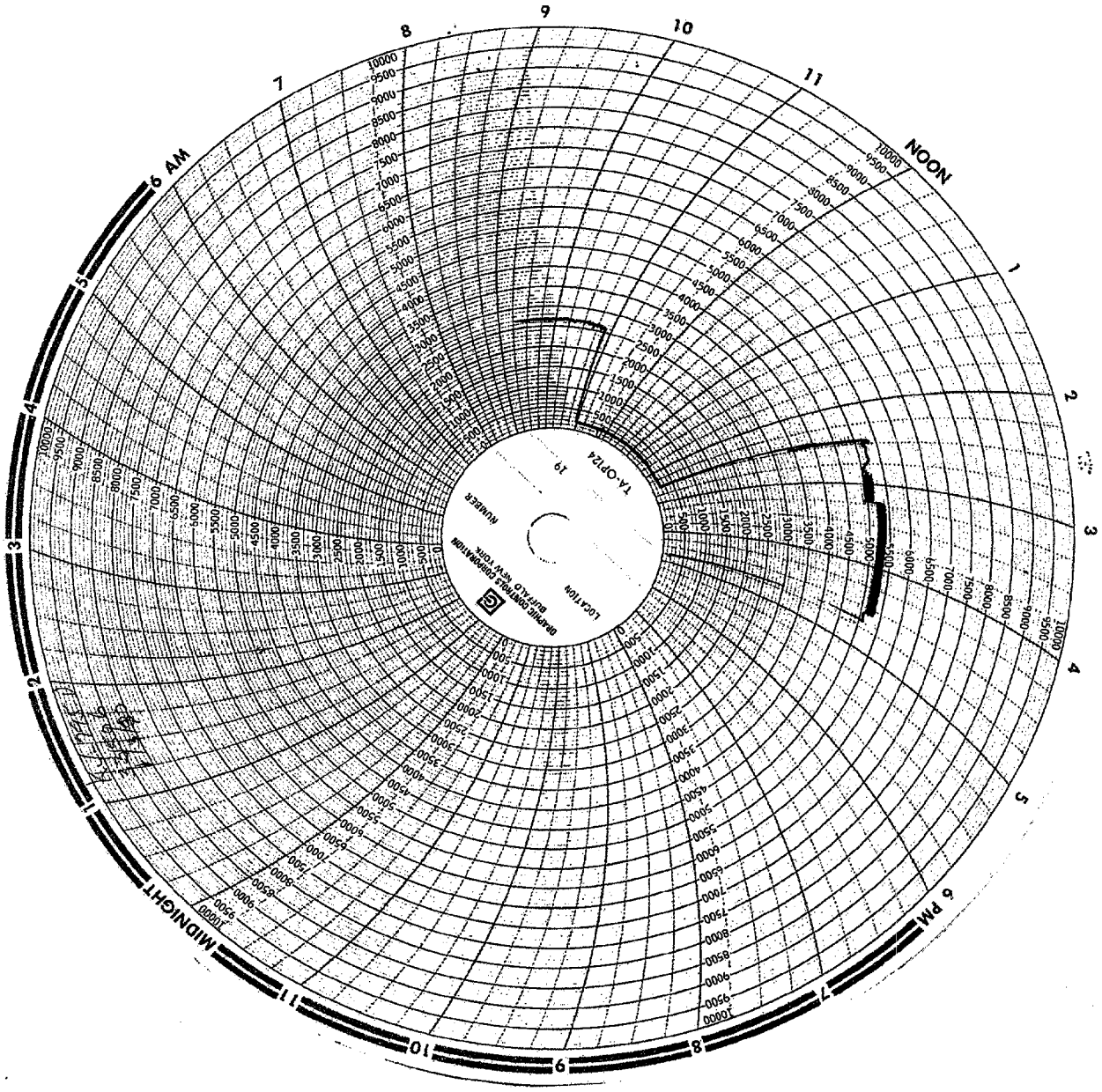

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V-24

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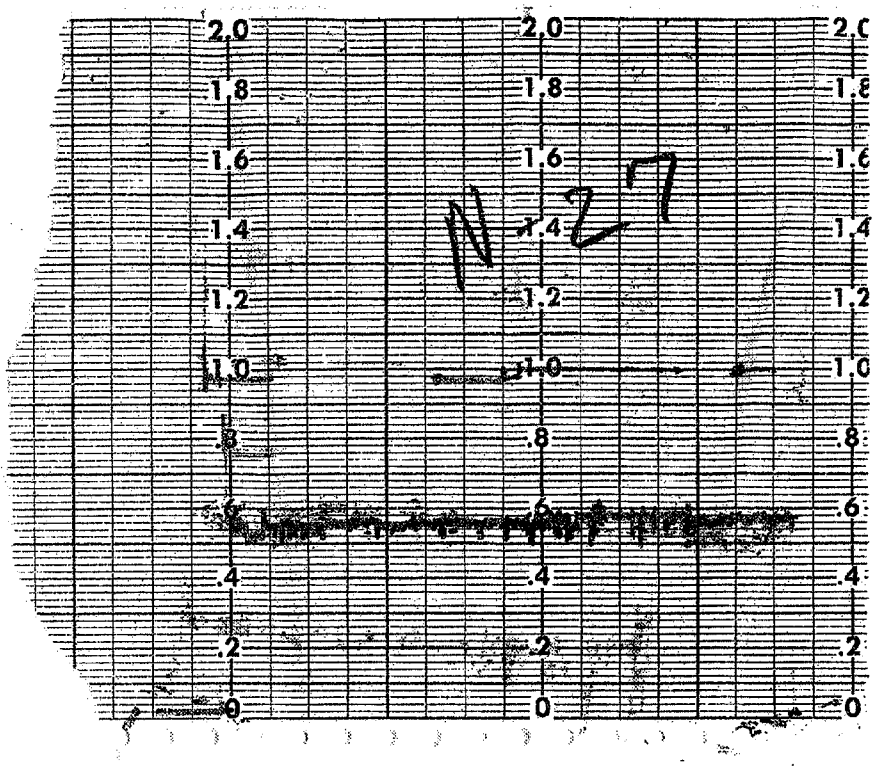
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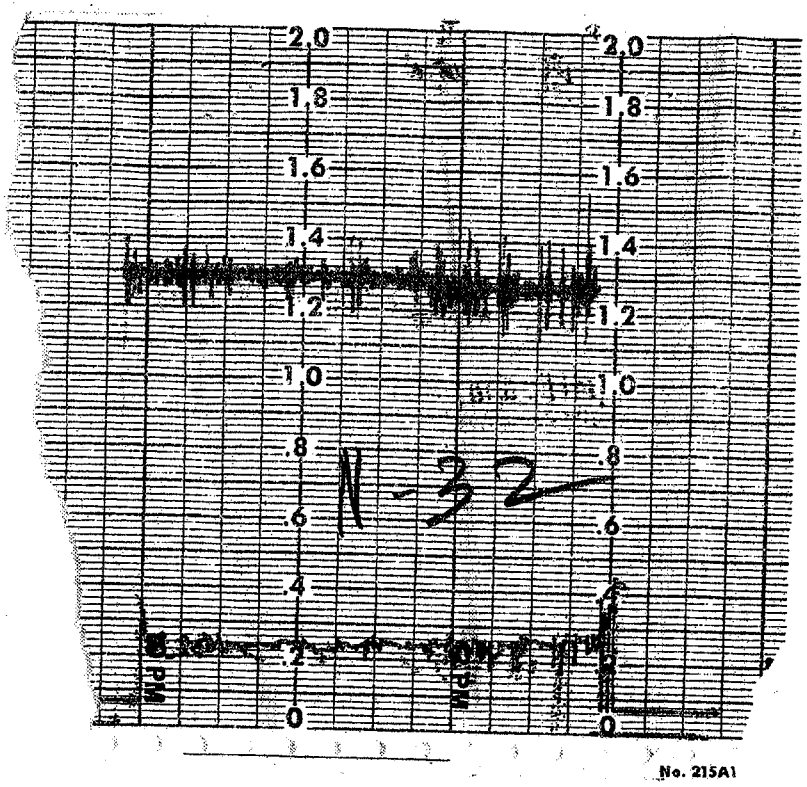

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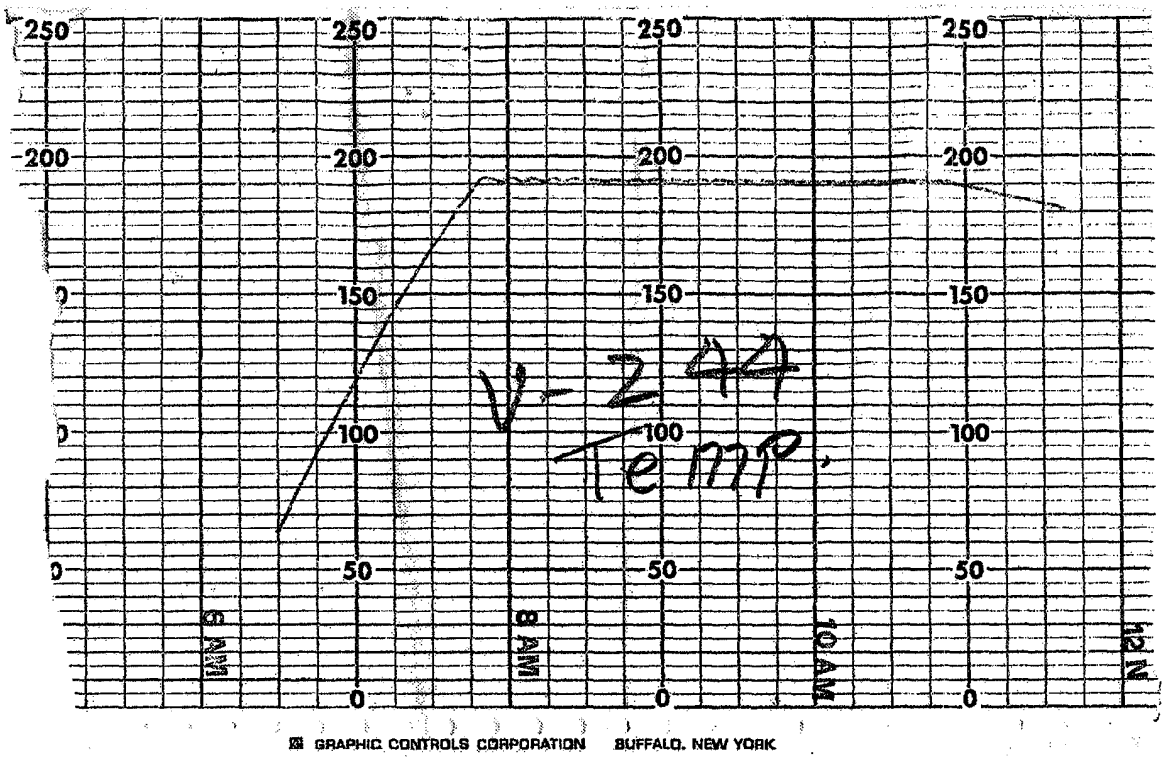
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GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK