

C6 03 CODE KY-788-D PKG.

MAR 15 34888

EST. WGT. 960 *860 LBS.

STD. HRS. 8.8

TIME

14 YC-3-B 98 4 Lot 24406, 2600

14 YC-3-B 98 4 Lot

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PUNCHED & CHECKED

PROCESSES	APPROVED BY
✓ KY-788-D	(J) EWK 9/28/76
✓	✓ MTW 9/30/76
✓	✓ DCG 9/30/76
✓	✓
TYPED BY	
NE 2-18-77	

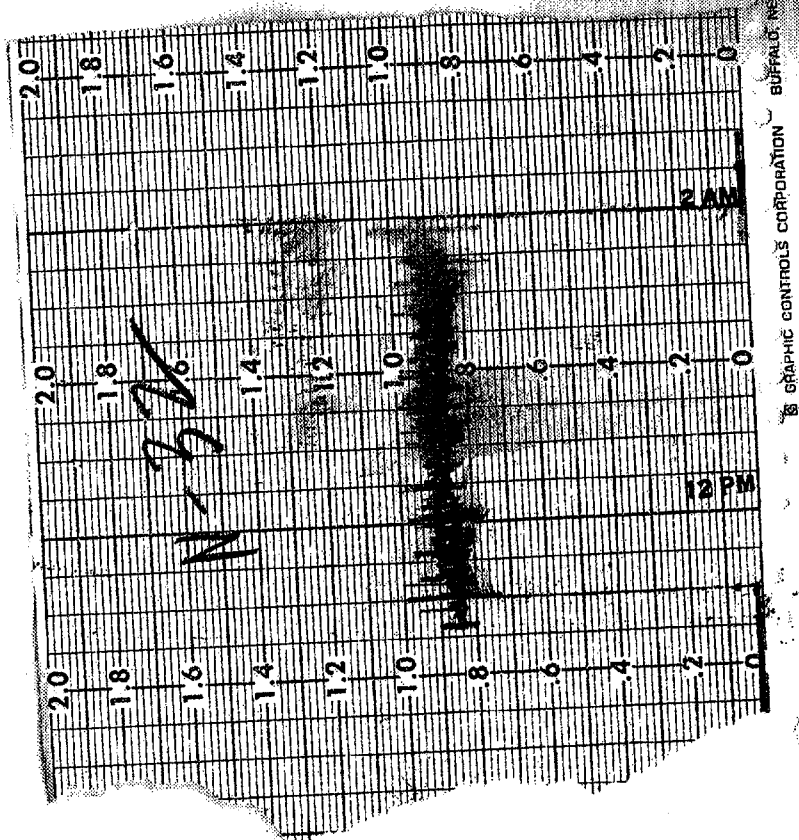
Total Wgt. 3560# 346 MAR 19 1980

NON-BLEEDING

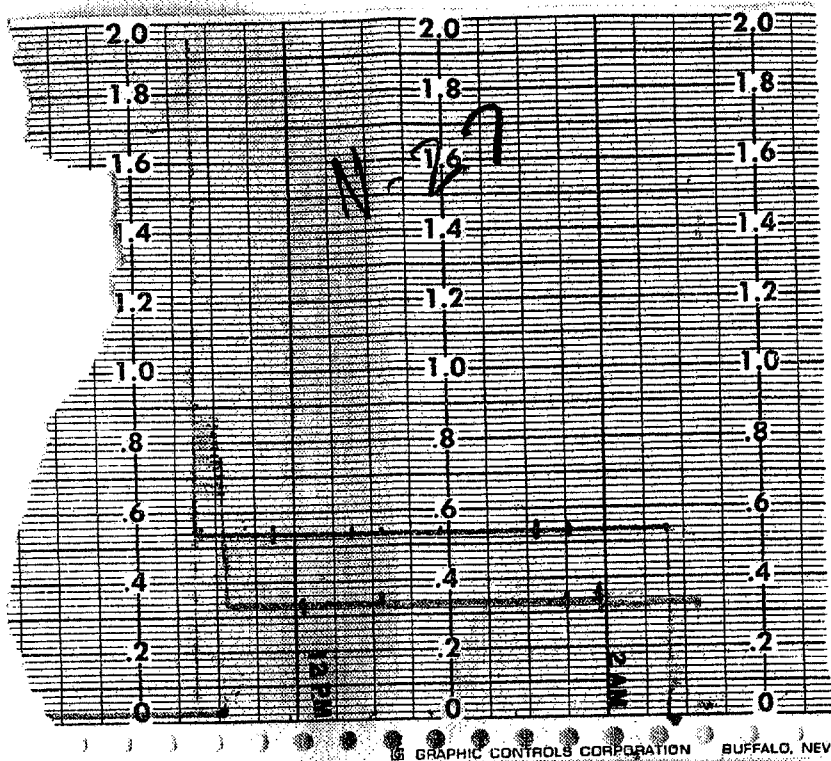
JIPMENT	NAME	USE LBS.	N CODE	ACC LBS
203	6. "KROLOR" YELLOW - LIGHT			
&	1. Run 25" (350 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
205	2. Weigh in drum & pour in	345	32-D	345
1	3. Dump in & stir 5 min	52 x 50	YC-3-B	2600
	Record: Start 4:30 A.M.	24406		
	Fin 5:30 A.M.	2600		
	75" (1275 G)			
	4. Adj to 70" (1200 G) 2400-2600			
	5. Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6. When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water			
	7. Record: V-205 Vol 44 "& adj to 60" (2100 G)			
	8. Inspect homog. strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205	9. Run 10" (514 G) water into V- 244 & start agitator			
SV	10. Pump V-205 thru Homog at 4800-5200 psi into V-			
2	Record: Time Start 8:00 A.M. 135			
	Note: If Homog pressure falls below 4800 ps., 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 A1 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
&	13. Press SV Cam Reset PB- set 22 TC in Auto Remote			
CP	(Temperature is set at 190-194 F)			
3	14. Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 60% - preset #2 208 Gal		15-A	416
	b. 13LG 47% - preset #6 135 Gal		20-A	135
	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. 3ER10 (N-27-D/Water) Ratio 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 0.77 GPM 0.90		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			
320	16. Operator Step PB			
243	17. Record Level 21G 56%. If below 35% follow solution			
SP	make-up procedure for N-27-D			
&	18. Adj SV to 47" (2400 G)			
CP	19. Record pH 10.9. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
4	Siphon into SV & Record: pH 11.2			
	20. Operator Step PB			

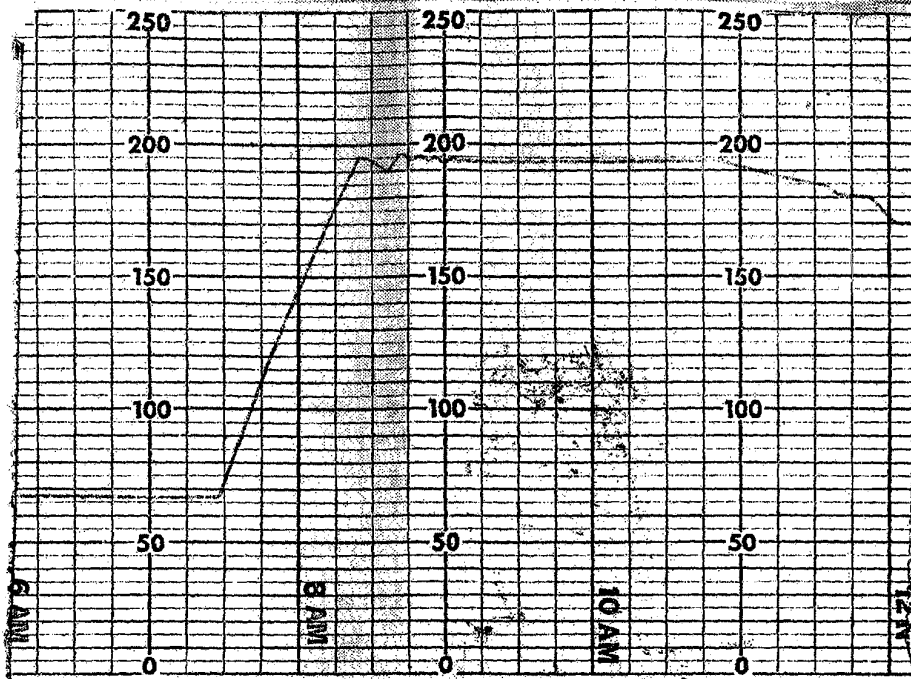
V-244

UIPMENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACCT LBS
SV	21	SP Step 06/39 - After heat up Record: pH 9.9 (9.5-10.0)						
SP	22	Switch 3FC20. 8FC10. 8FC20 to Auto						
	23	Operator Step PB						
5	24	SP Step 10/43 - When 3FC20. 8FC10. 8FC20 water flows is 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:					11:50 AM	
		SP Step						
		V-244/244	pH	Range	Time			
		13/48 (30 min)	9.7	9.3-10.0	12:20			
		14/47 (60 min)	9.65	9.3-10.0	12:50			
		15/48 (2 hrs)	9.65	9.3-10.0	1:50			
		16/49 (2 hrs 25 min)	9.65	9.3-10.0	2:15			
		17/50 (Final 3 hrs)	7.5	7.5-8.5	2:50			
		Note: If not as specified notify Supervisor & Note in log						
		If final pH is above 8.5, adj 7.5-8.5						
		& Record: pH Assume 77%					27-D	
339	28	While striking run 30" (234 G) water into V-339						
6	29	Add in 7-8 min				350	530-A	350
	30	Adj to 49" (382 G) at 80-100 OF						
	31	Stir 5 min & record pH 10.1 (9.5-10.5)						
	32	Stir 15 min or longer to dissolve for SP Step 26/56						
	33	Record Vol 4.9 " & Calculate 4.9 " (Vol X 0.78 = 38.2 G)						
	34	Set preset #8 to 38.2 from S 33						
302	35	Run 40" (440 G) water into V-302						
7	36	Add & stir 2 min for S 40 Assume 50%				360	7-D	180
SV	37	SP Step 17/50 After checking pH. Operator Step PB						
SP	38	Sift in 2 bags				100	120-A	100
	39	SP Step 23/53 Record: pH 3.2 (3.7-4.2)						
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min						
	41	Record: pH 9.4 (9.0-9.5) & if necessary adj to pH 9.0-9.5						
		& 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						
	42	Operator Step PB						
	43	SP Step 29 - Record: pH 9.9 (9.0-10.0) Time						
	44	Operator Step PB						
	45	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time	SP Step	Time	SP Step			
		7:00A		3:00PM		2:35		
		3-P		4-P		120		
		METERING			N-32 settings			
		START 11:50AM	P.H. - 9.9			0.90		
		12:05PM	9.7					
		12:20	9.7					
		12:35	9.65			Adj to 0.92		
		12:50	9.65					
		1:50	9.65					
		2:15	9.65					
		2:50	7.5					



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