

CG 03 CODE KY-787-D PKG.

FEB 26 34561

EST. WGT. 1090-990 LBS.

STD. HRS. 8.9 TIME 11 PM

14 - YC-2-B 98 4 Lot 24477.1600 #
Lot 24469.800 #
Lot

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	

PUNCHED & CHECKED 4 - 1st Pass
" 3 - 2nd "

Total Wgt. - 3490# 3390

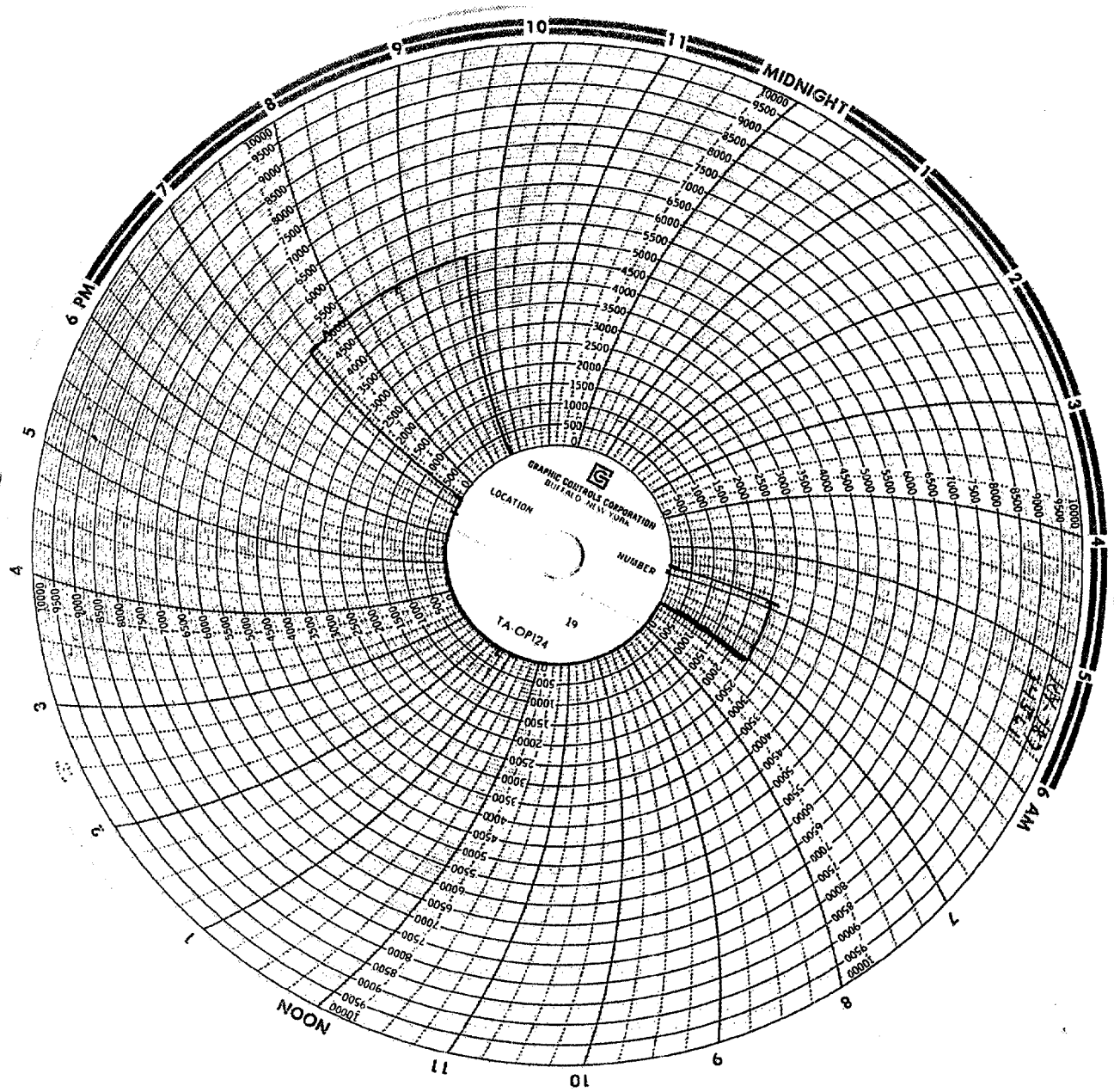
FEB 29

NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	"KROLOR" - YELLOW MEDIUM			
&	1 Run 60" (992 G) water into V-203. Set agitator on high speed.			
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
	Record: Start 2:30 AM			
	Fin 3:30 AM	1600		
	75" (1275 G)	24464		
	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, wash color thru Homog at 1800-2000 psi using minimum water			
	7 Record V-205 Vol 4.2 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED			
205	10 Run 10" (514 G) water into SV & start agitator			
&	11 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time start 7:30 Total Min 140			
2	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
	12 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
SP	13 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
&	14 Press SV Cam Reset PB-set 22TC in Auto Remote			
CP	(Temperature is set at 190-194F)			
3	15 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 58 % - preset #1 80 Gal		15-A	160
	b. 13LG 44 % - preset #6 135 Gal		20-A	135
	16 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	17 Operator Step PB			
SP	18 Record Level 2 LG 68 %. If below 35% follow solution make-up procedure for N-27-D			
&	19 Adj to 48" (250 G)			
CP	20 Record pH 10.6			
4	21 Adj to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% (10 parts water to 1 part N-7-D)	22	7-D	11
	Siphon into SV. Record pH 11.1			
	22 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>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: <u>11:25 AM</u>					
	SP STEP					
	V-243/V-244 pH Range Time					
	13/46 (30 min) <u>9.9</u> 9.0-10.0 <u>11:55</u>					
	14/47 (60 min) <u>9.9</u> 9.0-10.0 <u>12:25</u>					
	15/48 (2 hrs) <u>9.9</u> 9.0-10.0 <u>1:25</u>					
	16/49 (2 hrs 25 min) <u>9.9</u> 9.0-10.0 <u>1:50</u>					
	17/50 (3 hrs Final) <u>8.5</u> 7.5-8.5 <u>2:25</u>					
	NOTE: If not as spec'd 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 Adj 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>39.0G</u>					
	35 Set preset #8 to <u>39.0G</u> 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 GIFT 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>7</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>2:00 PM</u> <u>145</u>					
	<u>3:00 PM</u> <u>11:00 PM</u> <u>235</u>					
	<u>4:00 PM</u> <u>4:30 PM</u> <u>222</u>					



V-2A3

