

CG 03 CODE KY-787-D PKG.

EST. WGT. 1090 990 LBS.

STD. HRS. 8.9 TIME

14 - YC-2-B 98 4 Lot 24066, 2400 #

Lot
Lot

PUNCHED & CHECKED

MAR - 5 1980

4 2ND PASS

Total Wgt. - 3490# 3390

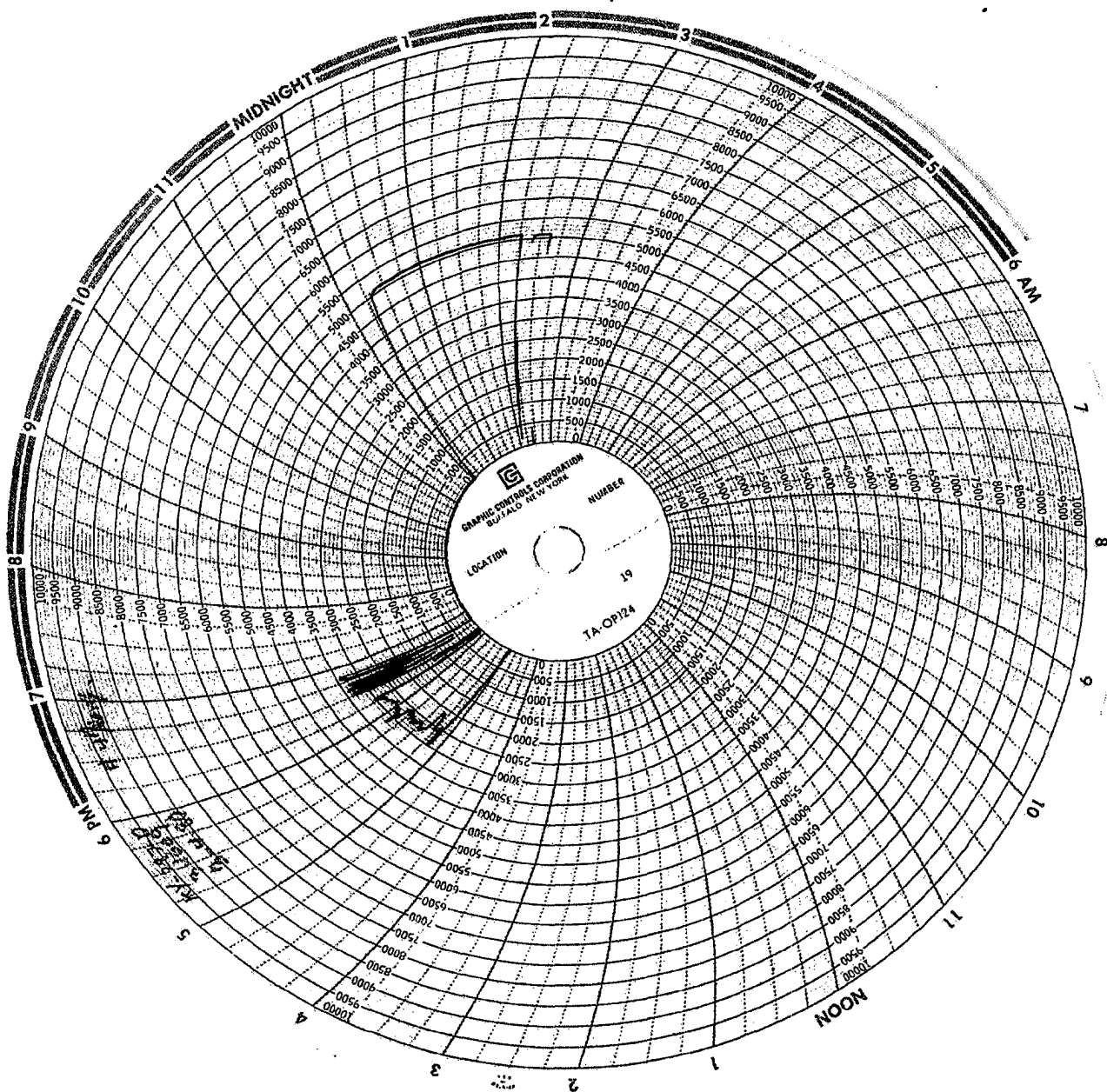
NON-BLEEDING

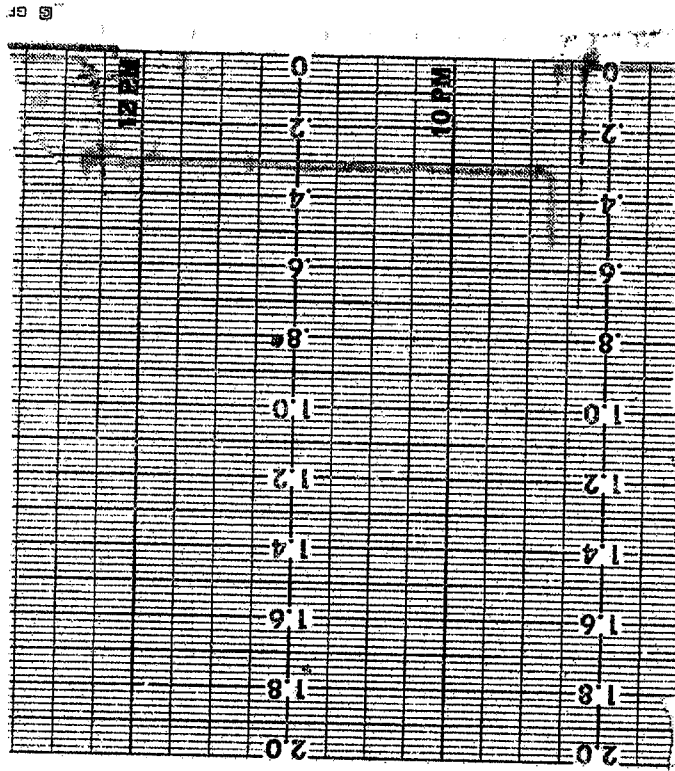
PROCESSES		APPROVED BY	
() KY-787-D	()	EWK	9/22/76
()	()	DCG	9/27/76
()	()	MTW	9/30/76
()	()		
TYPED BY			
N.E. 2/12/77			

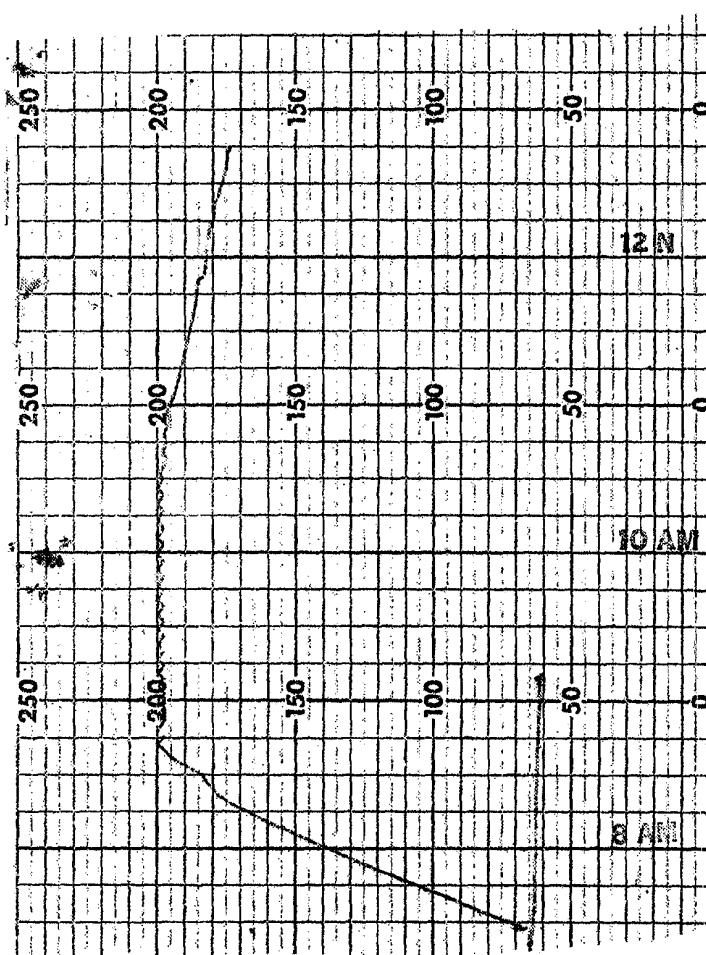
IPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	"KROLOR" - YELLOW MEDIUM			
203 & 205	1 Run 60" (992 G) water into V-203. Set agitator on high speed.			
1	2 Weigh in drum & pour in	320	32-D	320
	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 2:35 PM	2400		
	Fin 4:20 PM			
	75" (1275 G)			
	Adj to 70" (1200 G) 2400-2600			
263	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 42" & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	During Homog, RUN V-203 agitator on low speed.			
205 & SV	9 Run 10" (514 G) water into SV & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into V-247			
	Record: Time start 12:30 AM Total Min 120			
	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
263	11 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
SP & CP	12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
3	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 36% - preset #1 80 Gal		15-A	160
	b. 13LG 23% - 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. 3FC10 (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 & CP	16 Operator Step PB			
4	17 Record Level 2 LG 90%. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj to 48" (2470 G)			
	19 Record pH 10.6			
	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)	24	1-D	12
	Siphon into SV. Record pH 11.3			
	21 Operator Step PB			

V-244

JIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT. LBS.
	2	03	KY-787-D	3490				
SV	22	SP Step 06/39 - After heat up Record: pH <u>9.9</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	25	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>5:10</u>			
		14/47 (60 min)	<u>9.8</u>	9.0-10.0	<u>5:40</u>			
		15/48 (2 hrs)	<u>9.8</u>	9.0-10.0	<u>6:40</u>			
		16/49 (2 hrs 25 min)	<u>9.7</u>	9.0-10.0	<u>7:00</u>			
		17/50 (3 hrs Final)	<u>8.0</u>	7.5-8.5	<u>7:40</u>			
		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 Assume 77%						
							27-D	
339	29	While striking, run 30" (234 G) water into V-339						
6	30	Add in 7-8 min						
	31	Add to 49" (382 G) at 80 - 100°F					350	530-A 350
	32	Stir 5 min & record pH (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>38.28</u>						
	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	SIFT in 2 Bags					100	128-A 100
SP	40	SP Step 23/53 - Record: pH <u>3.4</u> (3.7-4.2)						
&	41	Run in N-7-D from <u>37</u> in 10-12 min & stir 5 min.						
CP	42	Record: pH <u>9.2</u> (9.0-9.5) & if necessary adj pH 9.0-9.5						
8		& Record: pH Assume 77%						
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%						
		Siphon N-7-D into SV					7-D	
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.2</u> (9.0-10.0) Time <u>8:58</u>						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start		Finish		Optr		
		Time	SP Step	Time	SP Step			
		<u>11:00 AM</u>		<u>7:00 AM</u>		<u>4:09-387</u>		
		<u>7:00 PM</u>		<u>9:00 PM</u>		<u>126</u>		







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