

243204 (Automated) C6 03 CODE KY-787-D PKG. PUNCHED & CHECKED

FEL 28 34610

EST. WGT. 1090 99% LBS.

MAR - 3 1980 OK

STD. HRS. 8.9 TIME 3P M

14 - YC-2-B 98 4 Lot 24480, 2000 #
Lot 24064, 400 #
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	

Homog # 3 - 1st Pass

Total Wgt. - 3490# 3390

NON-BLEEDING

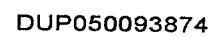
PMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	"KROLOR" - YELLOW MEDIUM			
03	1 Run 60" (992 G) water into V-203. Set V-203 agitator on high speed			
&	2 Weigh in drum & pour in	320	32-D	320
05	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start 8:01 AM Lot 24480 Fin 9:00 AM 24064	2000		
	25" (1275 G)			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water			
	7 Record V-205 Vol 54 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOGS, RUN V-203 AGITATOR ON LOW SPEED.			
05	9 Run 10" (514 G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-			
2	Record: Time start 9:35 AM Total Min 1:00			
	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 31 % - preset #1 80 Gal	15-A	160	
	b. 13LG 50 % - 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 50 %. If below 35% follow solution			
7ET	make-up procedure for N-27-D			
&	18 Adj to 48" (2470 G)			
CP	19 Record pH 10.1			
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)	10	1-D	5
	Siphon into SV. Record pH 11.2			
	21 Operator Step PB			

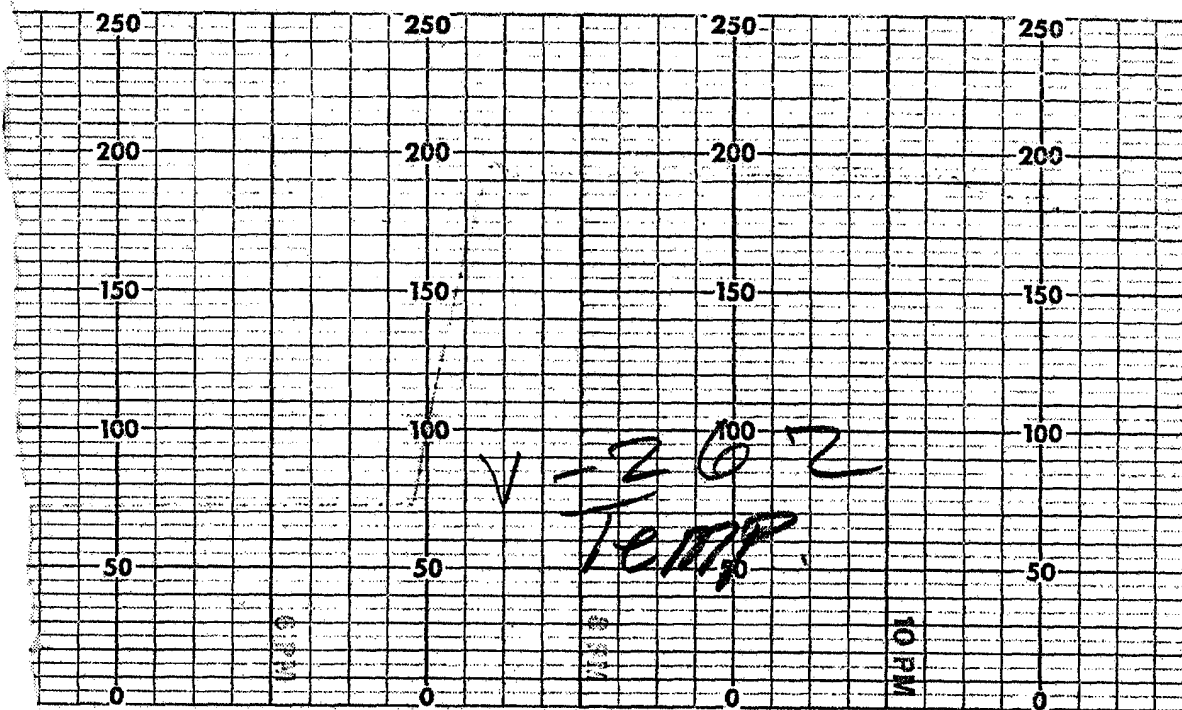
N 2632

N-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			10.0 (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	26	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			1.50			
	28	During strike, record pH & time as follows:						
		SP STEP						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	9.7	9.0-10.0	2:120			
		14/47 (60 min)	9.7	9.0-10.0	2:150			
		15/48 (2 hrs)	9.5	9.0-10.0	3:150			
		16/49 (2 hrs 25 min)	9.45	9.0-10.0	4:15			
		17/50 (3 hrs Final)	9.5	7.5-8.5	4:50			
		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			10.4 (9.5-10.5)			
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol 49" & calculate 49" (Vol) x 0.78 = 38.2 G						
	35	Set preset #8 to 38.2 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			3.2 (3.7-4.2)			
&	41	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
CP	42	Record: pH 9.2 (9.0-9.5) & if necessary add pH 9.0-9.5						
8		& Record: pH 9.2			Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D)			Assume 50%	18	7-D	9
		Siphon N-7-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH			9.2 (9.0-10.0) Time 5:45/P			
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time	SP Step	Time	SP Step			
		3:00P		11:00P		235-342		
		7P		3P		120-201		
		3:00P		5:50P		235-259		

EQUIPMENT	PAGE 2	CG03	CODE KY-787-D (R)	EST. WGT.	3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete Record: pH <u>10.0</u> (9.5-10.0)							
	26	Set V-343 acid pump at 82 setting (± 150 min)							
	27	Set V-349 silicate pump at 72 setting (± 120 min)							
	28	Immediately meter in V-343 & 349, Maintain SV at 190-193F during strike							
	29	Record:	Start	Finish	Minutes				
		V-343	<u>1:20 P</u>	<u>4:00 P</u>	<u>170</u>				
		V-349	<u>1:40 P</u>	<u>3:25 PM</u>	<u>125</u>				
		Record:	Time	V-343 in	V-349 in	SV pH	Normal pH		
		at 20 min	<u>1:40 P</u>	(35)	(14)	<u>9.9</u>	9.3-10.0		
		40 min	<u>2:00 P</u>	(30)	(11)	<u>9.9</u>	9.3-10.0		
		1 hr	<u>2:20 P</u>	(24)	(9)	<u>9.9</u>	9.3-10.0		
		2 hrs	<u>3:20 P</u>	(8)	(0)	<u>10.0</u>	9.3-10.0		
		Finish	<u>4:00 P</u>	0		<u>7.35</u>	8.5		
		Note: If pH drops below 9.0 in 1st hr, stop pumps & see Supv.							
		If final pH is above 8.5 adj to 7.5-8.5 & Record: pH							
		Assume 77 %						27-D	
330 7	30	Run 20" (392 G) water into V-330 & heat to 80-100 OF							
	31	Add in 7-8 min				350	530-A	350	
	32	Stir 5 min & Record: pH <u>6.5</u> (9.5-10.5)							
	33	Stir 20 min or longer to dissolve for S 46							
357 8	34	Run 11" (80 G) water into V-357 & heat to 135-140 OF							
	35	Dump in & stir to dissolve for S-42				160	15-A	160	
302 9	36	Run 30" (360 G) water into V-302							
	37	Add & stir 2 min for S44				Assume 50%	180	7-D	90
SV 10	38	When V-349 MTY, Rinse in with minimum water then set pump to zero setting							
	39	When V-343 MTY, rinse in with minimum water then turn off pump motor							
	40	Turn off steam							
	41	Sift in 2 bags				100	128-A	100	
	42	Run in V-357 from S 35 & stir 5 min							
	43	Record: pH <u>3.5</u> (3.7-4.2)							
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min							
	45	Record: pH <u>9.2</u> (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 into SV							
	46	Run in V-330 thru 20 mesh screen & stir 20 min							
313 11	47	Run 10" (128 G) water into V-313 & dump in				135	20-A	135	
	48	Stir 5 min to dissolve for S 49							
SV 12	49	Run V-313 into SV in 15-20 min							
	50	Stir 15 min							
	51	Record: pH <u>9.3</u> (9.0-10.0)							
	52	Stop agitator <u>Do not stop V-065.</u>							
		START	FINISH	OPTR					
		<u>3:00 P</u>	<u>5:20 P</u>	<u>235-342</u>					
		Step	V-262 (20 RPM)	V-243, 244, 246, 247					
		9	5"	10"					
		18	25"	48"					





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