

CG 03 CODE KY-788-D PKG.

MAR 11 34818 PUNCHED & CHECKED
EST. WGT. 960 860 LBS.

STD. HRS.	8.8	TIME
14 YC-3-B	98	4 Lot 24403
14 YC-3-B	98	4 Lot 24402
14 YC-3-B	98	4 Lot 24402

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		

Homog #3 - 1ST Pass
"S" #3 - 2ND " "

Total Wgt. 3560# 3460

NON-BLEEDING

MENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" "KROLOR" YELLOW - LIGHT			
203	1 Run 23" (360 G) water into V-203. RUN AGITATOR ON HIGH SPEED			
203	2 Weigh in drum & pour in	345	32-D	345
203	3 Dump in & stir 5 min	52 x 50	YC-3-B	2600
	Record: Start 2:20 AM	24403		
	Fin 3:55 AM	24402		
	75" (1275 G)			
	Adj to 70" (1200 G)			
	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 " & adi 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-243 & start agitator			
205	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time Start 5:10 AM total min 70			
	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 #3 (V-243) or #8 (V-244)			
&	13 Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
CP	14 Record levels and set Raw Material Counter #1 as follows			
3	a. 11LG 53% - preset #2	208 Gal	15-A	416
	b. 13LG 67% - 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		
	b. 3FC20 (N-27-D Water) in Manual Local	4.4 GPM		
	c. 3FR10 (N-27-D/Water) Ratio	0.8		
	d. 8FC10 (N-32-D Controller) in Manual	0.72 GPM		
	e. 8FC20 (N-32-D Water) in Manual Local	3.9 GPM	32-D	1215
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water) Ratio	1.1		
	16 Operator Step PB			
	17 Record Level 21G 88%. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.2. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.2	20	7-D	10
	20 Operator Step PB			

V-243

ENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS
21	SP Step 06/39 - After heat up Record: pH	9.8	(9.5-10.0)					
22	Switch 3FC20. 8FC10. 8FC20 to Auto							
23	Operator Step PB							
24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits.							
	Swich 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:							
	SP Step							
	V-243/V-244	pH	Range	Time				
	13/46 (30 min)	9.6	9.3-10.0	10:15 A.M.				
	14/47 (60 min)	9.6	9.3-10.0	10:45 A.M.				
	15/48 (2 hrs)	9.6	9.3-10.0	11:45 A.M.				
	16/49 (2 hrs 25 min)	9.6	9.3-10.0	12:10 P.M.				
	17/50 (Final 3 hrs)	6.5	7.5-8.5	12:45 P.M.				
	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	
28	While striking run 30" (234 G) water into V-339							
29	Add in 7-8 min				350		530-A	350
30	Adj to 49" (382 G) at 80-100 °F							
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= 3.82 G)							
34	Set preset #8 to 30.2 G from S 33							
35	Run 40" (440 G) water into V-302							
36	Add & stir 2 min for S 40		Assume 50%		360		7-D	180
37	SP Step 17/50 After checking pH. Operator Step PB							
38	Stir in 2 bags				100		128-A	100
39	SP Step 23/53 Record: pH 3.8 (3.7-4.2)							
40	Run in N-7-D from S 36 in 10-12 min & stir 5 min							
41	Record: pH 9.3 (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 9.3 (9.0-10.0) Time 1:40 P.M.							
44	Operator Step PB							
45	SP Step 60 - Batch complete							
	Start	Finish	Optr					
	Time	SP Step	Time	SP Step				
	4:00 A		7:00 A		235		342	
	7:00 A.M.		2:00 P.M.		381.223			

Pump to VAT 240





