

CG 03 CODE KY-788-D PKG. **PUNCHED & CHECKED**→ MAR 20 34977
EST. WGT. 960 860 LBS.

MAR 24 1980

PROCESSES		APPROVED	
() KY-788-D	()	EWK 9/28/71	
()	()	MTW 9/30/71	
()	()	DCG 9/30/71	
()	()		
TYPED BY			
NE 2-18-77			

STD. HRS. 8.8 TIME 7 A M
 14 YC-3-B 98 4 Lot 24697, 2000
 14 YC-3-B 98 4 Lot 24694, 600
 14 YC-3-B 98 4 Lot 24694, 600

Homog #3 - 1ST Pass

MAR 20 1980

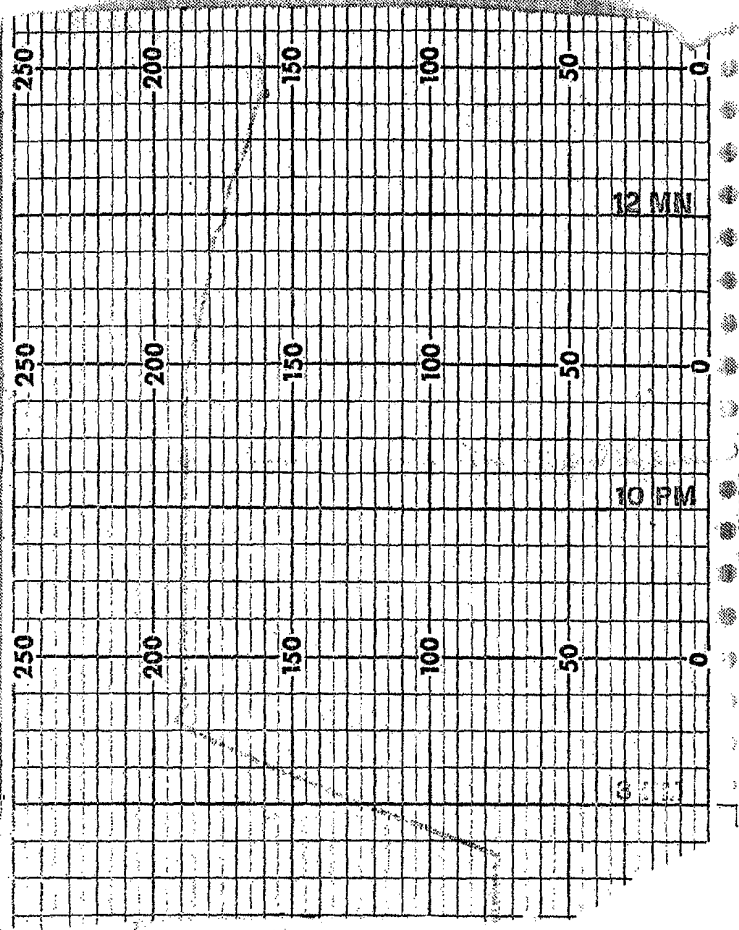
Total Wgt. 3560# 3460

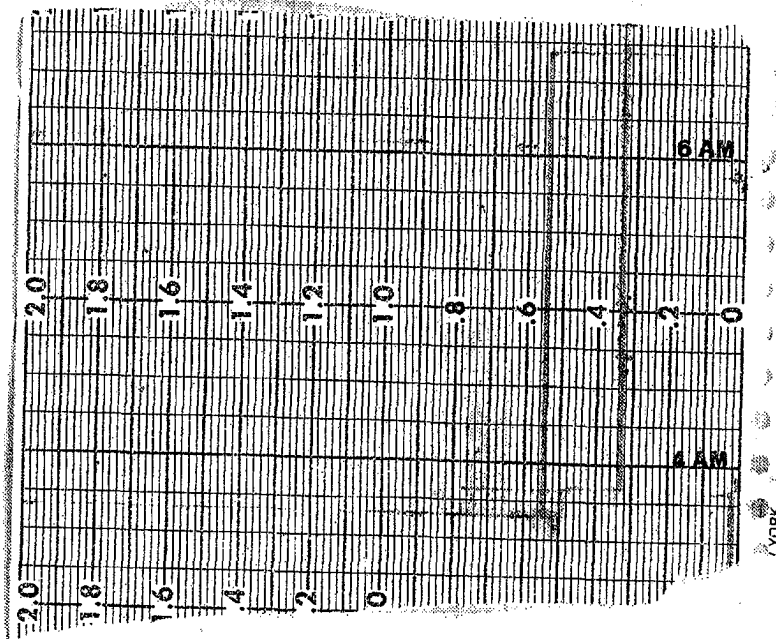
NON-BLEEDING

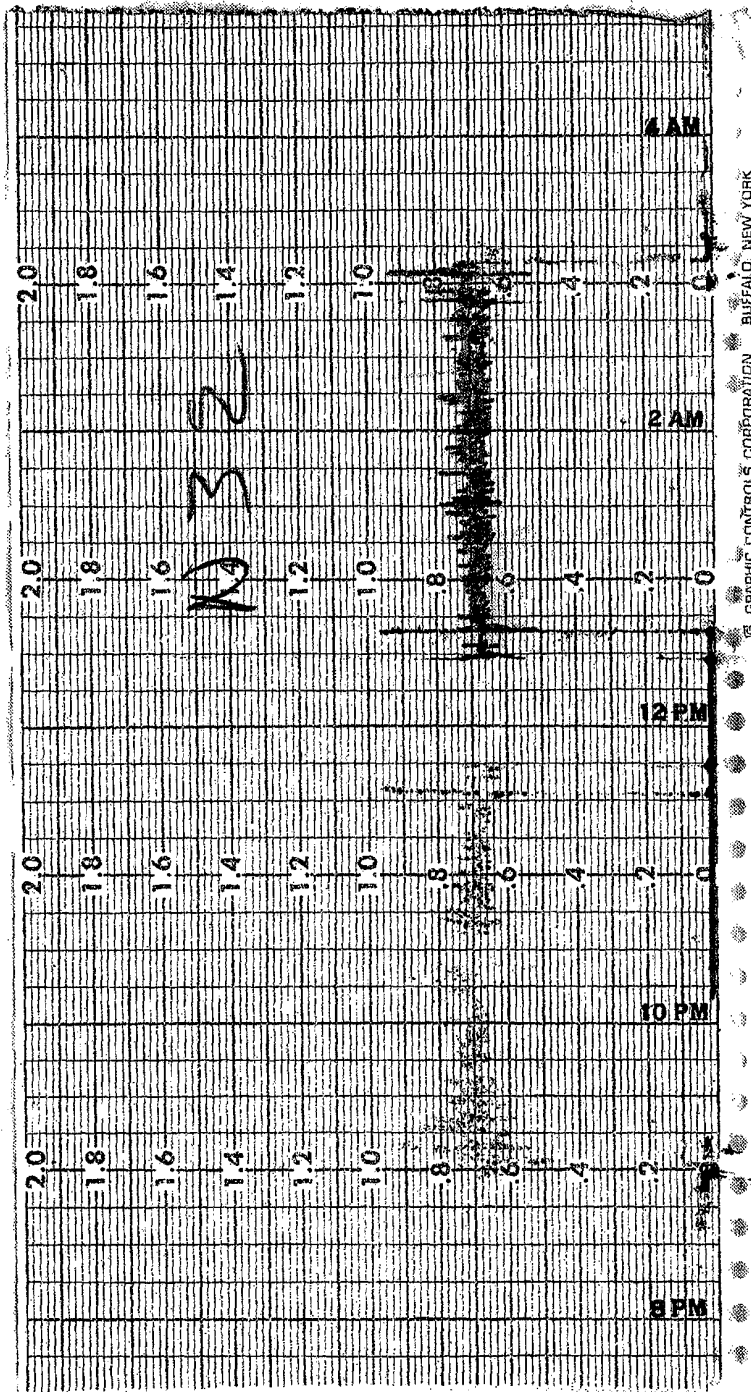
SHIPMENT	60"	NAME	USE LBS.	N CODE	AC LB
203	1	Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED			
&	2	Weigh in drum & pour in	345	32-D	345
205	3	Dump in & stir 5 min	52 x 50	YC-3-B	2600
1		Record: Start <u>1:30 P.M.</u> <u>24697</u> <u>2000</u>			
		Fin <u>1:30 P.M.</u> <u>24694</u> <u>600</u>			
	4	Adj to 70" (1200 G) <u>2400-2600</u>			
	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 <u>56</u> " & adj to 60" (2100 G)			
	8	Inspect homog. strainer & clean if necessary			
		DURING HOMOG SET V-203 AGITATOR ON LOW SPEED			
205	9	Run 10" (514 G) water into V- <u>243</u> & start agitator			
&	10	Pump V-205 thru Homog at 4800-5200 psi into V- <u>243</u>			
SV		Record: Time Start <u>1:45 P.M.</u> total min <u>1:50</u>			
2		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 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. 111 G <u>50</u> % - preset #2 208 Gal 15-A 416			
		b. 131 G <u>28</u> % - 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. 3FR20 (N-27-D/Water) Ratio 0.8			
		d. 3FC30 (N-32-D Controller) in Manual 0.72 GPM 32-D 1215			
		e. 3FC20 (N-32-D Water) in Manual Local 3.9 GPM			
		f. 3FC20 (N-32-D Water) in Remote			
		g. 3FR10 (N-32-D/Water) Ratio 1.1			
320	16	Operator Step PB			
243	17	Record Level 21 G <u>61</u> %. If below 35% follow solution make-up procedure for N-27-D			
SP	18	Adj SV to 47" (2400 G)			
&	19	Record pH <u>10.4</u> . Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D). Assume 50%	19	7-D	5
CP		Siphon into SV & Record: pH <u>11.1</u>			
4	20	Operator Step PB			

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QUIPMENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS.
SV	21	SP Step 06/39	- After heat up Record: pH 9.7 (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:						
		SP Step						
		V-243/V-244	pH - Range Time 8 PM					
		13/45 (30 min)	9.7 9.3-10.0 830 PM					
		14/47 (60 min)	9.7 9.3-10.0 900 PM					
		15/48 (2 hrs)	9.7 9.3-10.0 1000 PM					
		16/49 (2 hrs 25 min)	9.4 9.3-10.0 1025 PM					
		17/50 (Final 3 hrs)	8.2 7.5-8.5 1100 PM					
		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	25
	30	Add to 49" (382 G) at 80-100 °F						350
	31	Stir 5 min & record pH 10.2 (9.5-10.5)						
	32	Stir 15 min or longer to dissolve for SP Step 26/56						
	33	Record Vol 49 " & Calculate 49 " (Vol X 0.78 = 38.2 G)						
	34	Set preset #8 to 38.26 from S 33						
302	35	Run 40" (440 G) water into V-302						180
7	36	Add & stir 2 min for S 40 Assume 50%			360		7-D	49
SV	37	SP Step 17/50 After checking pH. Operator Step PB						
SP	38	Sift in 2 bags			100		128-A	10
	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 9.1 (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 9.1 (9.0-10.0) Time 12:20 PM						
	44	Operator Step PB						
	45	SP Step 60 - Batch complete						
	46	Pumped to V-240						
		Start Finish Optr						
		Time SP Step Time SP Step						
		SPM 11 PM 12:20 PM 282						
		1/10/84 12:20 PM 12/10						







GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

