CG 03 CODE KY-788-D PKG. _____

→ MAR 10 34805

EST. WGT. ~~960~~ 860 LBS.

STD. HRS. 8.8 TIME 3 PM

PUNCHED & CHECKED OK

MAR 13 1980 KP

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		

14 YC-3-B 98 4 Lot 24407 , 1500

14 YC-3-B 98 4 Lot 23864 , 150

14 YC-3-B 98 4 Lot 24403 , 950

Homog #4 1st Pass
" #4 2nd "

Total Wgt. ~~3560#~~ 3460

NON-BLEEDING

ENT		NAME: 60" (990G) "KROLOR" YELLOW - LIGHT	USE LBS.	N CODE	ACCT LBS.
03	1	Run ~~23" (360 G)~~ water into V-203 RUN AGITATOR ON HIGH SPEED			
	2	Weigh in drum & pour in	345	32-D	345
05	3	Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
		Record: Start 8.00 A.M. 24407	1500		
		Fin 9.00 A.M. 23864	150		
		75" (1275G) 24403	950		
	4	~~Adj~~ to ~~70" (1200 G)~~ 2400-2600	2600		
	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 minimun water 263			
	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			
05	9	Run 10" (514 G) water into V-244 & startagitator			
2	10	Pump V-205 thru Homog at 4800-5200 psi into V-244			
		Record: Time Start 2:20 PM Total min 195			
		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			
P	12	SP Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
& P	13	Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
	14	Record levels and set Raw Material Counter #1 as follows			
		a. 11LG 68 % - preset #2 208 Gal		15-A	416
		b. 13LG 78 % - 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. 3FR10 (N-27-D/Water) Ratio 0.8			
		d. 8FC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1215
		e. 8FC20 (N-32-D Water) in Manual Local 3.9 GPM			
		f. 8FC20 (N-32-D Water) in Remote			
		g. 8FR10 (N-32-D/Water) Ratio 1.1			
	16	Operator Step PB			
	17	Record Level 2LG 42 %. If below 35% follow solution make-up procedure for N-27-D			
	18	Adj SV to 47" (2400 G)			
	19	Record pH 10.0 . Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	38	7-D	19
		Siphon into SV & Record: pH 11.1			
	20	Operator Step PB			

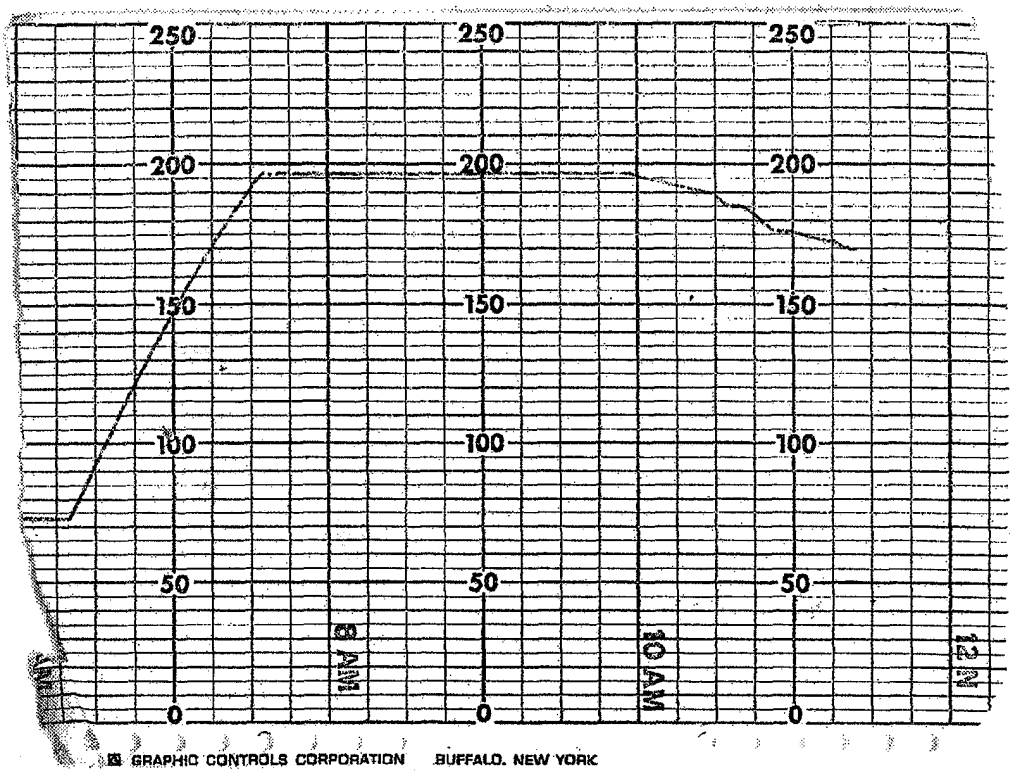
TO V-263

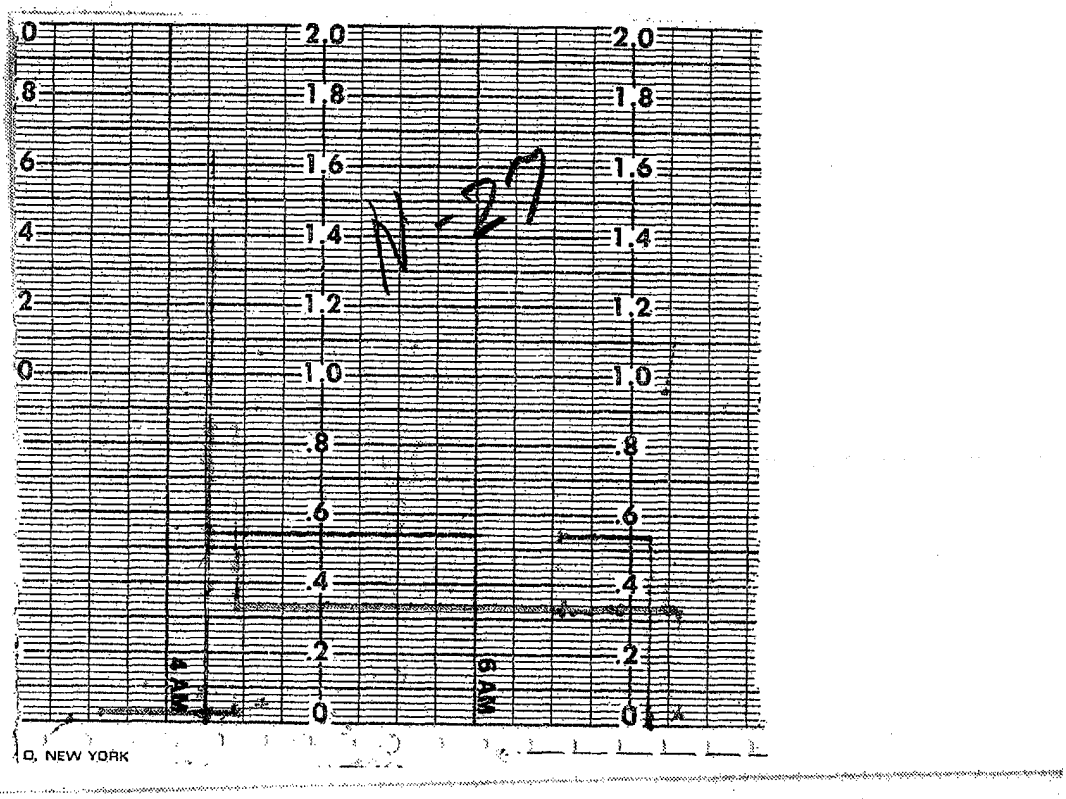
V-244

MENT		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 9.8 (9.5-10.0)			
SP	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 9:10PM			
	27	During strike, record pH & time as follows:			
		SP Step V-243/V-244 pH Range Time			
		13/46 (30 min) 9.5 9.3-10.0 9:40 PM			
		14/47 (60 min) 9.5 9.3-10.0 10:10 PM			
		15/48 (2 hrs) 9.4 9.3-10.0 11:10 PM			
		16/49 (2 hrs 25 min) 9.3 9.3-10.0 11:35 PM			
		17/50 (Final 3 hrs) 7.4 7.5-8.5 12:10 AM			
		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 10.2 (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 38.2G 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~~	~~Sfft in 2 bags~~	~~100~~	~~128-A~~	~~100~~
	~~39~~	SP Step 23/53 Record: pH 3.1 (3.7-4.2			
	~~40~~	Run in N-7-D from S 36 in 10-12 min & stir 5 min			
	41	Record: pH 9.5 (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 9.5			
	43	SP Step 29 - Record: pH _____ (9.0-10.0) Time 12:55			
	44	Operator Step PB			
	45	SP Step 60 - Batch complete			

Start Time	SP Step	Finish Time	SP Step	Optr
7:00 AM		3:00 PM		407-381
3:00 PM		11:00 PM		144-145
11:00 PM		7:00 AM		235-242

DUP050094739





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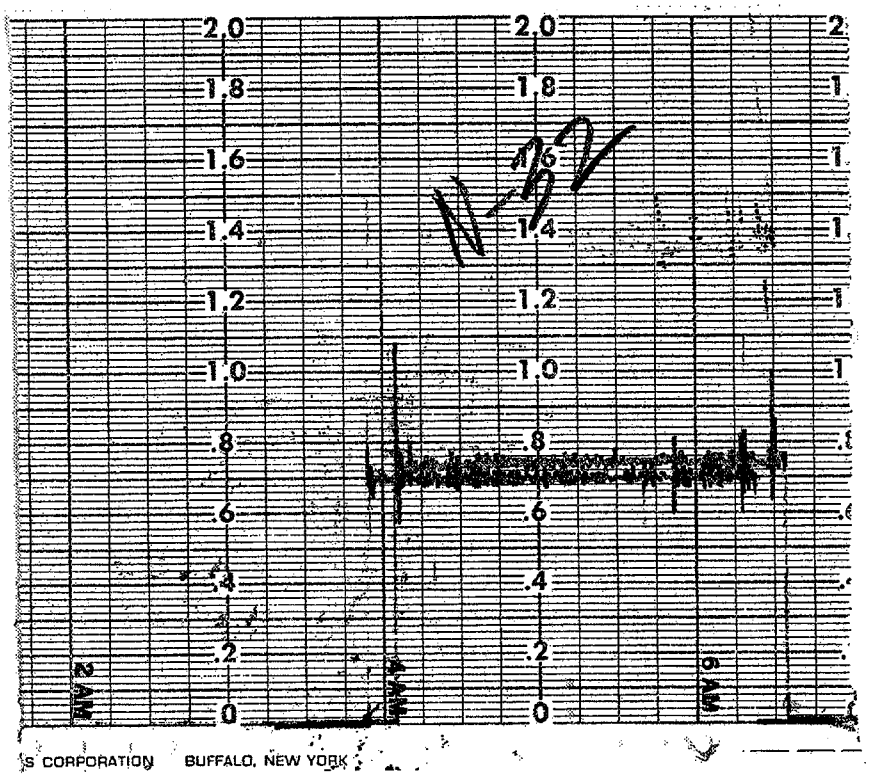

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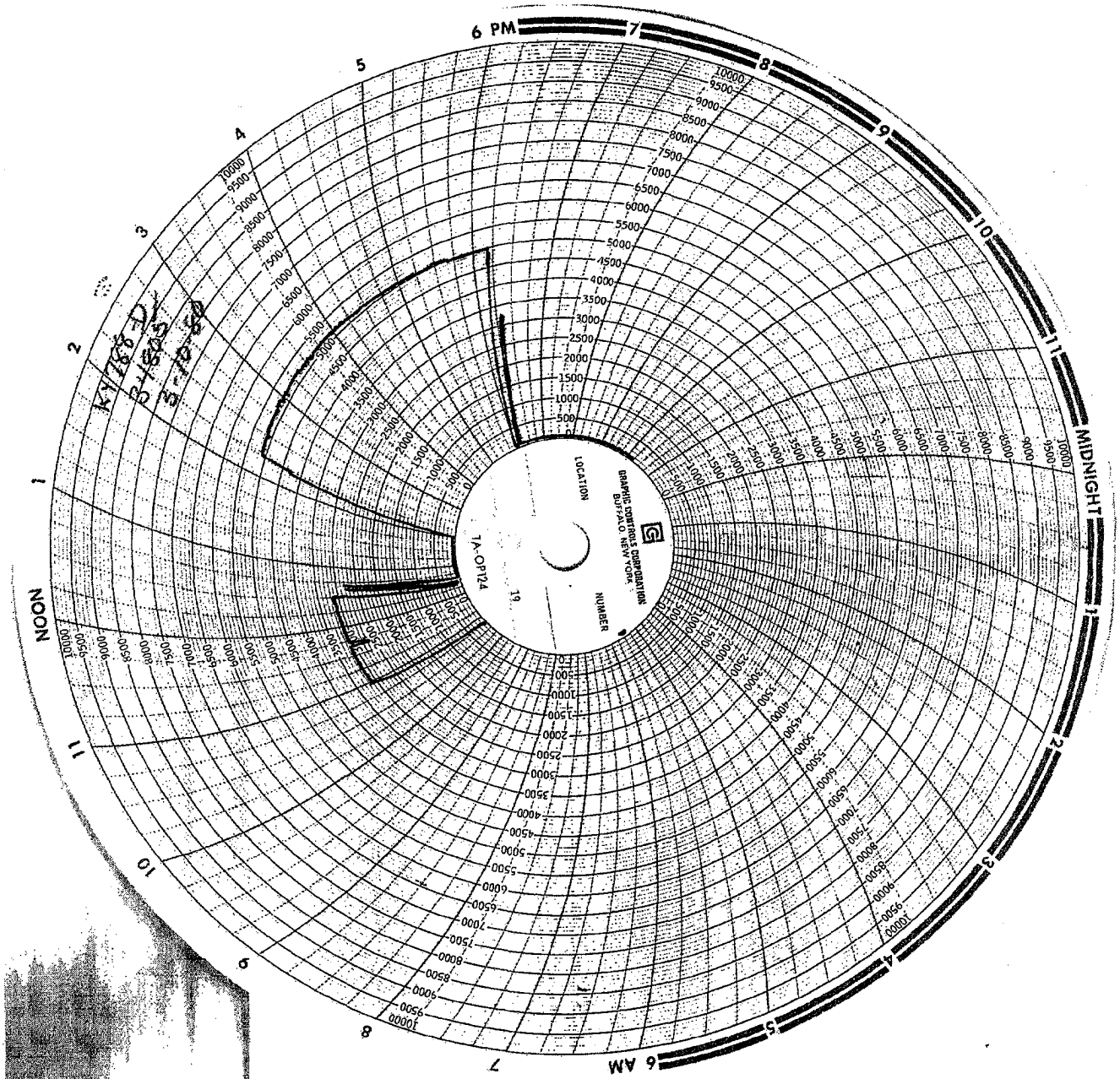

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V-244

DUP050094743