

CG 03 CODE KY-787-D

PKG.

FEB 28

34611

PUNCHED & CHECKED

EST. WGT.

1098 990

LJS.

STD. HRS.

8.9

TIME

11P M

MAR - 3 1980

14 - YC-2-B 98 4

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Total Wgt. - 3490# 3390

NON-BLEEDING

PMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	"KROLOR" - YELLOW MEDIUM			
203	1 Run 60" (992 G) water into V-203 <i>Set agitator on high speed.</i>			
&	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start <i>4:10 PM</i> Lot <i>2406.6</i>			
	Fin <i>5:30 PM</i> <i>2406.6</i>			
	<i>75" (1275 G)</i> <i>2400-2600</i>			
	4 Adj to 70" (1200 G)			
	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 <i>49</i> " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	<i>WARNING: Homog RUN V-203 Agitator on low speed</i>			
206	9 Run 100 (514G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-			
SV	Record: Time start <i>12:00 PM</i> Total Min <i>135</i>			
2	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 <i>58</i> % - preset #1 80 Gal		15-A	160
	b. 13LG <i>77</i> % - 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. 3FC10 (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. 8FC10 (N-32-D/Water Ratio) 0.83			
SV	16 Operator Step PB			
SP	17 Record Level 2 LG <i>67</i> %. If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj to 48" (2470 G)			
4	19 Record pH <i>10.7</i>			
	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)			
	Siphon into SV. Record pH			
	21 Operator Step PB			

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	

Note Step 28.

V-243

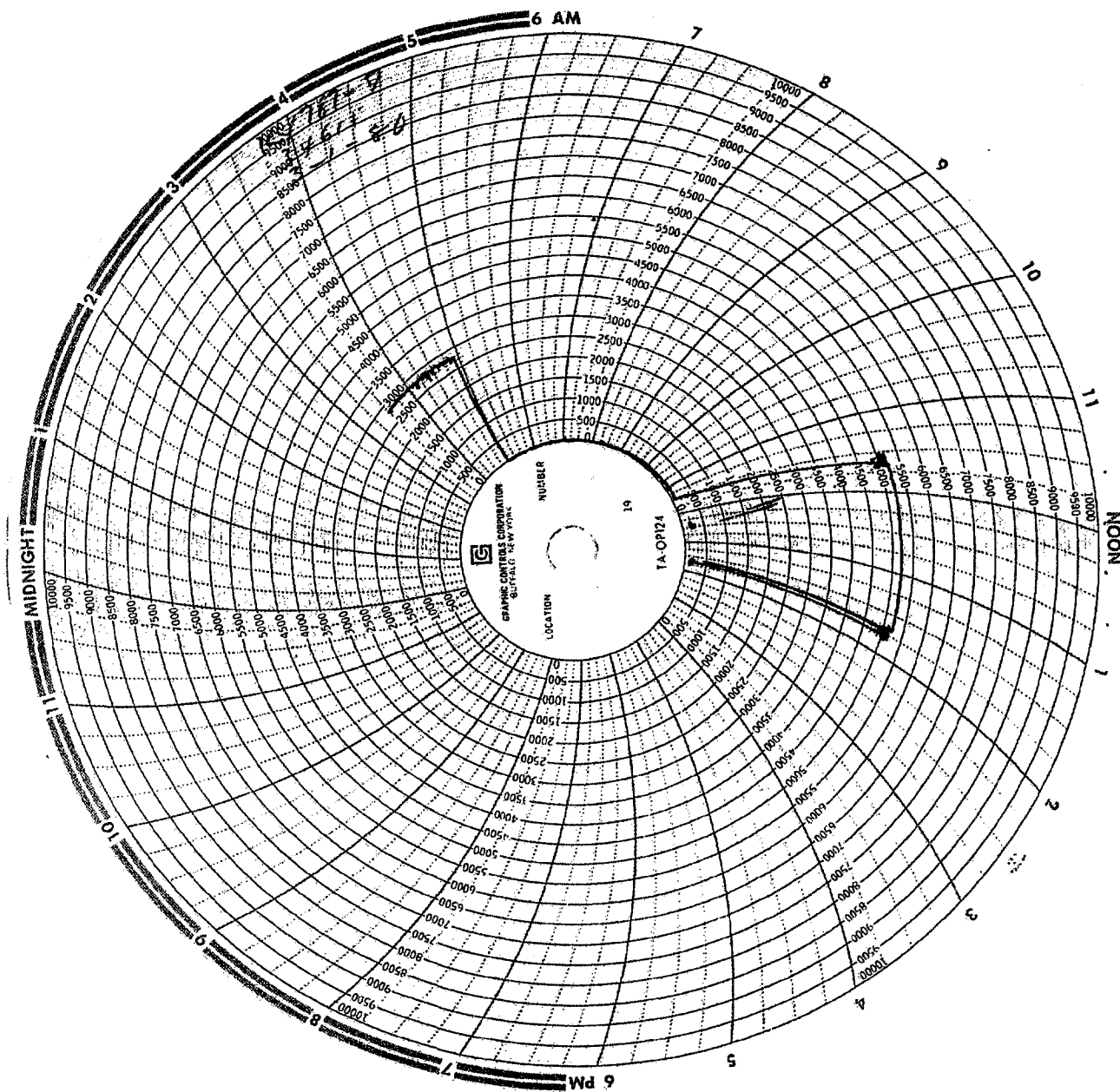
JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22	SP Step 06/39 - After heat up Record: pH <u>10.0</u> (9.5-10.0)						
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
5		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>9.75</u>	9.0-10.0	<u>3:40</u>			
		14/47 (60 min)	<u>9.3</u>	9.0-10.0	<u>4:10</u>			
		15/48 (2 hrs)	<u>9.2</u>	9.0-10.0	<u>5:10</u>			
		16/49 (2 hrs 25 min)	<u>9.15</u>	9.0-10.0	<u>5:35</u>			
		17/50 (3 hrs Final)	<u>7.65</u>	7.5-8.5	<u>6:10</u>			
		NOTE: If not as specified notify Supervisor & note in log						
		If final pH is Above 8.5, adj pH to 7.5-8.5 &						
		Record: pH			Assume 77%			27-0
339	29	While striking, run 30" (234 G) water into V-339						
6	30	Add in 7-8 min				350	530-A	350
	31	Adj to 49" (382 G) at 80 - 100°F						
	32	Stir 5 min & record pH <u>10.1</u> (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>38.22</u> G						
	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>3.5</u> (3.7-4.2)						
&	41	Run in N-7-D from S 37 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%			27-0
		(Dilute 10 parts water to 1 part N-7-D)			Assume 50%			7-D
		Siphon N-7-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.2</u> (9.0-10.0) Time <u>6:45</u> PM						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time	SP Step	Time	SP Step			
		<u>3:00P</u>		<u>6:50</u>		<u>235-54</u>		

Note

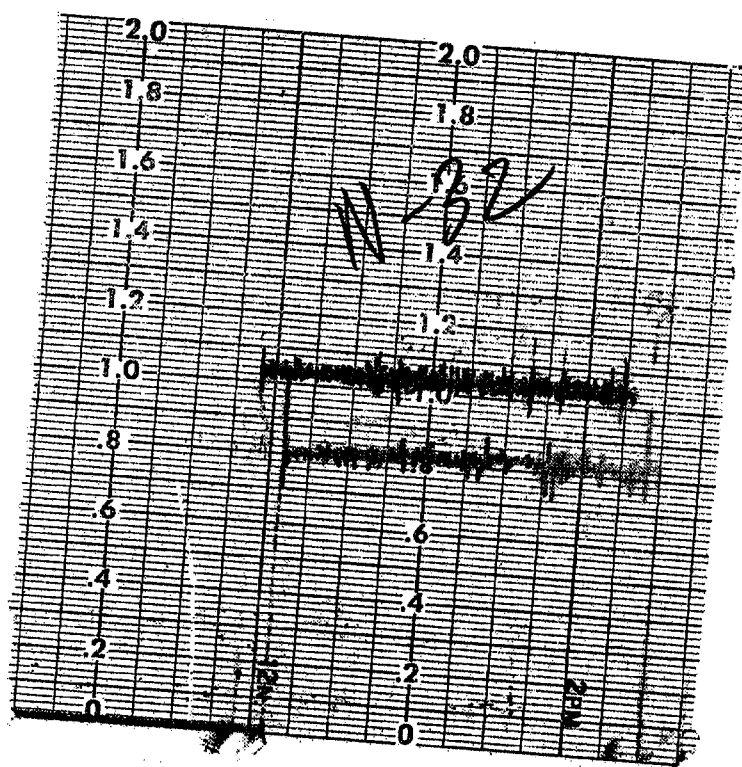
3:10/PM

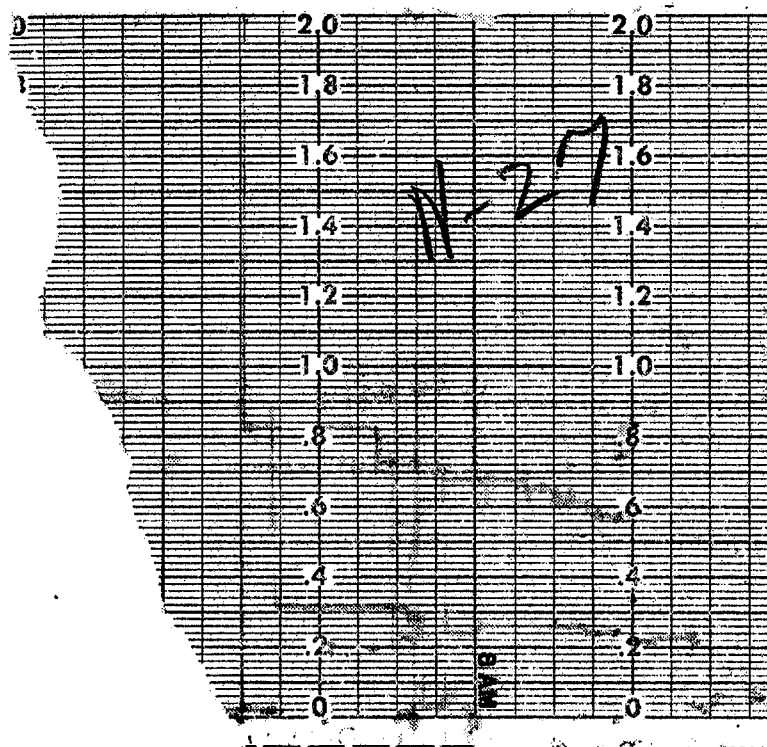
Cut N-27 To 0.73

SHUT N-27 OFF 15 MIN EARLY

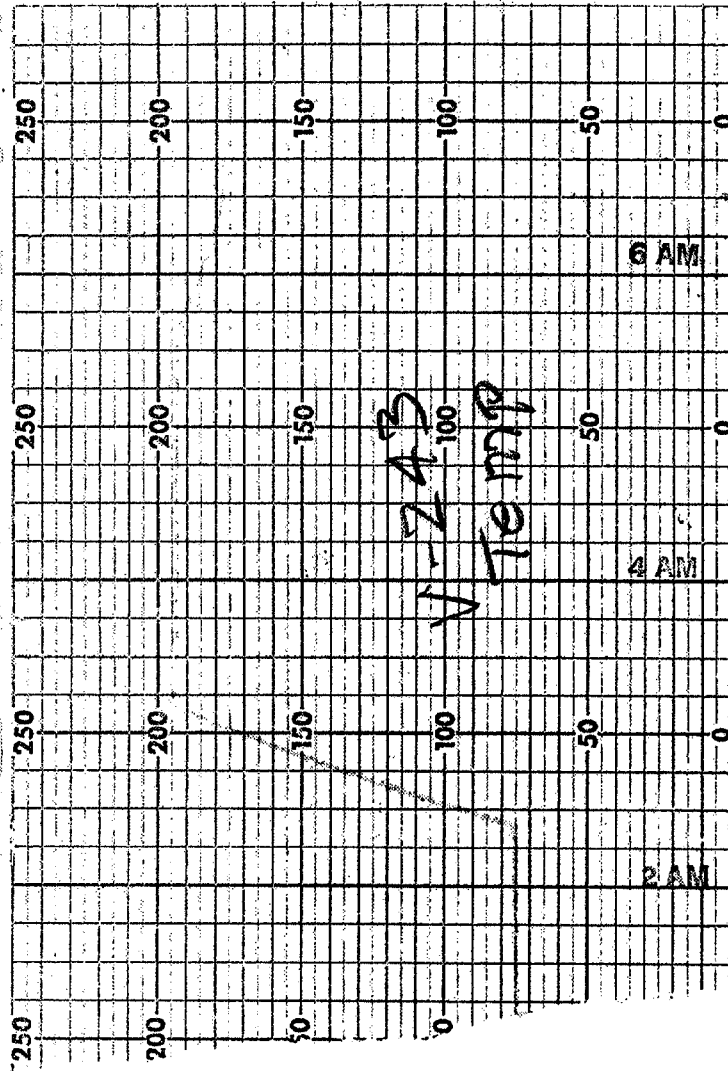


V-243





No. 215A1.



GRAPHIC CONTROLS