

CG 03 CODE KY-788-D PKG.
 → MAR 23 35022
 EST. WGT. 960 860 LBS.

PLEASE NOTE
 SAMPLE REQUEST
 AT STEP 41

PROCESSES APPROVED BY
 () KY-788-D () EWK 9/28/76
 () () MTW 9/30/76
 () () DCG 9/30/76
 TYPED BY
 NE 2-18-77

STD. HRS. 8.8 TIME 7 AM
 14 YC-3-B 98 4 Lot 34693 2000 OK
 14 YC-3-B 98 4 Lot 34720 600 JH
 14 YC-3-B 98 4 Lot

PUNCHED & CHECKED

MAR 26 1980

Total Wgt. 3560# 3460

NON-BLEEDING

SHIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	60" (9920) "KROLOR" YELLOW - LIGHT			
&	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED			
205	2 Weigh in drum & pour in	345	32-D	345
1	3 Dump in & stir 5 min	Lot 52 x 50	YC-3-B	2600
	Record: Start 34693 2000			
	Fin 34720 600			
	4 75" (12756)			
	5 Adj to 70" (1200 G) 2400-2600			
	6 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	7 When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water			
	8 Record: V-205 Vol 40" & adj to 60" (2100 G)			
	9 Inspect homog. strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205	10 Run 10" (514 G) water into V- & start agitator			
&	11 Pump V-205 thru Homog at 4800-5200 psi into V- 343			
SV	Record: Time Start 2:34.14 total min 1:20			
2	Note: If Homog pressure falls below 4800 ps., 3-way valve will recirculate slurry to V-205			
	12 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
SP	13 SP Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
&	14 Press SV Cam Reset PB- set 22 TC in Auto Remote.			
CR	(Temperature is set at 190-194 F)			
3	15 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 50% - preset #2 208 Gal		15-A	416
	b. 13LG 60% - preset #6 135 Gal		20-A	135
	16 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. 3FC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1216
	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	17 Operator Step PB			
243	18 Record Level 2LG 43%. If below 35% follow solution make-up procedure for N-27-D			
SP	19 Adj SV to 47" (2400 G)			
&	20 Record pH 10.4. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
CP	Siphon into SV & Record: pH 11.2			
4	21 Operator Step PB			

V-243

EQUIPMENT	PAGE 2 CG 03 CODE KY-788-D	EST. WGT. 3500 LBS.	USE LBS.	N CODE	ACCT LBS
SV	21 SP Step 06/39 - After heat up Record: pH <u>10.0</u> (9.5-10.0)				
SP	22 Switch 3FC20, 8FC10, 3FC20 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				12:00 PM
	V-243/V-244	pH	Range		Time
	13/45 (30 min)	9.6	9.3-10.0		12:30 PM
	14/47 (60 min)	9.6	9.3-10.0		1:00
	15/48 (2 hrs)	9.6	9.3-10.0		2:00
	16/49 (2 hrs 25 min)	9.6	9.3-10.0		2:25
	17/50 (Final 3 hrs)	7.7	7.5-8.5		3:00 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%				27-0
339	28 While striking run 30" (234 G) water into V-339				
6	29 Add in 7-8 min		350	530-A	350
	30 Adj to 49" (382 G) at 80-100 OF				
	31 Stir 5 min & record pH <u>10.2</u> (9.5-10.5)				
	32 Stir 15 min or longer to dissolve for SP Step 26/56				
	33 Record Vol <u>49</u> " & Calculate <u>49</u> " (Vol X 0.78 = 38.2 G)				
	34 Set preset #8 to 38.2 G from S 33				
302	35 Run 40" (440 G) water into V-302				
7	36 Add & stir 2 min for S 40 Assume 50%		360	7-D	180
SV	37 SP Step 17/50 After checking pH. Operator Step PB				
SP	38 Sift in 2 bags		100	120-A	100
	39 SP Step 23/53 Record: pH <u>3.9</u> (3.7-4.2)				
8	40 Run in N-7-D from S 36 in 10-12 min & stir 5 min				
	41 Record: pH <u>9.5</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-D into SV				
	42 Operator Step PB				
	43 SP Step 29 - Record: pH <u>9.5</u> (9.0-10.0) Time <u>4:30 P</u>				
	44 Operator Step PB				
	45 SP Step 60 - Batch complete				
	Start Finish Optr				
	Time: 3pm SP Step Time 5pm SP Step H38-381				

TAKE
SAMPLE
AFTER
PH ADJ.

PUMP TO 240 VET
Sample before resin/calcium
but after pH is adjusted.



