

S.V. 243/244 Automated C.V.

CG 03 CODE KY-907-D PKG.

EST. WGT. FFF-2 34159
1080 LBS.

STD. HRS. TIME 3pm 24 M

14 YC-2-B 93 4 Lot 24470 2000#
14 YC-2-B 93 4 Lot 24478 400#
14 YC-2-B 93 4 Lot #

PROCESSES		APPROVED BY	
()	KY-907-D	()	EWK 12/12/77
()		()	DCG 12/13/77
()		()	MW 12/15/77
()		()	
TYPED BY			
RJ 2/3/78			

OK
HP

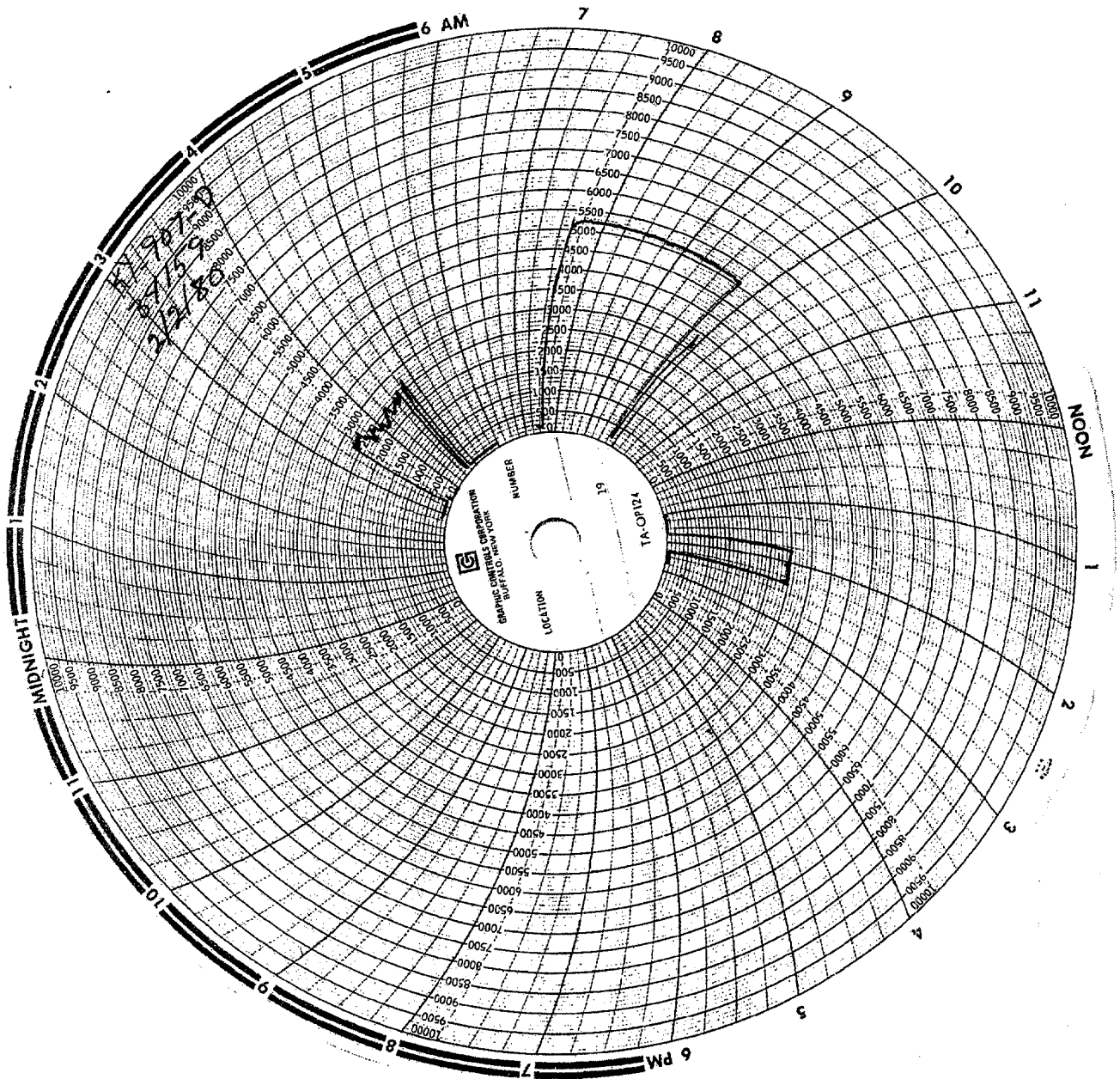
Total Weight - 3480#

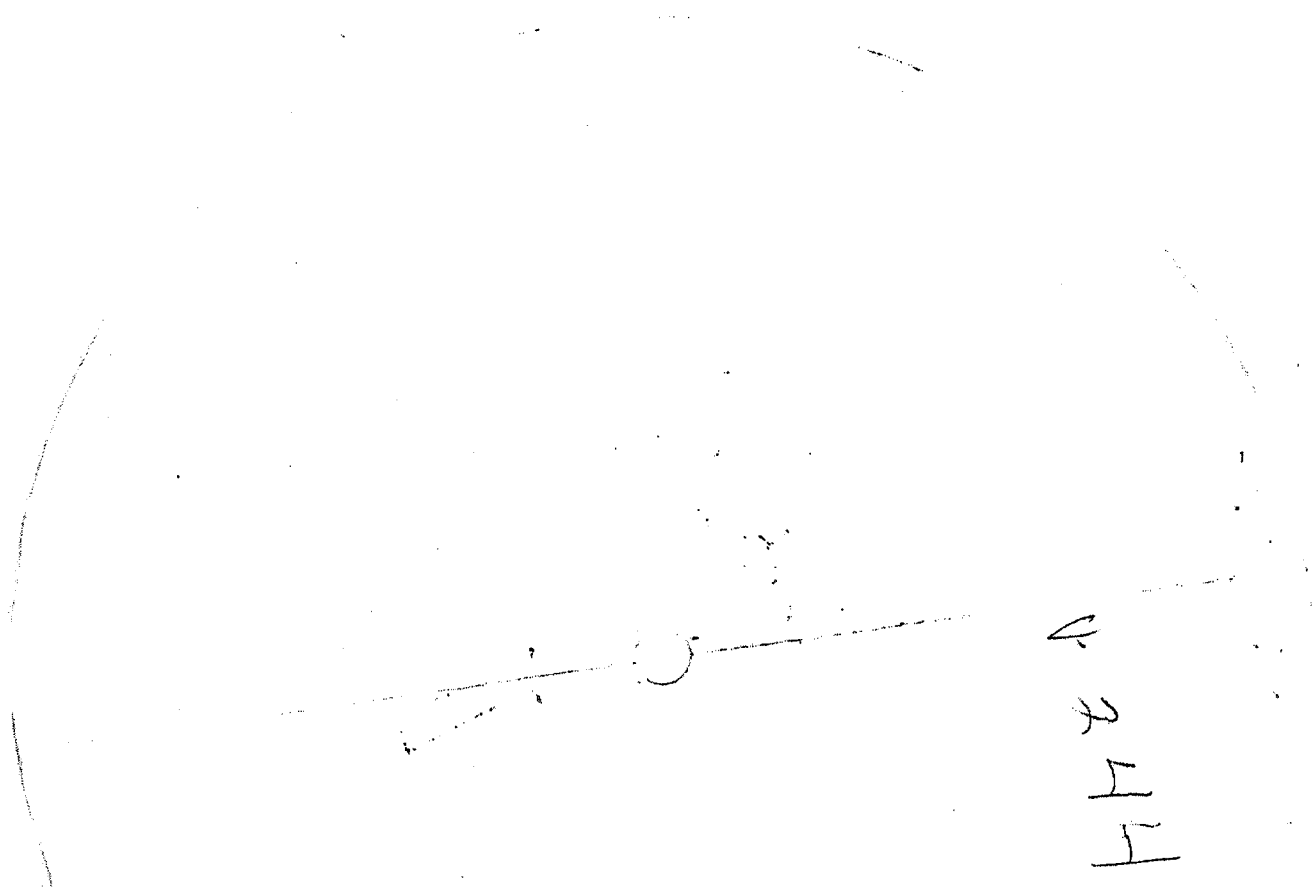
NON-BLEEDING

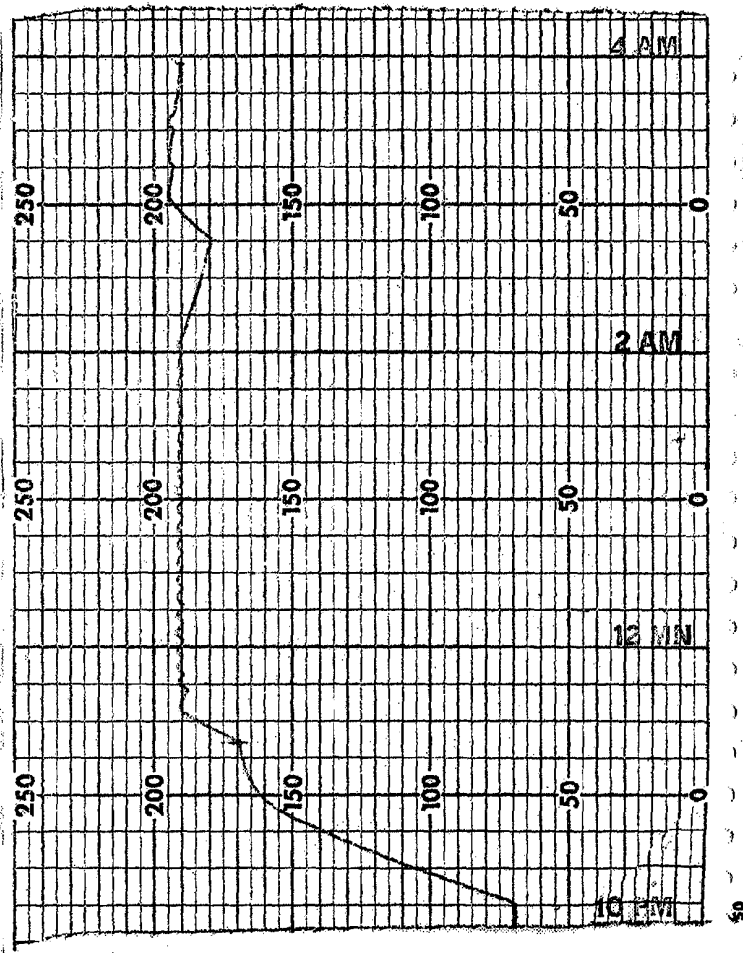
EQUIPMENT		NAME	USE LBS.	N CODE	ACCT. LBS.
		60" (990 G) KROLOR® - YELLOW MEDIUM			
203		1 Run 33" (560 G) water into V-203			
&		2 Pour in	320	32-D	320
205		3 Dump in	48 x 50	YC-2-B	2400
1		Record: Start <u>11:45 PM</u> Lot <u>24470</u> <u>2000</u>			
		Fin <u>1:00 AM</u> Lot <u>24478</u> <u>400</u>			
75" (1275 G)		4 Adj to 70" (1200 G) 2400-2600			
		5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
		6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
		7 Record V-205 Vol <u>48</u> " & adj to 60" (2100 G)			
		8 Inspect Homog strainer & clean if necessary			
205		9 Run 10" (514 G) water into SV & start agitator			
&		10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
SV		Record: Time Start <u>7:30 AM</u> Total Min <u>150</u>			
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 & CP		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 (Temperature is set at 190-194 F)			
3		14 Record levels and set Raw Materials Counter #1 as follows: 11.625% - preset #1 80 Gal		15-A	160
		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. 3FC20 (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. 8FR10 (N-32-D/Water Ratio) 0.83			
SV		16 Operator Step PB			
SP & CP		17 Record Level 2 LGO % . If below 35% follow solution make-up procedure for N-27-D			
		18 Adj to 48" (2470 G)			
4		19 Record: pH <u>10.7</u>			
		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)	20	7-D	10
		Siphon into SV Record: pH <u>11.4</u>			
		21 Operator Step PB			

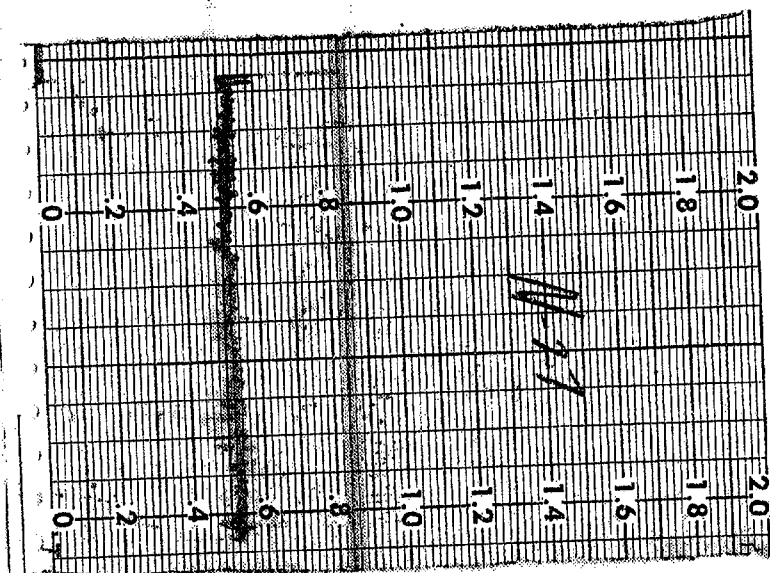
V-244

EQUIPMENT	PAGE	CG	03	CODE	KY-907-D (D)	EST. WGT.	3480	LBS.	USE	N	ACCT.
									LBS.	CODE	LBS.
SV SP & CP 5	22				SP Step 06/39 - After heat up Record: pH <u>10.0</u> (9.5-10.0)						
	23				Switch 3FC20, 8FC10, 8FC20 to Auto						
	24				Operator Step PB						
	25				SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
	26				Switch 3FC10 to Auto. Operator Step PB						
	27				SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote						
	28				Operator Step PB						
	28				During strike, Record pH & time as follows: <u>1:35 P.M.</u>						
					SP Step						
					V-243/V-244	pH	Range	Time			
					13/46 (30 min)	<u>9.9</u>	9.0-10.0	<u>2:05 PM</u>			
					14/47 (60 min)	<u>9.9</u>	9.0-10.0	<u>2:35 PM</u>			
					15/48 (2 hrs)	<u>9.9</u>	9.0-10.0	<u>3:35 PM</u>			
					16/49 (2 hrs 25 min)	<u>9.9</u>	9.0-10.0	<u>4:00 PM</u>			
					17/50 (3 hrs Final)	<u>8.5</u>	7.5-8.5	<u>4:35 PM</u>			
					NOTE: (1) If pH not as specified notify Supervisor & note in log (2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH						
					Assume 78%					27-D	
	29				Sift in				50	128-A	50
302 6	30				Add 17" (208 G) water to V-302						
	31				Add & stir 2 min for S58		Assume 50%		100	7-D	50
PT 7	32				During strike pump into PT				318	169-A	318
	33				Pump in				36	155-A	36
	34				Pump in				36	160-A	36
	35				Stir 10 min with lightning mixer for S39						
356 8	36				During strike run ^{14"} 20" (244 G) water into V-356						
	37				Turn on steam						
	38				Adj to <u>260°</u> (317 G) at <u>178-182°F</u> <u>81-82°C</u>						
	39				Pump PT mixture from S35 thru undersurface Distributor AFAP						
	40				Rinse PT with hot water from hot water mixer & pump in						
	41				Shut off pump <u>81-82°C</u>						
	42				Stir 30 min at <u>178-182°F</u> for S49						
	43				Do not shut off agitator						
SV & SP 9	44				When S29 complete, heat SV to 198-200°F in 5-10 min						
	45				Close water line & discharge valves at stearate pump						
	46				Open V-356 Discharge valves to stearate pump inlet						
	47				Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer						
	48				While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & close valve to sewer						
	49				Immediately open stearate pump discharge valve. Turn on pump & Homog V-356 to SV at 2900-3100 psi						
					Maintain SV at 198-200°F						
	50				While Homog V-356 to SV, shut off water valve at Stearate pump ASAP						
	51				When Homog complete, rinse in V-356 with hot water From hot water mixer						









No. 25A164