

S.V. (243) (244) (Automated)

C.V.

D.V.

CG 03 CODE KY-788-D PKG.

MARCH 11

34822

EST. WGT. 350 860 LBS.

STD. HRS. 8.8

TIME

7P M

14 YC-3-B 98 4 Lot 24402 2600

14 YC-3-B 98 4 Lot

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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			

OK
FP

PUNCHED & CHECKED

Homog #3 - 1st Pass
- #2 - 2nd PassTotal Wgt. 3500 3460⁴

MAR 17 1980

NON-BLEEDING

EQUIPMENT		NAME	USE LBS.	N CODE	ACCT. LBS.
		60 "KROLOR" YELLOW - LIGHT			
203	1	Run 25" (360 G) water into V-203 RUN AGITATOR ON HIGH SPEED			
205	2	Weigh in drum & pour in	345	32-D	345
205	3	Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
1		Record: Start 6:30 PM			
		Fin 7:30 PM	24402	2600	
		75"			
	4	Adj to 70" (1200 G) 2400-2600			
	5	Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 V263			
	6	When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water.			
	7	Record: V-205 Vol. 36 " & adj to 60" (2100 G)			
	8	Inspect homog. strainer & clean if necessary			
		DURING Homog, RUN V203 ON LOW SPEED			
205	9	Run 10" (514 G) water into V- 244 & start agitator			
SV	10	Pump V-205 thru Homog at 4800-5200 psi into V- 244			
2		Record: Time Start 11:30 AM Total min 140			
		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 #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. 11G 47% - preset #2 208 Gal		15-A	416
		b. 13LG 62% - preset #6 135 Gal		20-A	135
	15	Set strike flow controllers as follows:			
		a. 2FC10 (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			
320	16	Operator Step PB			
243	17	Record Level 21G 76 %. If below 35% follow solution make up procedure for N-27-D			
SP	18	Adj SV to 47" (2400 G)			
&	19	Record pH 10.6. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
CP		Siphon into SV & Record: pH 11.2			
4	20	Operator Step PB			

N 27532

JW

V-244

EQUIPMENT	PAGE 2 CG 03 CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	21 SP Step 06/39 - After heat up Record: pH <u>9.7</u> (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		
	13/46 (30 min)	<u>9.4</u>	9.3-10.0	<u>12:45</u>		
	14/47 (60 min)	<u>9.3</u>	9.3-10.0	<u>1:15</u>		
	15/48 (2 hrs)	<u>9.4</u>	9.3-10.0	<u>2:15</u>		
	16/49 (2 hrs 25 min)	<u>9.4</u>	9.3-10.0	<u>2:40</u>		
	17/50 (Final 3 hrs)	<u>7.9</u>	7.5-8.5	<u>3:15</u>		
	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	350
	30 Add to 49" (382 G) at 80-100 OF					
	31 Stir 5 min & record pH <u>10.1</u> (9.5-10.5)					
	32 Stir 15 min or longer to dissolve for SP Step 26/56					
	33 Record Vol <u>77</u> " & Calculate <u>77</u> " (Vol X 0.78 = <u>38.2 G</u>)					
	34 Set preset #8 to <u>38.2 G</u> from S 33					
302	35 Run 40" (440 G) water into V-302					
7	36 Add & stir 2 min for S 40			180	N-7-D	180
SV	37 SP Step 17/50 After checking pH. Operator Step PB					
SP	38 Sift in 2 bags			100	100-A	100
8	39 SP Step 23/53 Record: pH <u>3.6</u> (3.7-4.2)					
	40 Run in N-7-D from S 36 in 10-12 min & stir 5 min					
	41 Record: pH <u>9.0</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>9.0</u> (9.0-10.0) Time <u>2:45 P</u>					
	44 Operator Step PB					
	45 SP Step 60 - Batch complete					
	Start	Finish	Optr			
	Time SP Step	Time SP Step				
	<u>3 P</u>	<u>11 P</u>	<u>121-300</u>			
	<u>7 AM</u>	<u>4 PM</u>	<u>223-403</u>			
	<u>1:00 AM</u>	<u>3:00 PM</u>	<u>409</u>			
	<u>3:00 P</u>	<u>4:55 P</u>	<u>126</u>			



