

(243) 244 (Automated)

C.V.

D.V.

CG 03 CODE KY-788-D PKG.

EST. WGT. 960 860 LBS.

STD. HRS. 8.8 TIME

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	

CHECKED 1ST PASS - Homog #3

MAR 15 1980

Total Wgt. 3560# 3460

NON-BLEEDING

MENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	Run 23" (360 G) water into V-203. RUN AGITATOR ON HIGH SPEED			
&	12 Weigh in drum & pour in	345	32-D	345
205	3 Dump in & stir 5 min	52 x 50	YC-3-B	2600
1	Record: Start 11:00 AM 24402 2,600 Fin 12:30 PM			
	75" (12756)			
	4 Adj to 70" (1200 G) 2400-2600			
V-263	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 minimum water V-263			
	7 Record: V-203 Vol & adj to 60" (2100 G)			
	8 Inspect homog. strainer & clean if necessary			
V-263	9 Run 10" (514 G) water into V-243 & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
2	Record: Time Start 3:30 PM Total min 1:20			
	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 35% - preset #2 208 Gal 15-A 416			
	b. 13G 5% - 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			
20	16 Operator Step PB			
43	17 Record Level 21G 73%. If below 35% follow solution make-up procedure for N-27-D			
SP	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.2. 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			
	Siphon into SV & Record: pH 11.1			
	20 Operator Step PB			

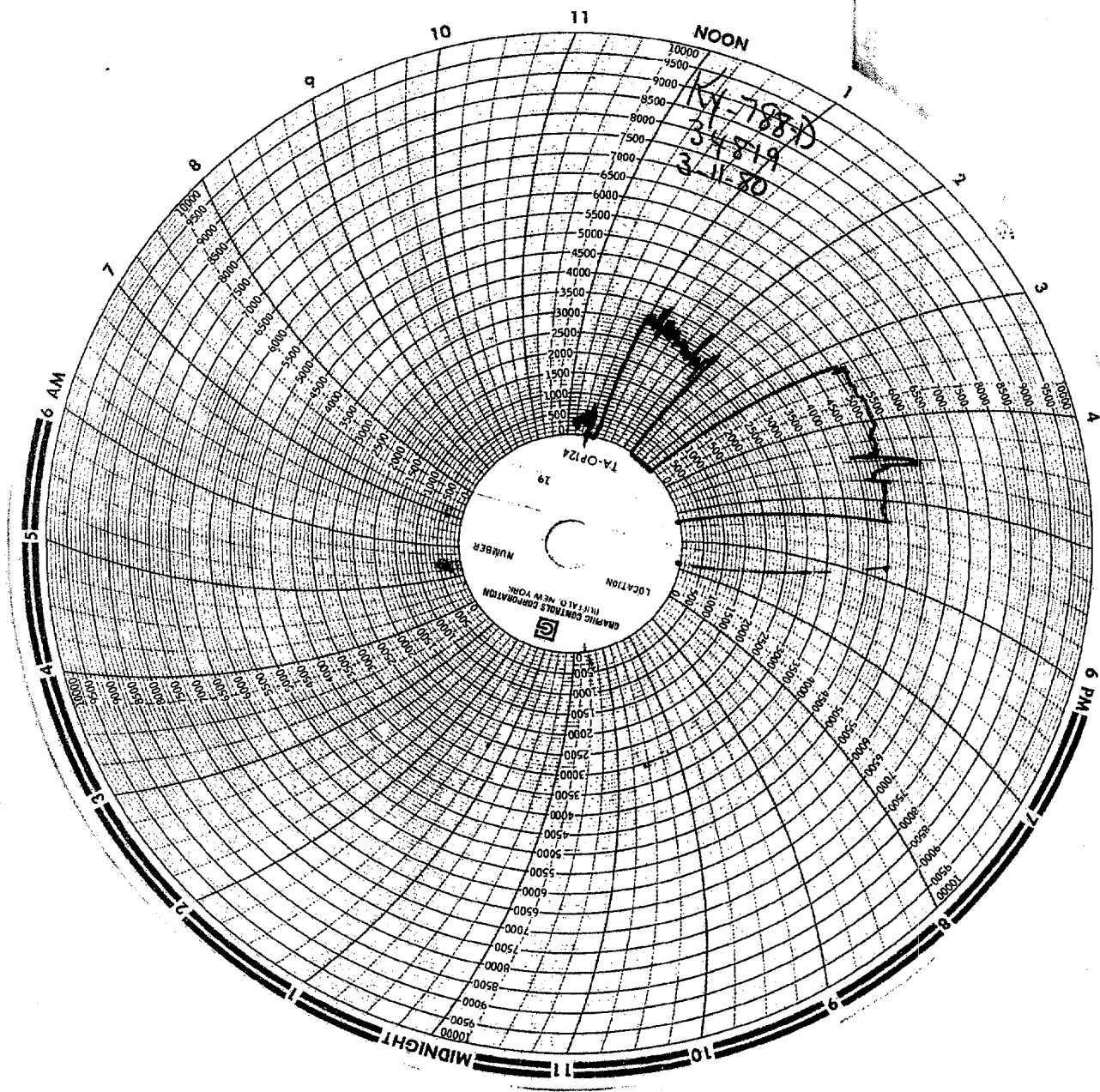
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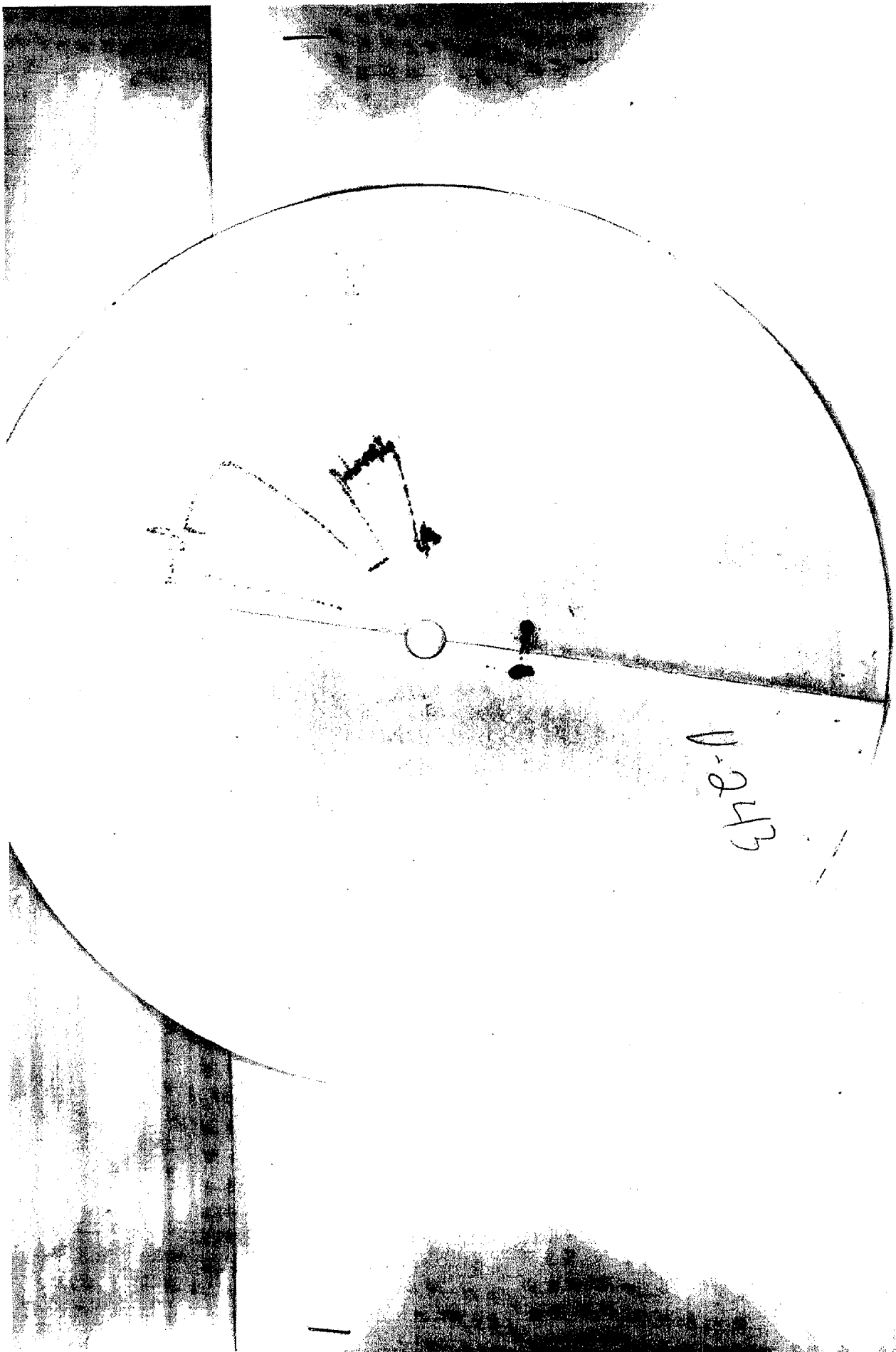
EJ.

U-243

ENT	PAGE 2	ec 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS
21	SP Step 06/39	- After heat up Record: pH	9.7	(9.5-10.0)				
22	Switch 3FC20.	8FC10, 8FC20 to Auto						
23	Operator Step PB							
24	SP Step 10/43	- When 3FC20, 8FC10, 8FC20 water flows is limits.						
		Switch 3FC10 to Auto.						
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)	9.3	9.3-10.0	7:45				
	14/47 (60 min)	9.3	9.3-10.0	8:15				
	15/48 (2 hrs)	9.4	9.3-10.0	9:15				
	16/49 (hrs 25 min)	9.4	9.3-10.0	9:40				
	17/50 (Final 3 hrs)	9.5	7.5-8.5	10:15				
	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	10.1	(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 46 G 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	Stir in 2 bags					100	128-A	100
39	SP Step 23/53 Record: pH	3.4	(3.7-4.2)					
40	Run in N-7-D from S 36 in 10-12 min & stir 5 min							
41	Record: pH 9.9 (9.0-9.5) & if necessary adj to pH 9.0-9.5							
	& Record: pH 9.5		Assume 77%			16	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	9.4	(9.0-10.0)	Time 11:20 PM				
44	Operator Step PB							
45	SP Step 60 - Batch complete							
	Start	Finish	Optr					
	Time 2:00 PM	Time 11:20 PM	SP Step 120-322					
			235					

ACID LOWERED
1.5





DUP050094735

