

CO 03 CODE KY-787-D

PKG.

DEC 19 33378

EST. WGT. 1090 990 LBS.

STD. HRS. 8.9 TIME

14 - YC-2-B 98 4 Lot 24070, 2200 #
 Lot 24077, 150 #
 Lot 24168, 50 #

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	

#3 1st Pass

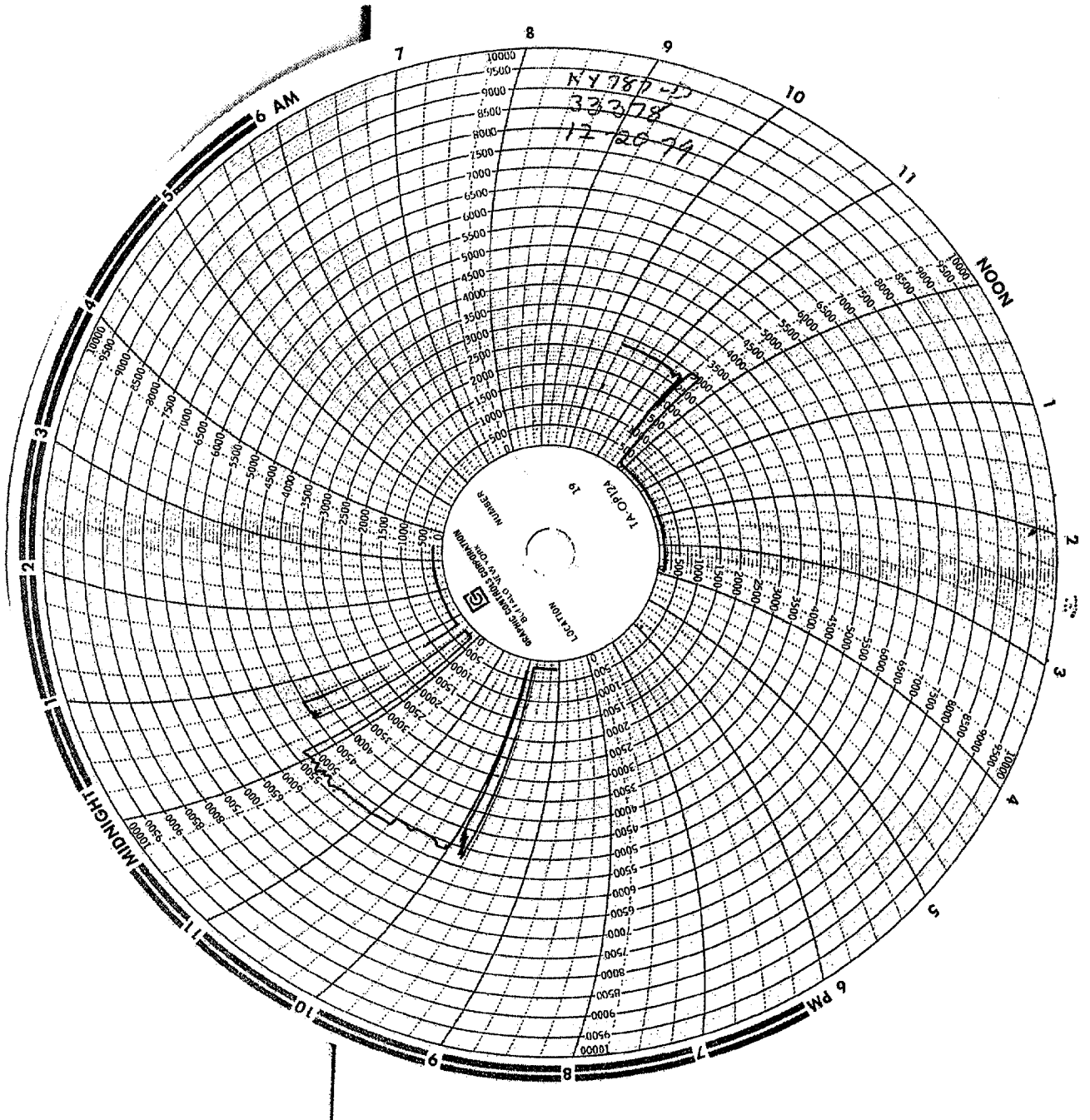
Total Wgt. - 3490# 3390

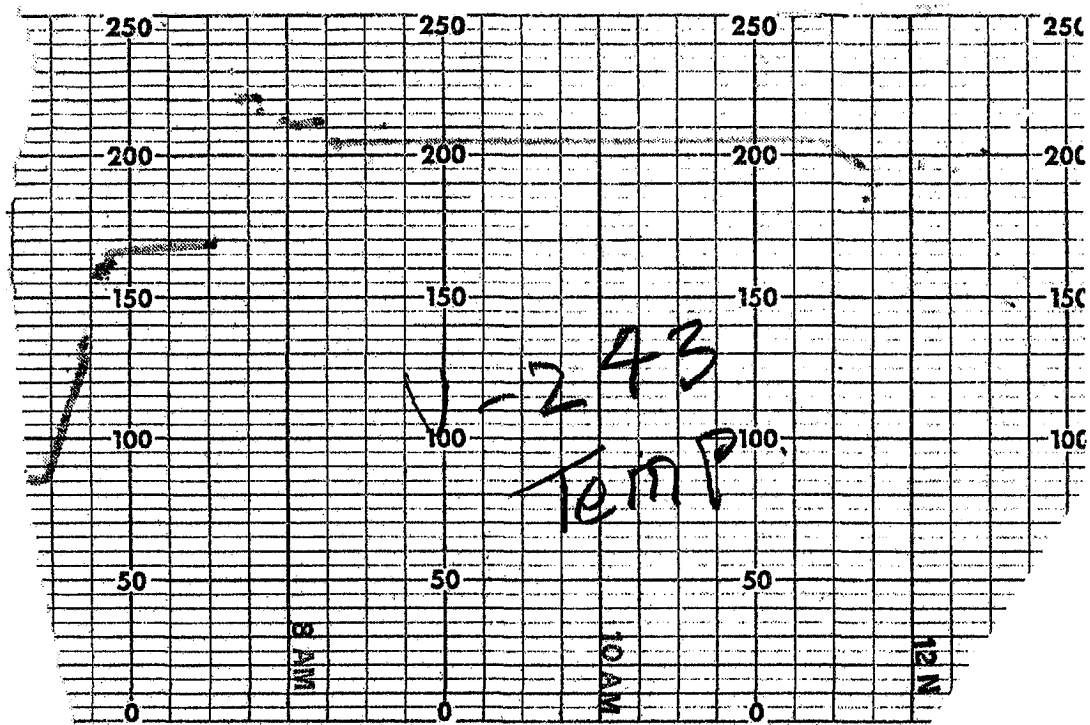
NON-BLEEDING

INVENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	10" "KROLOR" - YELLOW MEDIUM			
203	1 Run 10" (992 G) water into V-203			
&	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 6:15 AM	24070		
	Fin 8:45 AM	24077		
		24168		
	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 1800-2000 psi using minimum water			
	7 Record V-205 Vol V-263 & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time start 10:00 PM Total Min 150			
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 35 % - preset #1	80 Gal	15-A	160
	b. 13LG 40 % - 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. 3FR10 (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	17 Record Level 2 LG 62 %. If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj to 48" (2470 G)			
4	19 Record pH 10.5			
	20 Adj to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50%	30	7-D	15
	(10 parts water to 1 part N-7-D)			
	Siphon into SV, Record pH 11.3			
	21 Operator Step PB			

N-245

JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT.	3490	LBS.	USE LBS.	N CODE	ACC LBS
SV	22	SP Step 06/39 - After heat up Record: pH <u>9.7</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	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							
	29	During strike, record pH & time as follows: <u>3.20 AM</u>							
		SP STEP							
		V-243/V-244	pH	Range	Time				
		13/46 (30 min)	<u>9.7</u>	9.0-10.0	<u>3.50 AM</u>				
		14/47 (60 min)	<u>9.7</u>	9.0-10.0	<u>4.20 AM</u>				
		15/48 (2 hrs)	<u>9.7</u>	9.0-10.0	<u>5.20 AM</u>				
		16/49 (2 hrs 25 min)	<u>9.7</u>	9.0-10.0	<u>5.45 AM</u>				
		17/50 (3 hrs Final)	<u>8.1</u>	7.5-8.5	<u>6.20 AM</u>				
		NOTE: If not as specified notify Supervisor & note in log							
		If final pH is above 8.5, add pH to 7.5-8.5 &							
		Record: pH Assume 77%						27-D	
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>10.2</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>38.2G</u>							
	35	Set preset #8 to <u>38.2 G</u> 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	SP Step 23/53 - Record: pH <u>3.4</u> (3.7-4.2)					100	128-A	100
SP	40	Run in N-7-D from S 37 in 10-12 min & stir 5 min							
&	41	Record: pH <u>9.7</u> (9.0-9.5) & if necessary add pH 9.0-9.5							
CP	42	& Record: pH <u>9.5</u> Assume 77%					6	27-D	
8		(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>9.35</u> (9.0-10.0) Time <u>7:45</u>							
	45	Operator Step PB							
	46	SP Step 60 - Batch complete. Pump to V 240 when ready							
		Start	Finish	Optr					
		Time SP Step	Time SP Step						
		<u>7:00 AM</u>	<u>7:00 PM</u>	<u>409</u>					
		<u>11:00 PM</u>	<u>7:00 AM</u>	<u>145-144</u>					
		<u>7:00 AM</u>	<u>7:50 AM</u>	<u>235-342</u>					





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