

243, 244 (Automated)

MAR 27 1980

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

KY 7877D KY 795-D 35278

LOT 35245

APR 16 1980

PROCESSES		APPROVED BY	
()	KY-795-D (H)	(H)	EWK 10-05-76
()		()	DCG 10-07-76
()		()	MTW 10-11-76
()		()	FWP 12-22-78
TYPED BY			
emw122278			

110 HRS 8.2 TIME 11:00 M
 14 YC-2-B 93 4 Lot 24773, 2000#
 14 YC-2-B 93 4 Lot 24776, 1200#
 14 YC-2-B 93 4 Lot 24778, 200#
 24774, 100#

OK
 FP
 EL Homog #4 - 1st Pass

Total Wgt. 4612# 4380#

NON-BLEEDING

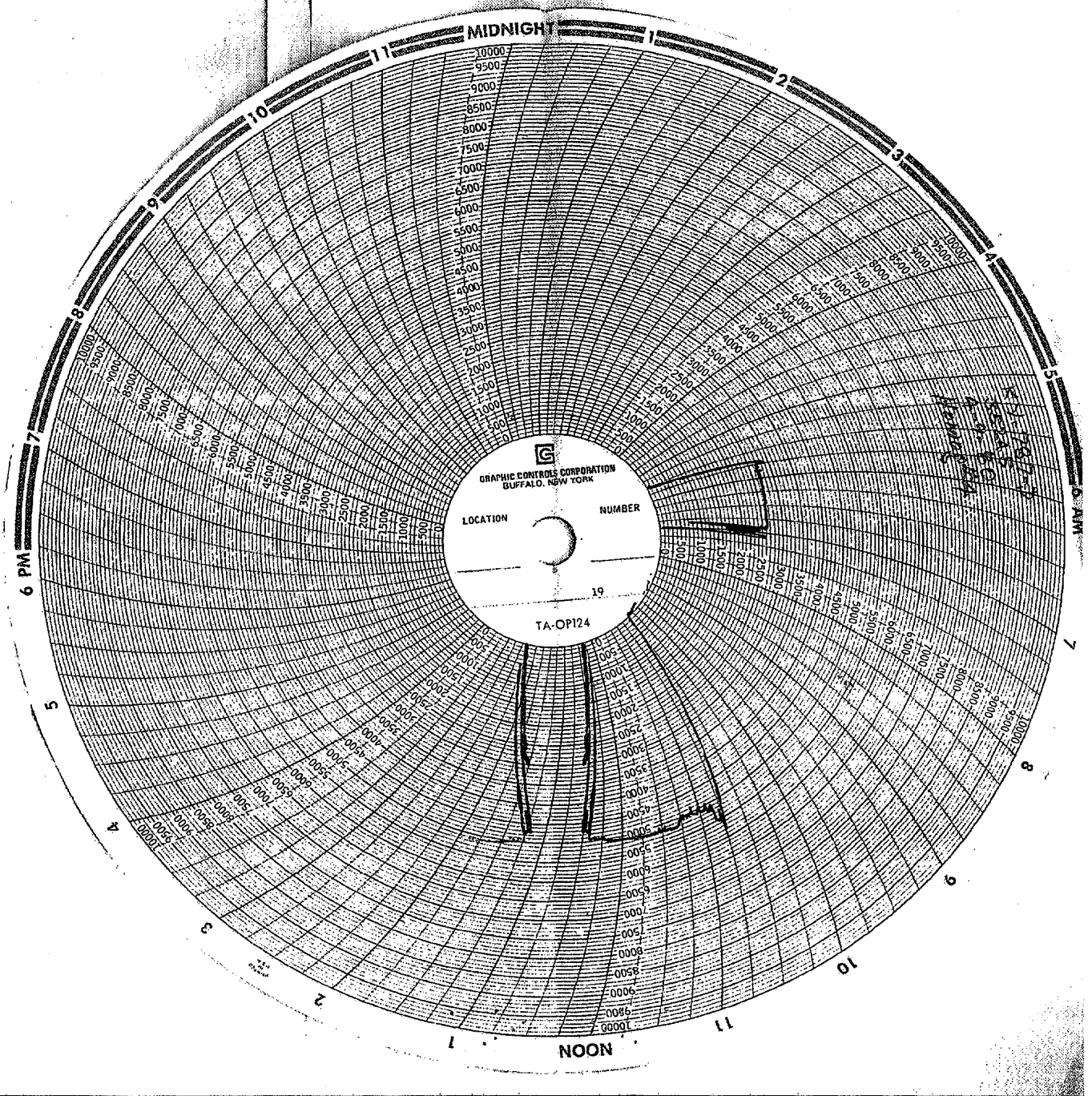
INVENT	NAME: KROLOR ⁰⁰ YELLOW MEDIUM	USE LBS.	N CODE	ACCT LBS.
203 & 205	1 Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED			355
	2 Weigh in drum & pour in	353475	32-D	475
	3 Dump in & stir 5 min	Lot 70 x 50	YC-2-B	3500
1	Record: Start 3:00 PM	24773	2000	
	Fin 5:20 AM	24776	1200	
	75" (1275 G)	24778	200	
	4 Adj to 78" (1328 G)	24774	100	
	5 Pump V-203 thru Homog at 2400-2600 psi into V-205			
	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7 Record: V-205 Vol 49" & adj to 51" (1874 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205 & SV	9 Run 10" (514 G) water into V-243 & start agitator			
	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time Start 10:15 AM 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. Rinse in using Hot Water			
SP & CP	12 SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (V-244)			
	13 Press SV Cam Reset PB set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
3	14 Record Levels and set Raw Material Counter #1 as follows:			
	a. 11 LG 64 % - preset #1 104 Gal		15-A	208
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.71 9.95 GPM		27-D	295
	b. 3FC20 (N-27-D Water) in Manual Local 5.76 7.7 GPM			
	c. 3FR10 (N-27-D / Water Ratio) 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 0.95 1.27 GPM		32-D	2675
	e. 8FC20 (N-32-D Water) in Manual Local 4.6 6.2 GPM			2001
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D / Water) Ratio 1.0			
SV & CP	16 Operator Step PB			
	17 Record Level 2LG 88 % if below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 68" (3495 G)			
4	19 Record: pH 10.6 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
	Siphon N-7-D into SV & Record: pH 11.1			
	20 Operator Step PB			

N32467

3:25P

243

EQUIPMENT	PAGE 2	EG 03 CODE KY-795-D (H) EST. WGT.	4612 LBS.	USE LBS.	N CODE	ACC LBS.															
SV	21	SP Step 06/39 - After heat up Record: pH 9.8 (9.5-10.0)																			
SP	22	Switch 3FC20, 8FC10, 8FC20, to Auto																			
&	23	Operator Step PB																			
CP	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits																			
5		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)	9.6	9.0-10.0	3:55																
		14/47 (60 min)	9.7	9.0-10.0	4:25P																
		15/48 (2 hrs)	9.75	9.0-10.0	5:25P																
		16/49 (3 hrs)	9.7	9.0-10.0	6:25P																
		17/50 (Final)	8.4	7.5-8.5	6:50P																
		NOTE: If not as specified notify Supervisor & note in log																			
		If final pH above 8.5 adj to 7.5-8.5																			
		& Record: pH		Assume 77%		27-D															
Drum	28	Weigh into 55 Gal Drum		Assume 50%	56	7-D 28															
7	29	Fill with water & stir 2 min																			
SV	30	SP Step 17/50 - After checking pH, Operator Step PB																			
SP	31	Step 23/53 - Record: pH 3.7 (3.3-3.7)																			
&	32	If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH				15-A															
CP	33	Sift in 3 bags			150	128-A 150															
8	34	Siphon in N-7-D from S 29 in 10-12 min & stir 5 min																			
	35	Record: pH 4.7 (4.0-4.2) & if necessary adj to pH 4.0-4.2																			
		& Record: pH 4.1		Assume 77%	6	27-D															
		(Dilute 10 parts water to 1 part N-7-D)		Assume 50%		7-D															
		Siphon N-7-D into SV																			
	36	Operator Step PB																			
	37	SP Step 24/54 - Pour in & stir 15 min			22	978-A 22															
	38	Operator Step PB																			
	39	SP Step 60 - Batch complete & PUMPED TO V-240																			
<table border="1"> <thead> <tr> <th>START</th> <th>FINISH</th> <th>OPTR</th> </tr> <tr> <th>TIME SP STEP</th> <th>TIME SP STEP</th> <th></th> </tr> </thead> <tbody> <tr> <td>3:30A</td> <td>7:00 AM</td> <td>235-54</td> </tr> <tr> <td>7:Am</td> <td>3: Pm</td> <td>223-282</td> </tr> <tr> <td>3:00P</td> <td>10:15 P</td> <td>126-120</td> </tr> </tbody> </table>							START	FINISH	OPTR	TIME SP STEP	TIME SP STEP		3:30A	7:00 AM	235-54	7:Am	3: Pm	223-282	3:00P	10:15 P	126-120
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