

CG 03 CODE KY-788-D PKG.

MAR 15 34889
EST. WGT. 960 860 LBS.STD. HRS. 8.8 TIME 7.4 M
14 YC-3-B 98 4 Lot 24465 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		

PUNCHED & CHECKED

Total Wgt. 3560# 3460

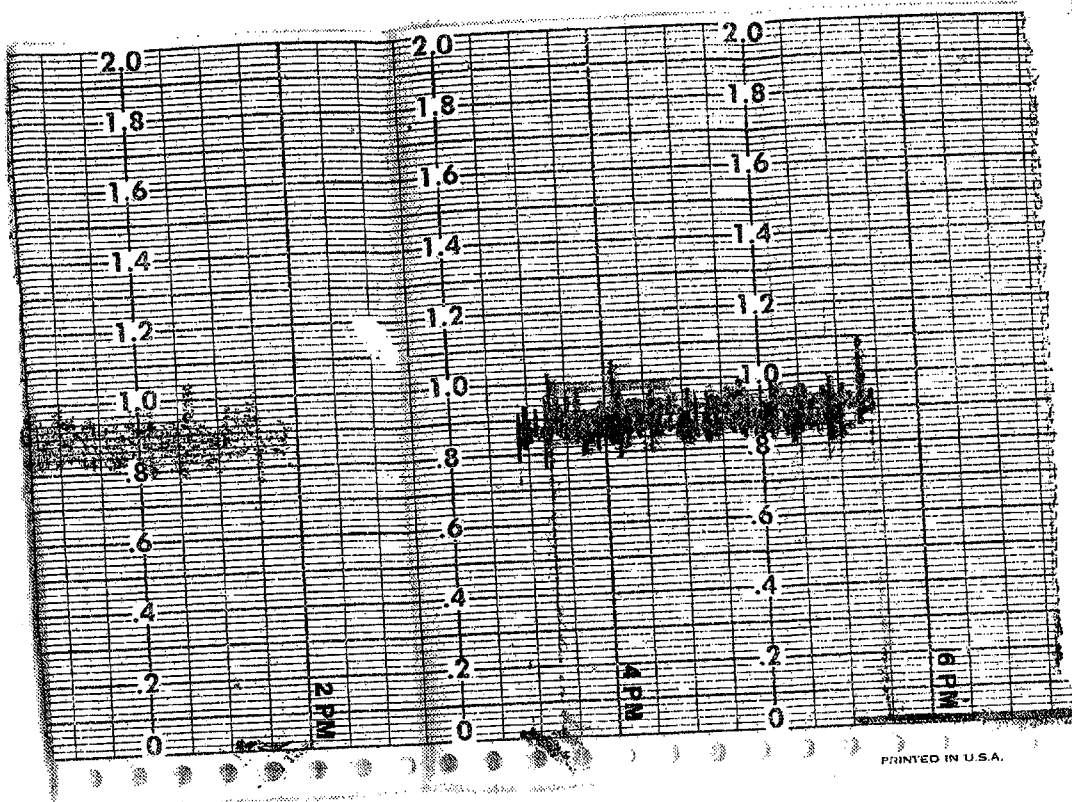
MAR 1 1980

NON-BLEEDING

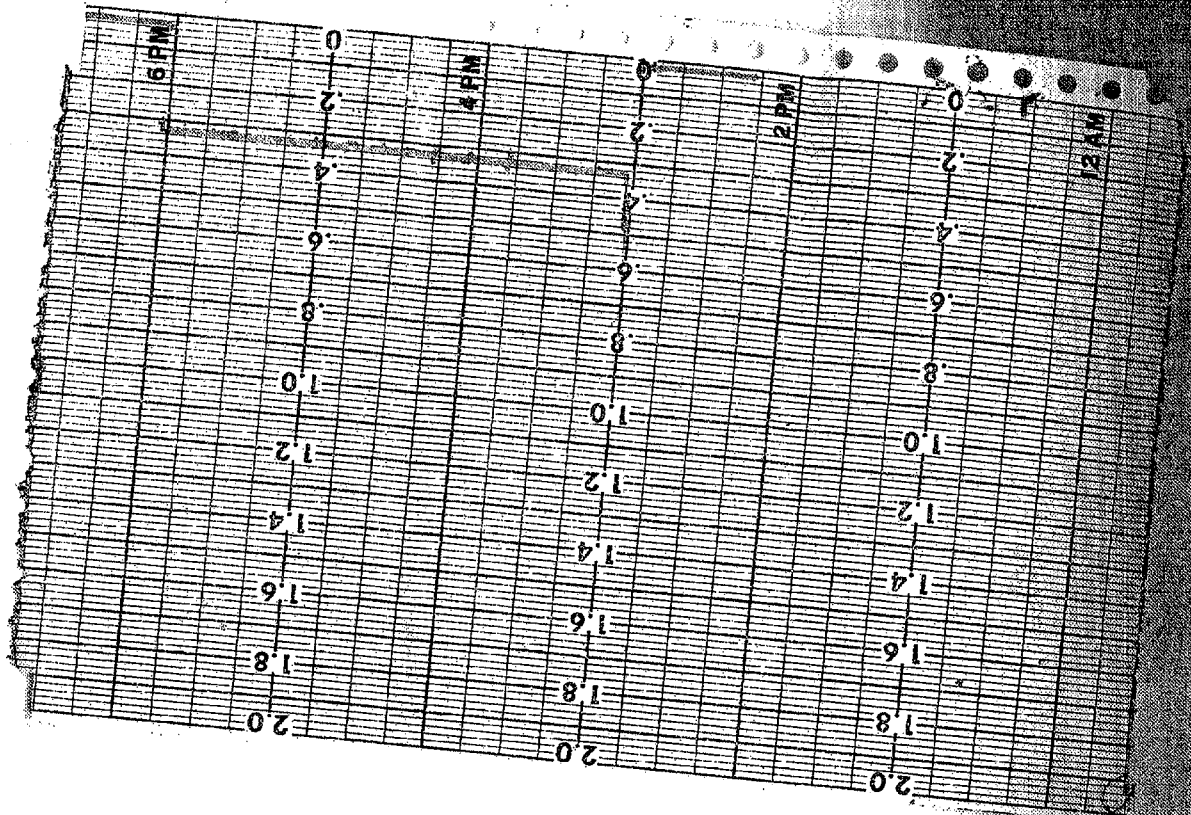
JIPMENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" (1906) "KROLOR" YELLOW - LIGHT			
&	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
205	2 Weigh in drum & pour in	345	32-D	345
1	3 Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
	Record: Start 4:15 PM			
	Fin 5:15 PM 24405 2600			
	75" (1275 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 washcolor thru Homog at 1800-2200 psi using minimum water.			
	7 Record: V-205 Vol 140 "& adj to 60" (2100 G)			
	8 Inspect homog. strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
205	8 Run 10" (514 G) water into V-244 & start agitator.			
&	9 Pump V-205 thru Homog at 4800-5200 psi into V-244			
SV	Record: Time Start 8:30 PM Total min 1:00			
2	Note: If Homog pressure falls below 4800 ps., 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 #1 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
&	13 Press SV Cam Reset PB- set 22 TC in Auto Remote			
CP	(Temperature is set at 190-194 F)			
3	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 64% - preset #2 208 Gal 15-A 416			
	b. 13LG 74% - preset #6 135 Gal 20-A 135			
	15 Set strike flow controllers as follows:			
	a. 3PC10 (N-27-D Controller) in Manual 0.54 GPM 27-D 180			
	b. 3PC20 (N-27-D Water) in Manual Local 4.4 GPM			
	c. 3PR10 (N-27-D/Water) Ratio 0.8			
	d. 8PC10 (N-32-D Controller) in Manual 0.72 GPM 32-D 1215			
	e. 8PC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 8PC20 (N-32-D Water) in Remote			
	g. 8PR10 (N-32-D/Water) Ratio 1.1			
320	16 Operator Step PB			
243	17 Record Level 21G 7% .If below 35% follow solution			
SP	make-up procedure for N-27-D			
&	18 Adj SV to 47" (2400 G)			
CP	19 Record pH 10.2 . Adj to 11.0-11.2 using N-7-D diluted to			
4	5% (10 parts water to 1 part N-7-D) Assume 50% 30 7-D 15			
	Siphon into SV & Record: pH 11.2			
	20 Operator Step PB			

V244

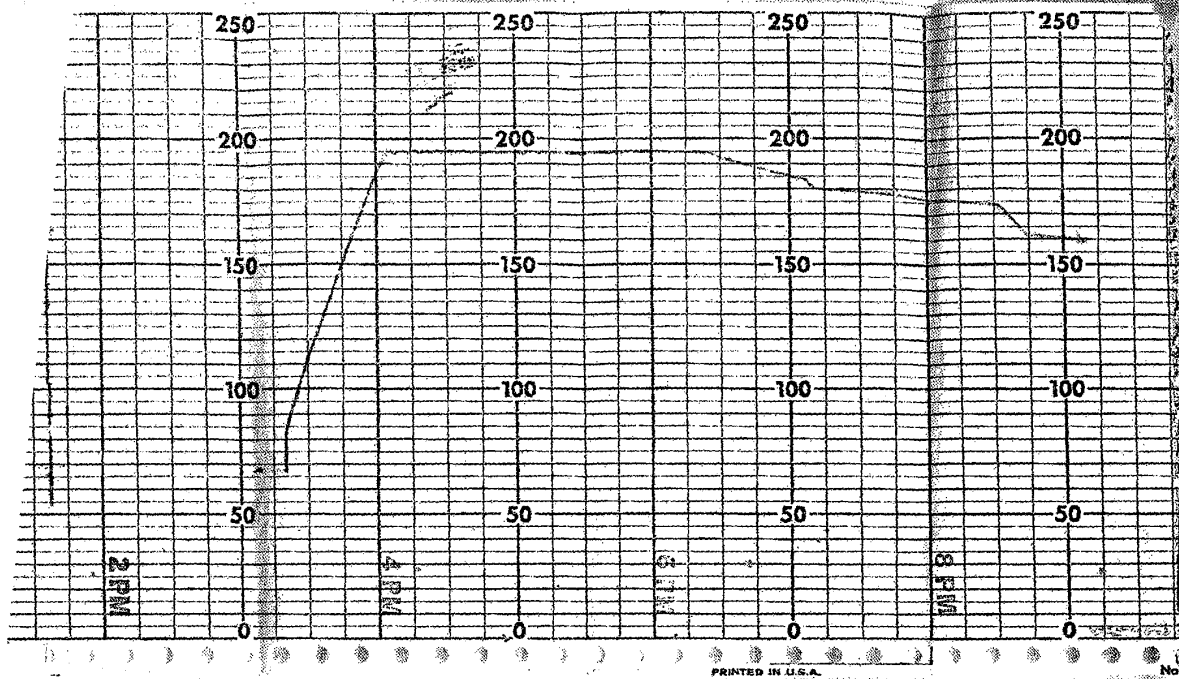
UIPMENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS.
SV	21	SP Step 06/39	- After heat up Record: pH 9.9 (9.5-10.0)					
SP	22	Switch 3FC20	8FC10, 8FC20 to Auto					
	23	Operator Step PB						
5	24	SP Step 10/43	- When 3FC20, 8FC10, 8FC20 water flows is limits					
			Swich 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-234/V-244	pH ~ Range Time					
		3/18 (30 min)	9.7 9.3-10.0 18:50 AM					
		14/47 (60 min)	9.7 9.3-10.0 1:20 PM					
		15/48 (2 hrs)	9.7 9.3-10.0 2:20 PM					
		16/49 (2 hrs 25 min)	9.6 9.3-10.0 2:45 PM					
		17/50 (Final 3 hrs)	9.9 7.5-8.5 3:20 PM					
		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 9.0 (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 = 37.2 G)						
	34	Set preset #8 to 37.2 G from S 33						
302	35	Run 40" (440 G) water into V-302						
7	36	Add & stir 2 min for S 40 Assume 50%			360		7-D	180
SV	37	SP Step 17/50 After checking pH. Operator Step PB						
SP	38	Sift in 2 bags			100		128-A	100
	39	SP Step 23/53 Record: pH 9.9 (3.7-4.2)						
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min						
	41	Record: pH 9.4 (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 9.4 (9.0-10.0) Time 5:30 PM						
	44	Operator Step PB						
	45	SP Step 60 - Batch complete						
		Start Finish Optr						
		Time SP Step Time SP Step						
		11:00 AM 5:40 PM 37						



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