

D.V. 244, Automated

C.V.

D.V.

CG 09 CODE KY-781-D PKG.

→ JAN 30 34104

3P

EST. WGT. 1178 1128 LBS.

STD. HRS. TIME M

14 YC-3-B 93 4 24417 3300 #

14 YC-3-B 93 4 #

14 YC-3-B 93 4 #

4478 Total Wgt. 4428# (Req)

PROCESSES		APPROVED BY
()	KY-781-D (N)	FWP 101378
()	()	AMJ 101378
()	()	
()	()	
TYPED BY		
emw101378		

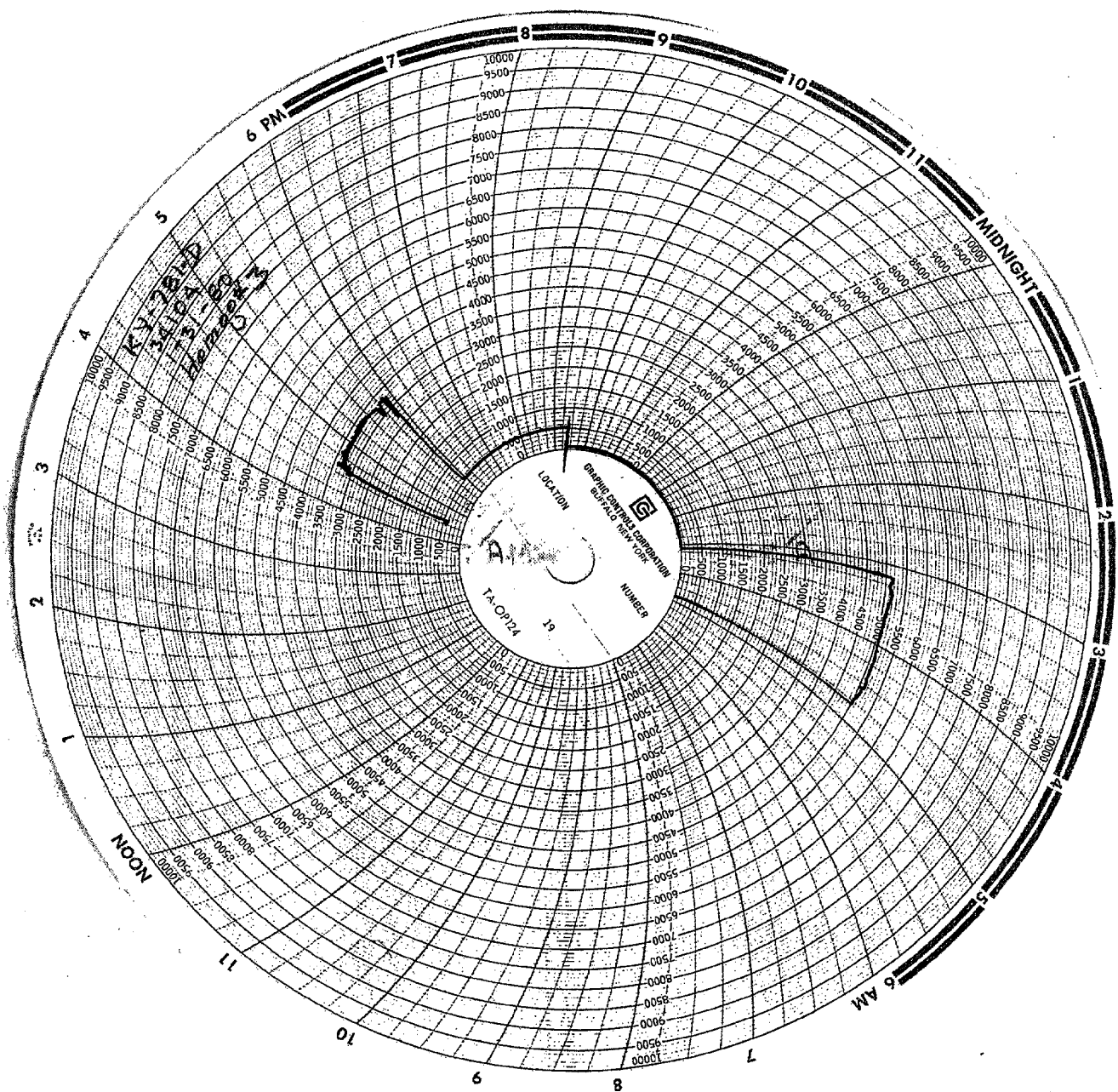
Homog # 3 - 1st Pass
Homog # 3 - 2nd Pass

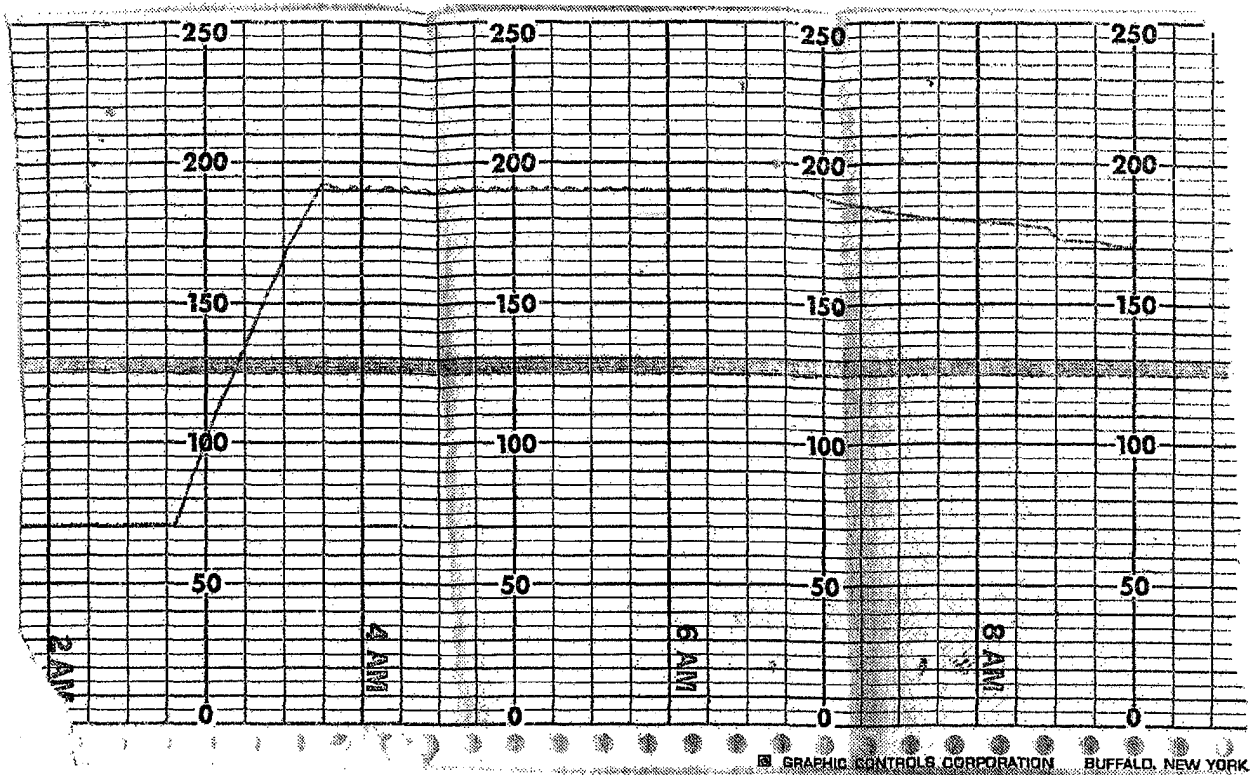
NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	1 Run 60" (992 G) water in V-203 & add	Assume 50%	36	7-D 18
&	2 Weigh in drum & pour in		442	32-D 442
205	3 Dump in & stir 5 min	Lot	66 x 50	YC-3-B 3300
1	Record: Start 9:45 A.M. 24417 3300			
	Fin 9:30 A.M.			
	75" (1275 G) 2440-2600			
	4 Adj to 80" (1360 G) & Record: pH 10.6 (10.5-11.5)			
	5 Pump V-203 thru Homog # at 1800-2200 psi into V-205			
	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-205 Vol 40" & adj to 45" (1662 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 12" (200 G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
SV	Record: Time Start 3:15 A.M. Total Min 90			
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 & CP	12 SP Step 01 - Set Formula Selector to position #1 (V-243) or #6 (V-244)			
3	13 Press SV Cam Reset PB-Set 22TC in Auto Remote (Temperature is set at 190-194°F)			
	14 Record levels and set Raw Material Counter #1 as follows:			
	a) 11LG 29 % - preset #3 187 Gal		15-A	374
	15 Set strike flow controllers as follows:			
	a) 3FC10 (N-27-D Controller) in Manual 0.9 GPM		27-D	373
	b) 3FC20 (N-27-D Water) in Manual Local 6.3 GPM			
	c) 3FR10 (N-27-D / Water Ratio) 0.7			
	d) 8FC10 (N-32-D Controller) in Manual 1.20 GPM		32-D	2527
	e) 8FC20 (N-32-D Water) in Manual Local 5.4 GPM			
	f) 8FC20 (N-32-D Water) in Remote			
	g) 8FR10 (N-32-D / Water Ratio) 0.9			
SV	16 Operator Step PB			
SP & CP	17 Record Level 2LG 47 %. If below 35% follow solution make-up procedure for N-27-D			
4	18 Adj SV to 54" (2800 G)			
	19 Record: pH 9.4			
	20 Adj pH to 11.4-11.6 using Assume 50% 40		7-D	20
	(Dilute to 5% (10 parts water to 1 part N-7-D)			
	Siphon into SV. Record: pH 11.4			
	21 Operator Step PB			

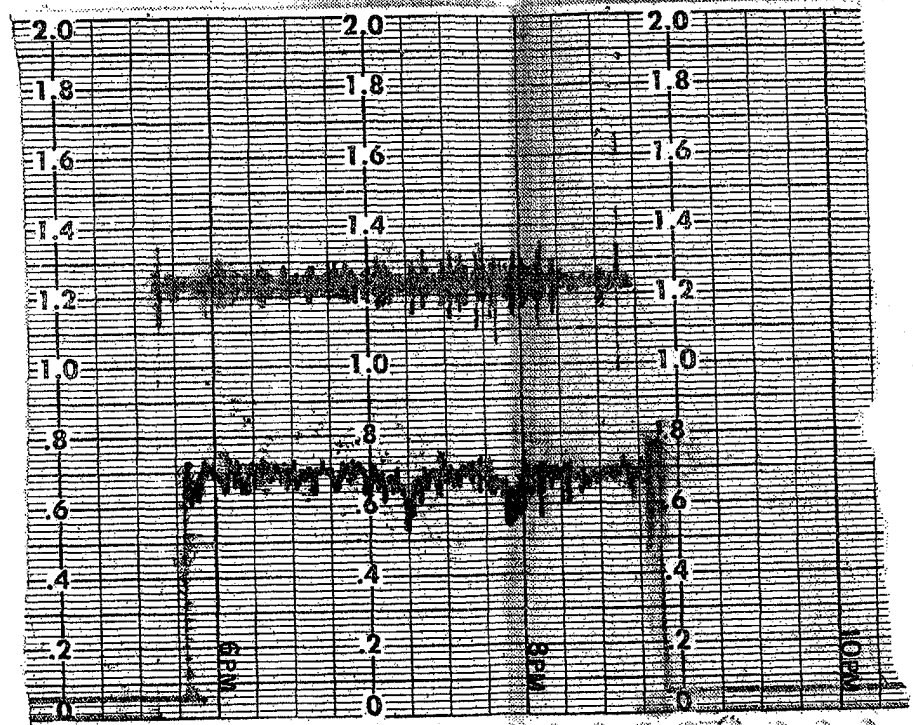
U-244

EQUIPMENT	PAGE 2	CG 03 CODE	KY-781-D	N EST. WGT.	1128 LBS.	USE LBS.	N CODE	ACC LBS.
SV	22	SP Step 06/39.	After heat up Record:	pH 9.2	(9.6-10.2)			
SP	23	Switch 3FC20, 8FC10, 8FC20,	to Auto					
&	24	Operator Step PB						
CP	25	SP Step 10.43 - When 3FC20, 8FC10, 8FC20 water flow in limits						
5		switch 3FC10 to Auto. Operator Step PB						
	26	SP Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20						
		to Remote. Operator Step PB						
	27	During Strike, Record pH & Time as follows:						
		SP Step	pH	Range	Time			
		13/41 (30 min)	9.9	9.3-10.0	2:55			
		14/47 (60 min)	9.9	9.3-10.0	8:25			
		(2 hrs)	9.9	9.3-10.0	9:25			
		(3 hrs)	9.9	9.3-10.0	10:25			
		17.50 (Final)	8.4	7.5- 8.5	11:10			
		NOTE: If pH not as specified notify Supervisor & note in						
		log. If final pH is above (8.5) Adj to pH 7.5-8.5						
		M			%		27-D	
V-302	28	Add 31" (379 G) water to V-302						
6	29	Add & stir 5 min		Assume 50%		124	7-D	62
SV	30	SP Step 17/50 after checking pH. Operator PB						
SP	31	SP Step 23/53 Record: pH 3.6	(3.3-3.7)					
&	32	If necessary adj pH (DOWN ONLY) Record: pH					15-A	
CP		NOTE: Dissolve extra N-15-A in water at 110-120°F in drum						
7		Use ±30 Gal of water to 50# N-15-A. Stir SV 5 min						
		after each addition						
	33	Sift in				200 150	128-A	150
	34	Run in N-7-D from S 29 & stir 5 min						
	35	Record: pH 4.3	(4.2-4.4)					
	36	If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts						
		H ₂ O to 1 part N-7-D) or N-27						
		M			%		27-D	
		Assume 50%					7-D	
		Siphon (if N-7-D) into SV. Record: pH						
	37	Operator Step PB						
	38	SP Step 24/54 - Add N-978-A & stir 15 min				20	978-A	20
	39	Operator Step PB						
	40	SP Step 60 - Batch Complete						
		START		FIN		OPTR		
		TIME	SP STEP	TIME	SP STEP			
		2:00 P		11:00 P		235-301		
		3:00 AM		7:04 AM		381-282		
		7:00 A		12:30 P		126		

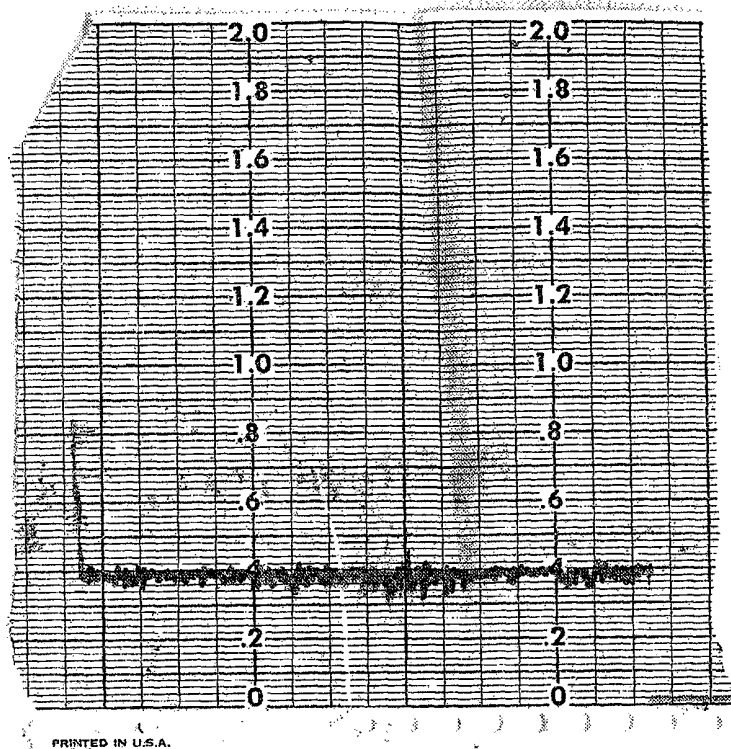




GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



DUP050094895