243 244 (Automated) C D.V.

YC-3-B

CG 03 CODE KY-788-D PKG.

→ APR 11 35535

EST. WGT. 960 LBS.

STD. HRS. 8.8 TIME 3P M

14 YC-3-B 98 4 Lot 24720 , 2000

14 YC-3-B 98 4 Lot 24699 , 600

14 YC-3-B 98 4 Lot

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		

OK

KP

PUNCHED & CHECKED

3 HOMO 2ND PASS

APR 16 1980

APR 14 1980

Total Wgt. 3560#

NON-BLEEDING

JIPMENT		NAME	USE LBS.	N CODE	ACCT. LBS.
		60" (1900 G) "KROLOR" YELLOW - LIGHT			
203 & 205 1	1	Run ~~23" (360 G)~~ water into V-203, SET AGITATOR ON HIGH SPEED			
	2	Weigh in drum & pour in	345	32-D	345
	3	Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
		Record: Start 3:45 Pm 24720	2000		
		Fin 5:Pm 24699	600		
		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 minimun water 263			
	7	Record: V-205 Vol 42 "& adj to 60" (2100 G)			
	8	Inspect homog. strainer & clean if necessary			
		DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205 & SV 2	9	Run 10" (514 G) water into V-244 & startagitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into V-244			
		Record: Time Start 12.01 Total min 150			
		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 3	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)			
	14	Record levels and set Raw Material Counter #1 as follows			
		a. 11LG 29 % - preset #2 208 Gal		15-A	416
		b. 13LG 37 % - preset #5 135 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			
320 243 SP & CP 4	16	Operator Step PB			
	17	Record Level 2LG 89 %. If below 35% follow solution make-up procedure for N-27-D			
	18	Adj SV to 47" (2400 G)			
	19	Record pH 10.35 . 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			

Jk

Set pass in 263 VAT

20 REV.

N32254

V-244

UIPMENT		PAGE 2 CG 03 CODE KY-788-D EST. WGT. 3550 LBS.	USE LBS.	N CODE	ACCT LB
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			
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits;			
5		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 pH Range Time			
		V-244			
		13/45 (30 min) 7.8 9.3-10.0 6:00			
		14/47 (60 min) 4.86 9.3-10.0 6:30			
		16/48 (2 hrs) 9.9 9.3-10.0 7:30			
		16/49 (2 hrs 25 min) 9.95 9.3-10.0 7:55			
		17/50 (Final 3 hrs) 9.2 8.5-8.5 8:30			
		Note: If not as specified notify Supervisor & Note in log			
		If final pH is above 8.5, adj 7.5-8.5			
		& Record: pH 8.4 Assume 77%	18	27-D	14
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 °F			
	31	Stir 5 min & record pH 10.1 (9.5-10.5)			
	32	Stir 15 min or longer to dissolve for SP Step 56			
	33	Record Vol 63 " & Calculate 63 " (Vol X.078= 4.3 G)			
	34	Set preset #8 to 4.3G 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 3.4 (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 9.2 (9.0-10.0) Time 2:55 PM			
	44	Operator Step PB			
	45	SP Step 60 - Batch complete			

Start Time	SP Step	Finish Time	SP Step	Optr
5 PM		11 PM		320-322
11:00 PM		7:00 AM		409-244
7:00 A		10:00 PM		235-301

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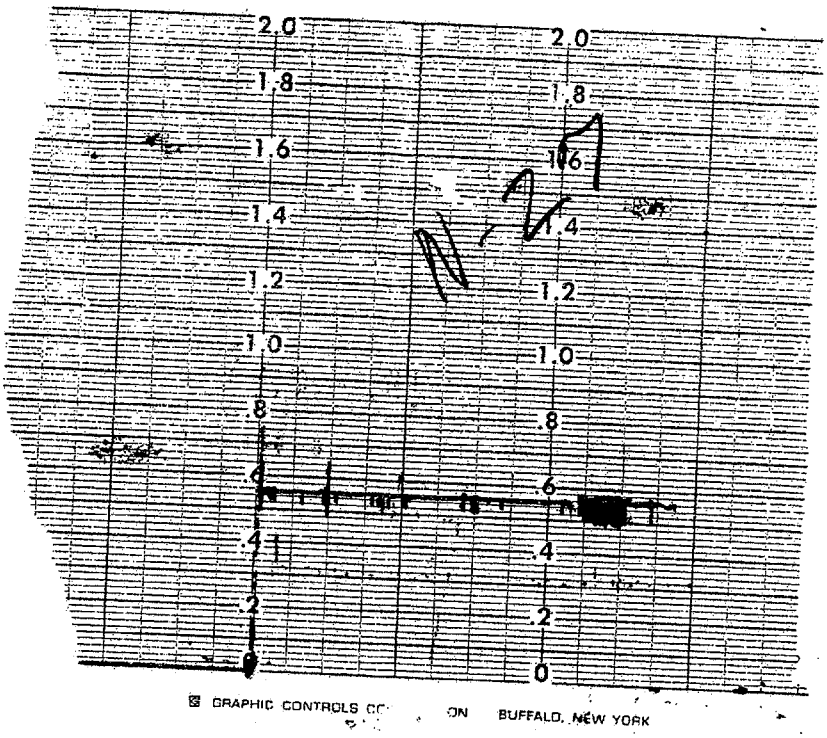

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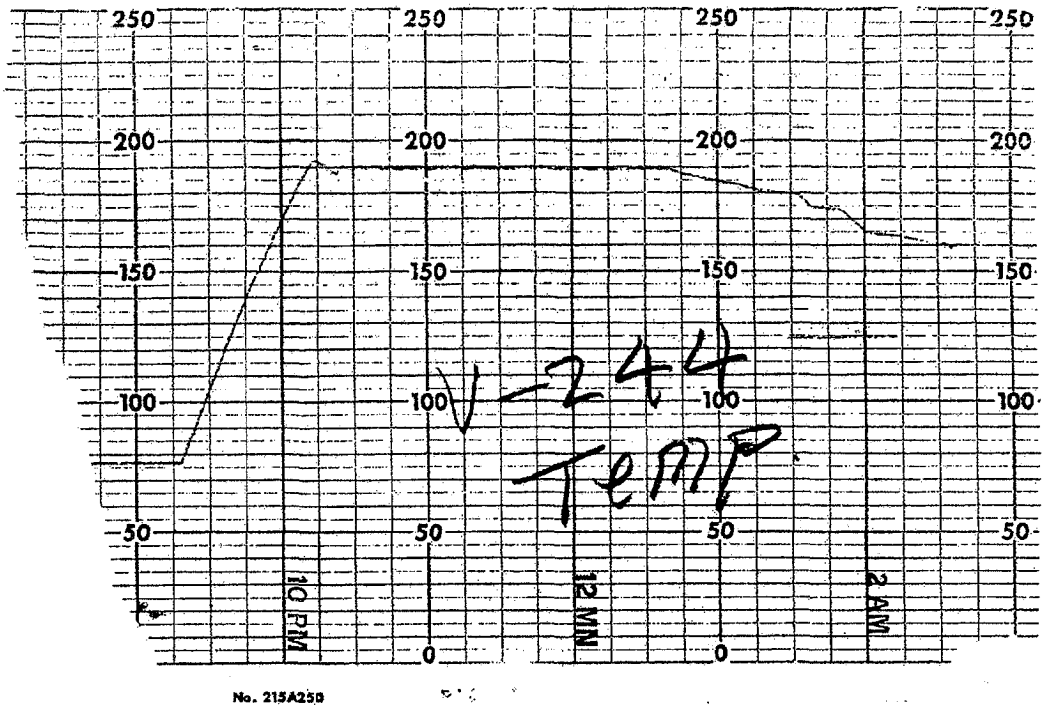
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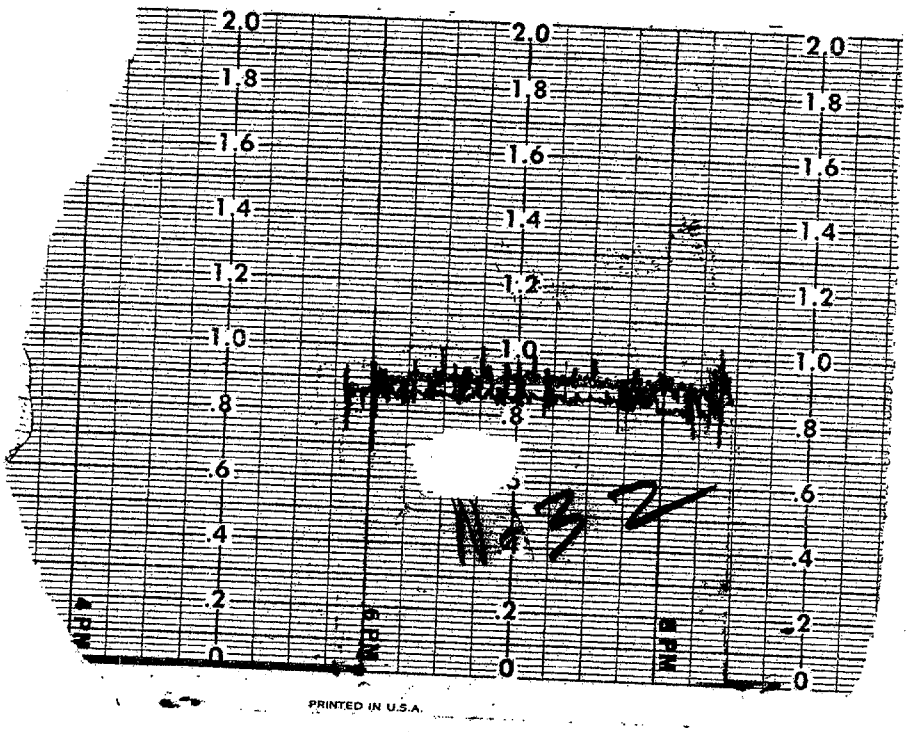
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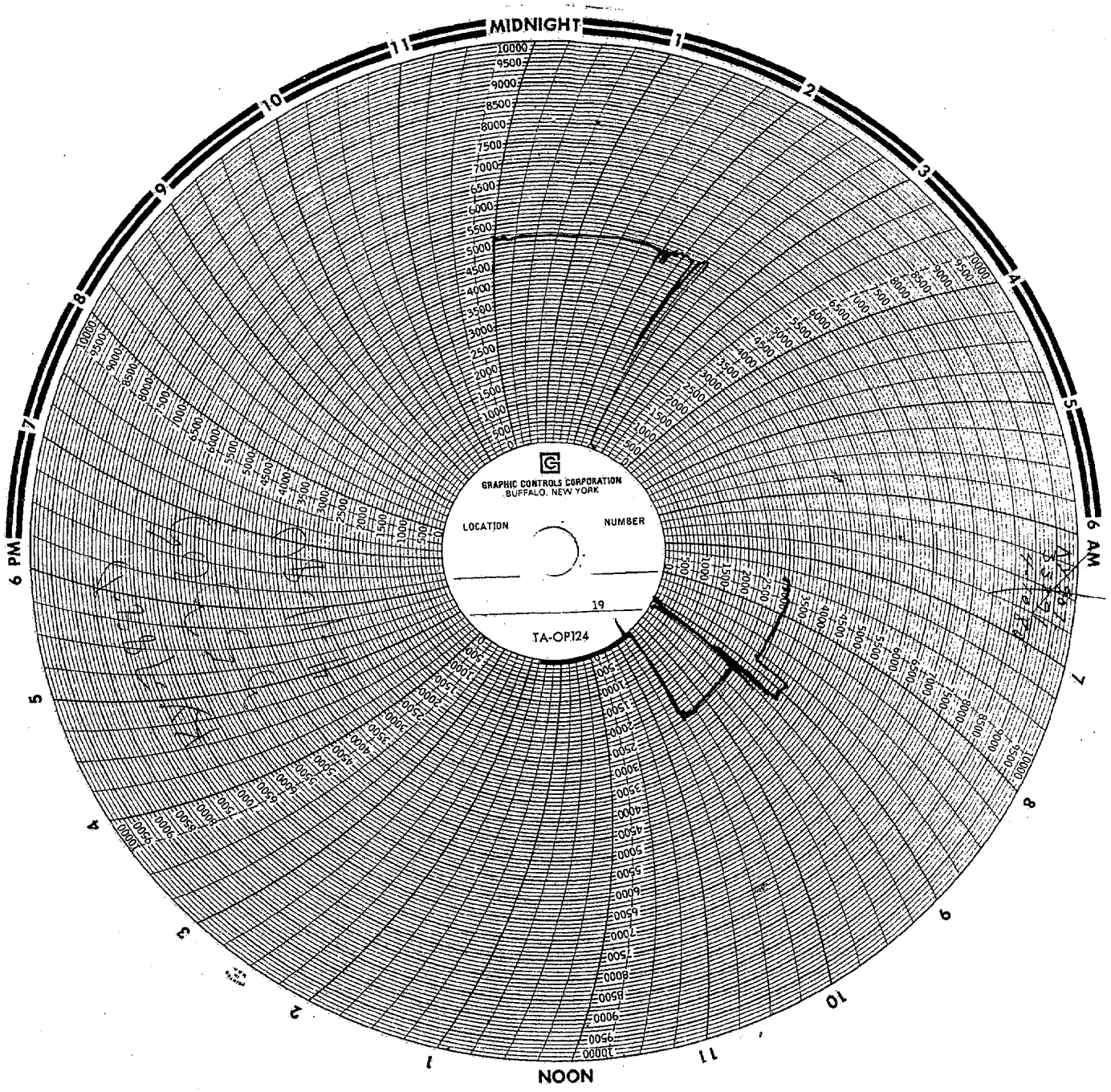

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