

MAR 27 1980

MAKING INSTRUCTIONS- BATCH UNIT

V 2413 (AUTOMATED)

C V

D V

CG 03 CODE KY-787-D

PKG

EST WGT 1090

LBS

STD MRS 8.9

TIME

14 YC-2-B 93 4

LOT

24476, 2002

LOT 24474, 400

LOT

PUNCHED & CHECKED

OK

PROCESSES	APPROVED BY
() KY-787-D	() EWK 9-22-76
()	() DCG 9-27-76
()	() MTW 9-30-76
()	()
RE TYPED BY	
CJH 2-8-80	

Homog #4 - 1st Pass
 "8" #4 - 2nd Pass
 MAR 30 1980

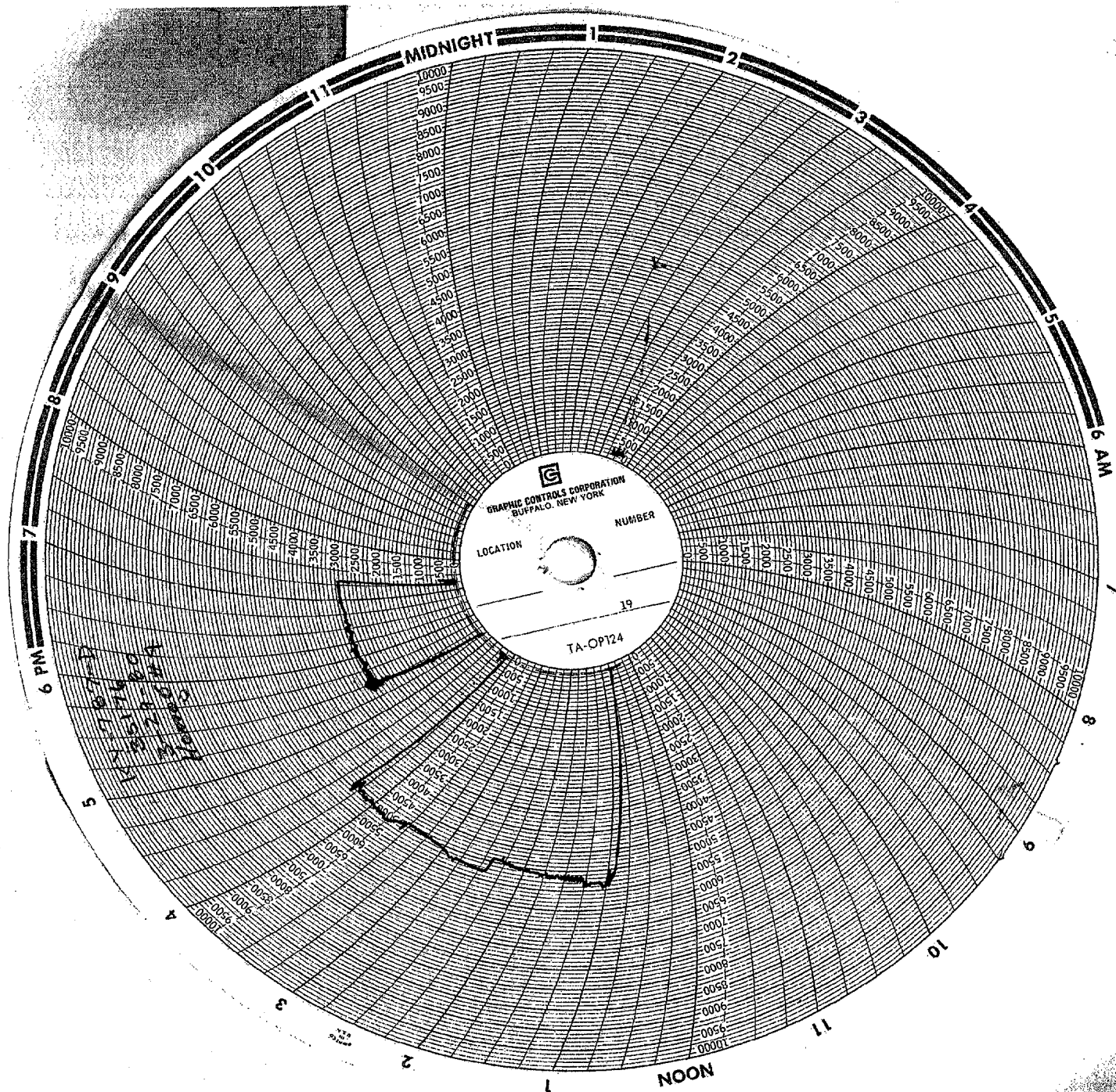
TOTAL WGT 3490#

NON-BLEEDING

APMENT	NAME	USE LBS	N CODE	ACCT LBS
203	"KROLOR" YELLOW MEDIUM			
203 & 205	1 RUN 60" (992 G) WATER INTO V-203 SET AGITATOR ON HIGH SPEED	320	32-D	320
203	2 WEIGH IN DRUM & POUR IN	48 X 50	YC-2-B	2400
203	3 DUMP IN AND STIR 5 MIN			
203	4 RECORD: START	24476		
203	5 FIN	24474		
203	6 25" (1225 G)	2400-2600		
203	7 PUMP V-203 THRU HOMOG #3 AT 1800-2200 PSI INTO V-205			
203	8 WHEN V-203 MTY, WASH COLOR THRU HOMOG AT 1800-2000 PSI USING MINIMUM WATER	2675		
203	9 RECORD V-205 VOL & ADJ TO 60" (2100 G)			
203	10 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
203	11 PUMP V-203 THRU HOMOG #3 AT 1800-2200 PSI INTO V-205			
203	12 RUN 10" (514 G) WATER INTO SV. START AGITATOR			
203	13 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-203			
203	14 RECORD: TIME START 1:05 PM TOTAL MIN 2:20			
203	15 NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
203	16 WHEN V-205 MTY, RUN IN 5" (240 G) WATER AND PUMP THRU HOMOG AT 4800-5200 PSI			
SP & CP	17 SP STEP 01 - SET FORMULA SELECTOR TO POSITION 1/2 (V-243) OR 1/2 (V-244)			
3	18 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
3	19 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
3	20 A 11LG 1.3% - PRESET #1 80 GAL 15-A 160			
3	21 B 13LG 2.2% - PRESET #6 135 GAL 20-A 135			
3	22 SET STIRKE FLOW CONTROLLERS AS FOLLOWS:			
3	23 A SEC10 (N-27-D CONTROLLER) IN MANUAL 0.85 GPM 27 275			
3	24 B SEC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
3	25 C SEC10 (N-27-D/WATER RATIO) 0.61			
3	26 D SEC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM 32-D 7840			
3	27 E SEC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
3	28 F SEC20 (N-32-D WATER) IN REMOTE			
3	29 G SEC10 (N-32-D/WATER RATIO) 0.83			
SV	30 OPERATOR STEP PB			
SP & CP	31 RECORD LEVEL 2 LG 6.4% IF BELOW 35% FOLLOW SOLUTION			
4	32 MAKE-UP PROCEDURE FOR N-27-D			
4	33 ADJ TO 48" (240 G)			
4	34 RECORD: PH 10.5			
4	35 ADJ TO 11.1 - 11.3 USING N-7-D DILUTED TO 5% ASSUME 50% (10 PARTS WATER TO 1 PART N-7-D)	22	1-D	11
4	36 SIPHON INTO SV. RECORD PH 11.2			
4	37 OPERATOR STEP PB			

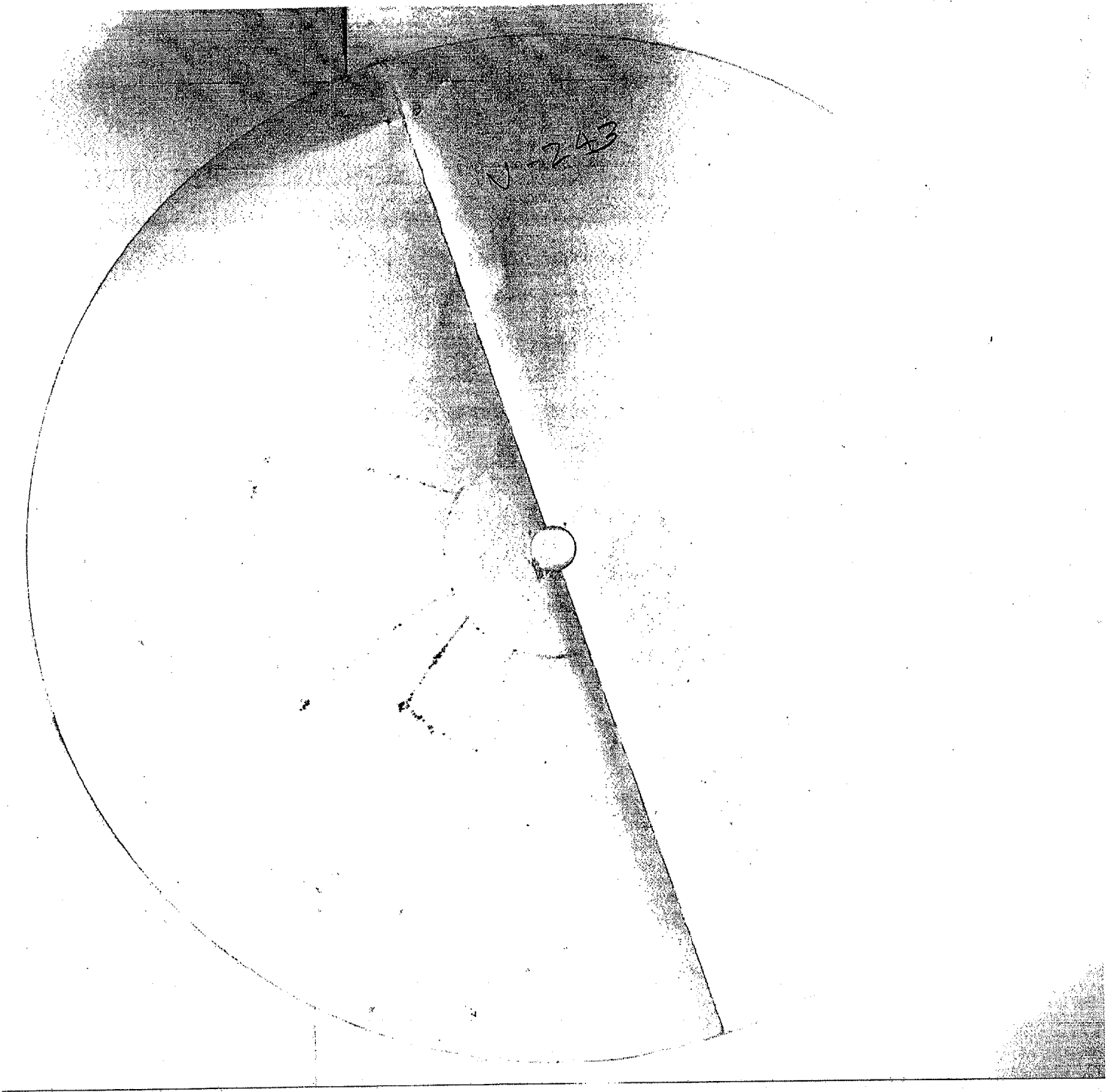
V-2213

INSTRUMENT	PAGE 2	CG-03	CODE	KY-787-D	EST. WGT	3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: PH 10.05 (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		SWITCH 3FC10 TO AUTO OPERATOR STEP PB								
	26	SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH								
		3FC20 TO REMOTE								
	27	OPERATOR STEP PB								
	28	DURING STRIKE, RECORD PH & TIME AS FOLLOWS:								
		SP STEP								
		V-243/V-241	PH	RANGE	TIME					
		13/46 (30 MIN)	9.9	9.0-10.0	6:30					
		14/47 (60 MIN)	9.9	9.0-10.0	7:00					
		15/48 (2 HRS)	9.9	9.0-10.0	8:00					
		16/49 (2 HRS 25 MIN)	9.9	9.0-10.0	8:25					
		17/50 (3 HRS FINAL)	7.7	7.5-8.5	9:00					
		NOTE: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG								
		IF FINAL PH IS ABOVE 8.5, ADJ 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								
	31	ADJ TO 49" (382 G) AT 80 - 100°F								
	32	STIR 5 MIN & RECORD PH 10.2 (9.5-10.5)								
	33	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26								
	34	RECORD VOL 49" & CALCULATE 49" (VOL) X 0.78 = 38.2 G								
	35	SET PRESET #8 TO 55 2 G 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	SIFT IN 2 BAGS								
SP	40	SP STEP 23/53 - RECORD PH 3.4 (3.7-4.2)								
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
CP	42	RECORD: PH 9.3 (9.0-9.5) & IF NECESSARY ADJ PH 9.0-9.5								
8		& RECORD: PH ASSUME 77% 27-D								
		(DILUTE 10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% 7-D								
		SIPHON N-7 INTO SV								
	43	OPERATOR STEP PB								
	44	SP STEP 29/58 RECORD: PH 9.25 (9.0-10.0) TIME 10:15 PM								
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE								
		START		FINISH						
		TIME	SP STEP	TIME	SP STEP	OPTR				
		5:30 P		11:00 P		235				
		7:00 P		2:00 PM		420				
		3:00 P		10:15 P		235				



N32461.01

DUP050461352



DUP050461353