SV 243, 244 Automated C.V. YC-3-B D.

CG 03 CODE KY-781-D PKG. _____

JAN 17 33867

EST. WGT. 818 LBS.

STD. HRS. _____ TIME 11P M

| PROCESSES | | APPROVED B |
|---|---|---|
| ( ) KY-781-D | (N) | FWP 10-13-78 |
| ( ) | ( ) | AMJ 10-13-78 |
| ( ) | ( ) | FWP 06-26-79 |
| ( ) | ( ) | |
| TYPED BY emw062879 | | |

14 YC-3-B 93 4 Lot 24420 , 2000#
14 YC-3-B 93 4 Lot 23879 , 850#
14 YC-3-B 93 4 Lot _____ , _____#
14 YC-3-B 93 4 Lot _____ , _____# 03 Ky 781D 28306 PO 88 600#

OK

Total Wgt 4268# (Req. 2850)

NON-BLEEDING

| EQUIPMENT | | NAME: KROLOR® YELLOW LIGHT | USE LBS. | N CODE | ACC LBS |
|---|---|---|---|---|---|
| 203 & 205 1 | 1 | Run 60" (992 G) water in V-203 & add Assume 50% | 30 | 7-D | 15 |
| | 2 | Weigh in drum & pour in | 382 | 32-D | 382 |
| | 3 | Dump in & stir 5 min Lot | 57 x 50 | YC-3-B | 2850 |
| | | Record: Start 3:30 pm | | | |
| | | Fin 4:45 pm 24420 | 2000 | | |
| | | 75" (1275 G) 2400-2600 23879 | 850 | | |
| | 4 | Adj to 80" (1360 G) & Record: pH (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 42" & adj to 45" (1662 G) | | | |
| | 8 | Inspect Homog strainer & clean if necessary | | | |
| 205 & SV 2 | 9 | Run 12" (200 G) water into SV & start agitator | | | |
| | 10 | Pump V-205 thru Homog at 4800-5200 psi into V-243 | | | |
| | | Record: Time Start 7:30 Total Min 155 | | | |
| | | 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 & pump thru Homog at 4800-5200 psi. | | | |
| SP & CP 3 | 12 | SP Step 01 — Set Formula Selector to position #1 (V-243) or #6 (V-244) | | | |
| | 13 | Press SV Cam Reset PB-Set 22TC in Auto Remote (Tempterature is set at 190-194°F) | | | |
| | 14 | Record levels & set Raw Material Counter #1 as follows: | | | |
| | | a) 11LG 30 % — preset #3 162 Gal | | 15-A | 324 |
| | 15 | Set strike flow controllers as follows: | | | |
| | | a) 3FC10 (N-27-D Controller) in Manual 0.78 GPM | | 27-D | 322 |
| | | b) 3FC20 (N-27-D Water) in Manual Local 5.44 GPM | | | |
| | | c) 3FR10 (N-27-D / Water Ratio) 0.7 | | | |
| | | d) 8FC10 (N-32-D Controller) in Manual 1.04 GPM | | 32-D | 2182 |
| | | e) 8FC20 (N-32-D Water) in Manual Local 4.66 GPM | | | |
| | | f) 8FC20 (N-32-D Water) in Remote | | | |
| | | g) 8FR10 (N-32-D / Water Ratio) 0.9 | | | |
| SV SP & CP 4 | 16 | Operator Step PB | | | |
| | 17 | Record Level 2LG 48 %. If below 35% follow solution make-up procedure for N-27-D | | | |
| | 18 | Adj 243 SV to 54" (2800 G) | | | |
| | 19 | Record: pH 10.6 | | | |
| | 20 | Adj pH to 11.4-11.6 using Assume 50% | 30 | 7-D | 15 |
| | | (Dilute to 5% (10 parts water to 1 part N-7-D)) | | | |
| | | Siphon into SV. Record: pH 11.4 | | | |
| | 21 | Operator Step PB | | | |

REV.

V-243

| EQUIPMENT | | PAGE 2 CG 03 CODE KY-781-D (N) EST. WGT. 4268 LBS. | USE LBS. | N CODE | AC LI |
|---|---|---|---|---|---|
| SV SP & CP 5 | 22 | SP Step 06/39 — After heat-up Record: pH 10.0 (9.6-10.2) | | | |
| | 23 | Switch 3FC20, 8FC10, 8FC20 to Auto | | | |
| | 24 | Operator Step PB | | | |
| | 25 | SP Step 10/43 — When 3FC20, 8FC10, 8FC20 water flow in limits switch 3FC10 to Auto. Operator Step PB | | | |
| | 26 | SP Step 11/44 — When 3FC10, 3FC20 flow in limits, switch 3FC20 to Remote. Opterator Step PB | | | |
| | 27 | During strike, Record pH & Time as follows: | | | |
| | | SP Step — pH — Range — Time | | | |
| | | 13/41 (30 min) — 9.8 — 9.3-10.0 — 2:00AM | | | |
| | | 14/47 (60 min) — 9.8 — 9.3-10.0 — 2:30 AM | | | |
| | | ( 2 hrs) — 9.8 — 9.3-10.0 — 3:30AM | | | |
| | | ( 3 hrs) — 9.7 — 9.3-10.0 — 4:30AM | | | |
| | | 17/50 ( Final) — 7.8 — 7.5- 8.5 — 5:15AM | | | |
| | | 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 | |
| ALM 6 | 28 | During strike clean #2 ALM magnetic separator & pump strainer | | | |
| | 29 | Install dust hood to #2 ALM & run in 2000# water | | | |
| | 30 | Dump in Lot 28326 | 600 | KY-781-D | 600 |
| | 31 | Stir 60 min. Add water as necessary to fluidize | | | |
| | 32 | When strike (S 27) complete, pump ALM thru box screen into SV-243 | | | |
| | 33 | Rinse in ALM & lines | | | |
| | 34 | Clean magnetic separator & strainer | | | |
| 302 7 | 35 | Add 31" (379 G) water to V-302 | | | |
| | 36 | Add & stir 5 min Assume 50% | 110 | 7-D | 55 |
| SV SP & CP 8 | 37 | SP Step 17/50 — After checking pH. Operator PB | | | |
| | 38 | SP Step 23/53 — Record: pH 2.5 (3.3-3.7) | | | |
| | 39 | If necessary adj pH (DOWN ONLY) Record: pH | | 15-A | |
| | | NOTE: Dissolve extra N-15-A in water at 110-120°F in drum Use ± 30 G of water to 50# N-15-A. Stir SV 5 min after each addition | | | |
| | 40 | Run in N-7-D from S 36 & stir 5 min | | | |
| | 41 | Record: pH 4.2 (4.2-4.4) | | | |
| | 42 | If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts $H_2O$ to 1 part N-7-D) or N-27-D M , % | | 27-D | |
| | | Assume 50% | | 7-D | |
| | | Siphon (if N-7-D) into SV. Record: pH | | | |
| | 43 | Operator Step PB | | | |
| | 44 | SP Step 24/54 — Add N-978-A & stir 15 min | 17 | 978-A | 17 |
| | 45 | Operator Step PB | | | |
| | 46 | SP Step 60 — Batch complete | | | |
| | 47 | PUMP V-243 TO V-240 | | | |

| START Time | START SP Step | FINISH Time | FINISH SP Step | OPTR |
|---|---|---|---|---|
| 5:00 PM | | 11:00 PM | | 201-27 |
| 11:00 PM | | 7:00 AM | | 244-37 |
| 7:00 AM | | 7:45 AM | | 235 |

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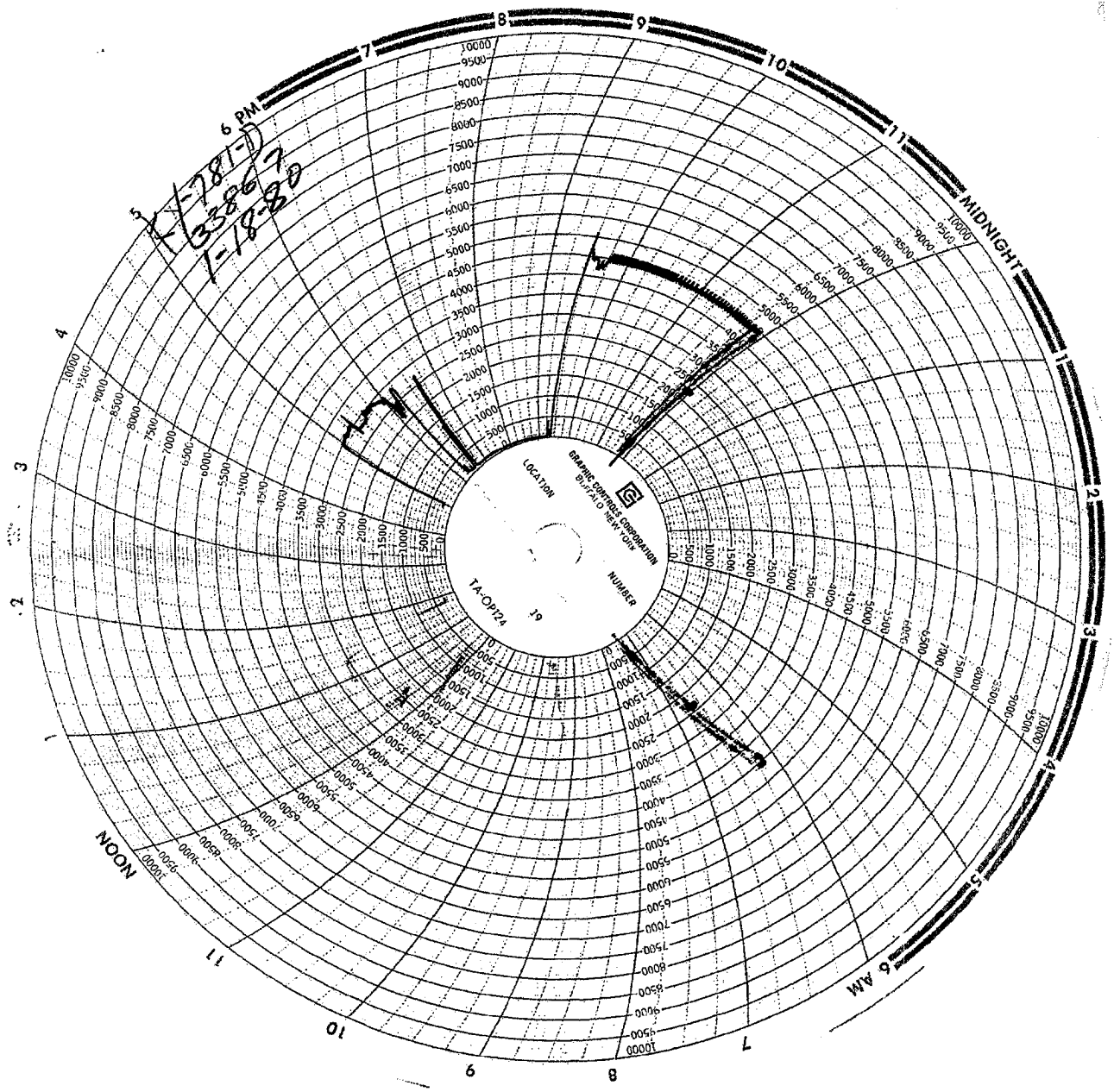


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V-243

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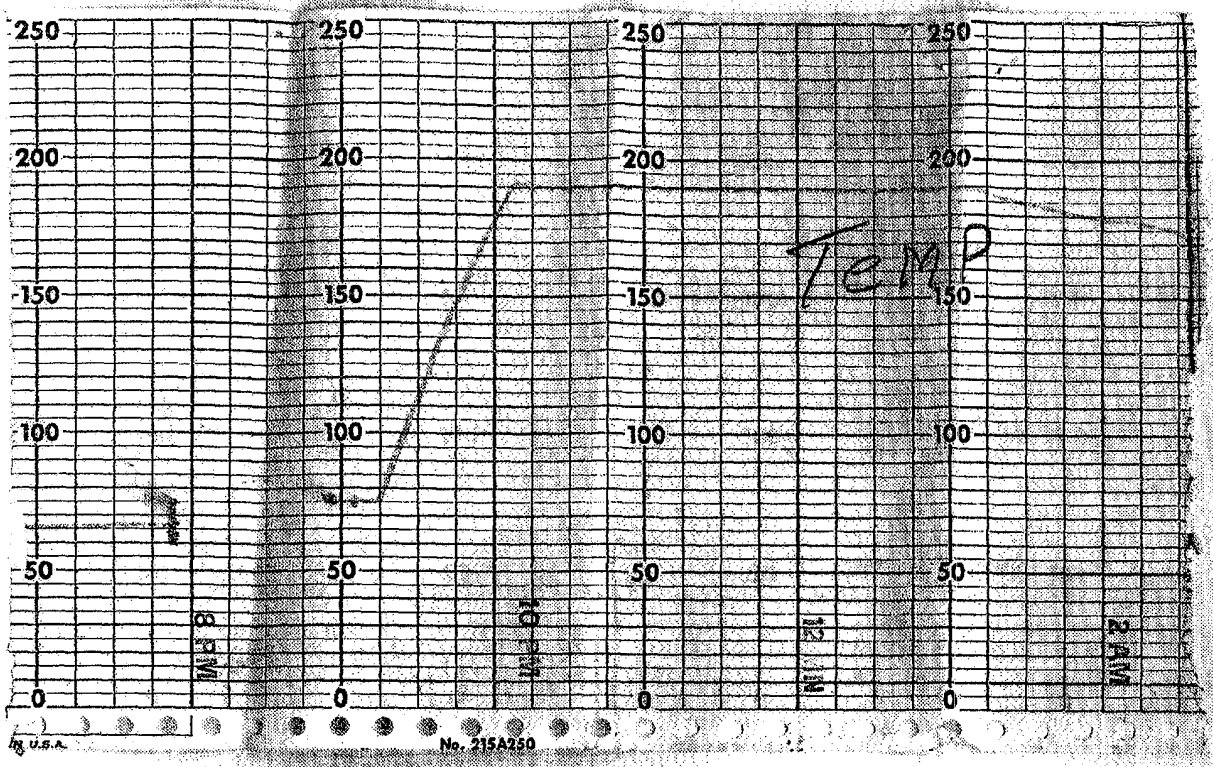


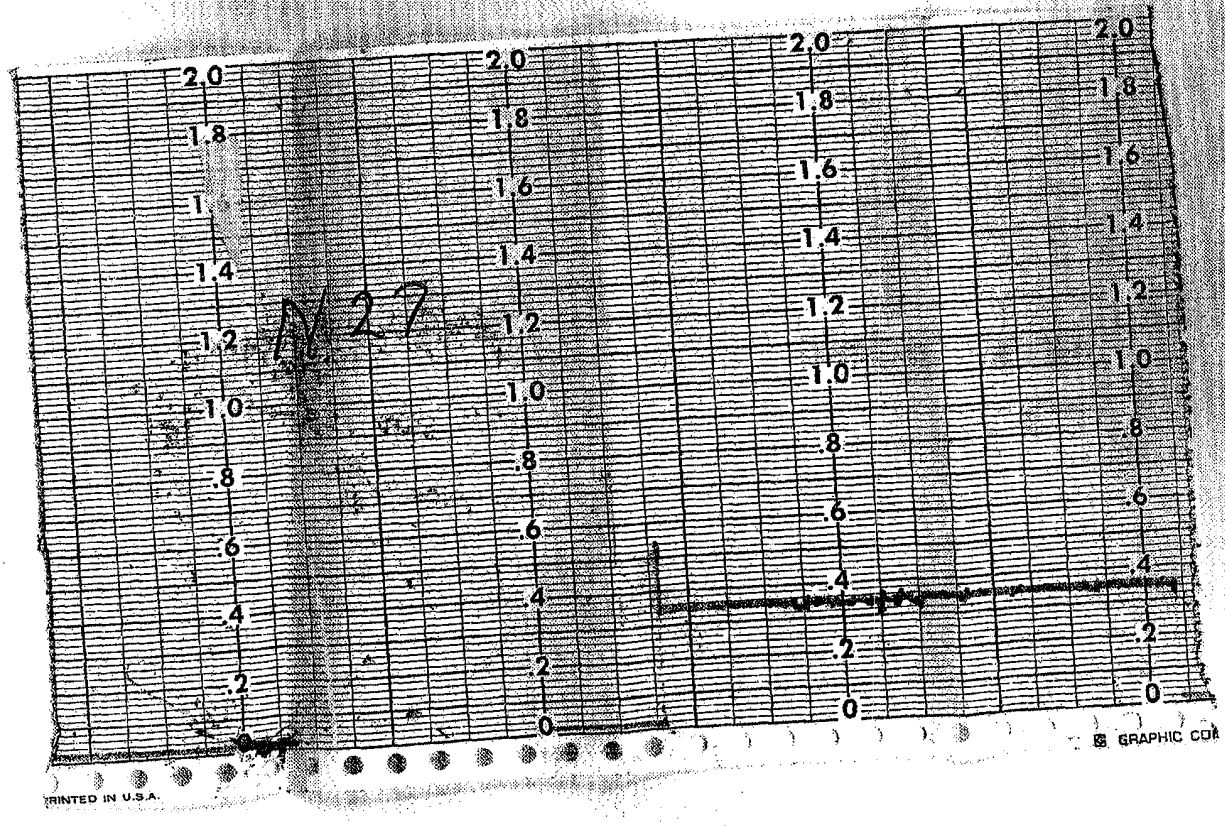


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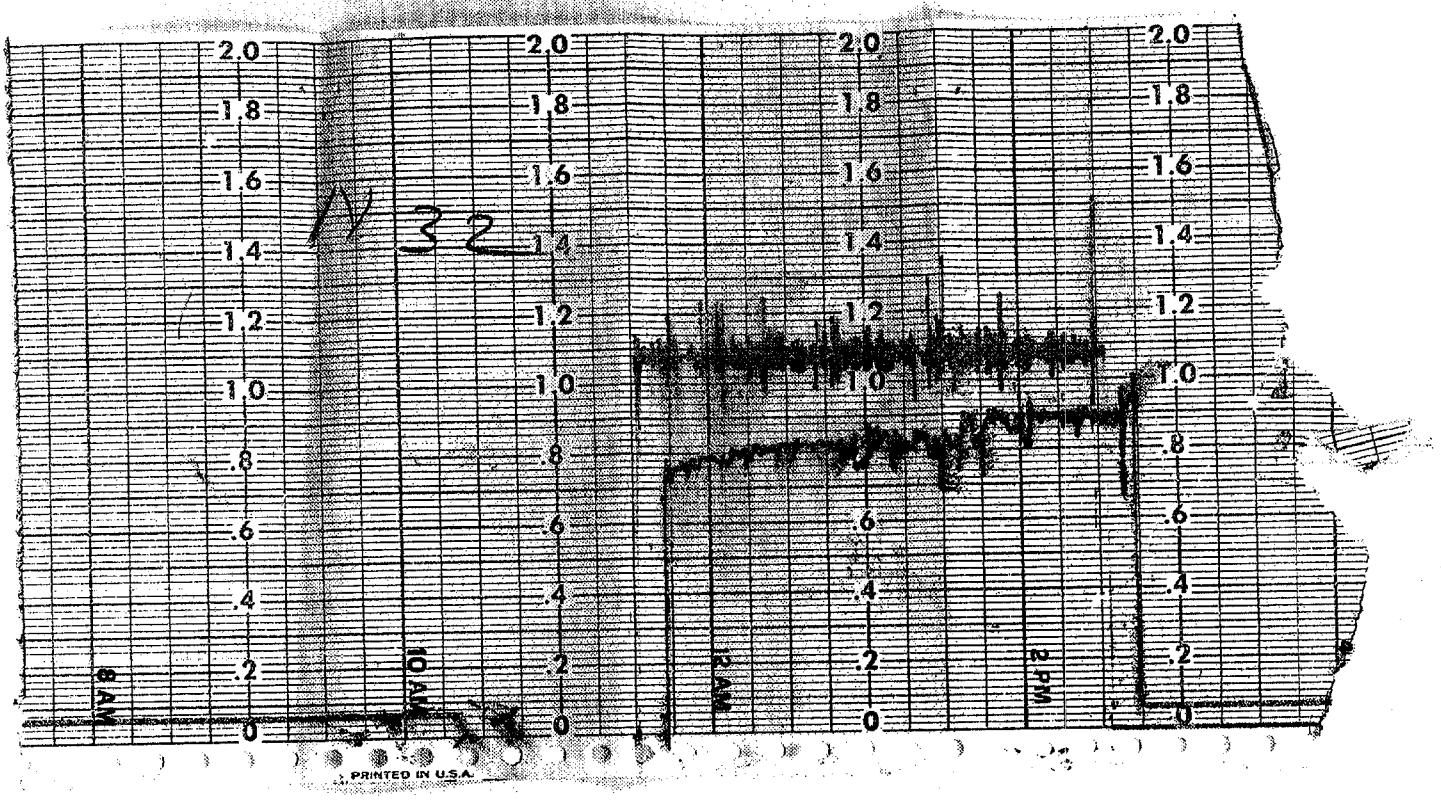


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