

243.244 (Automated)

C.V.

D.V.

CG 05

CODE KY-787-D

PKG.

JAN 16

33856

YC-2-B

EST. WGT.

1090

LBS.

STD. HRS.

8.9

TIME

3 P M

14 - YC-2-B 98 4

Lot 24170, 1800 #

Lot 24408, 600 #

Lot

Homog #4-2nd Pass

PROCESSES

APPROVED BY

() KY-787-D

() FWK 9/22/76

()

() DCG 9/27/76

()

() MTW 9/30/76

()

()

TYPED BY

N.E. 2/12/77

600# of YC-3 dumped into batch in error, 241.

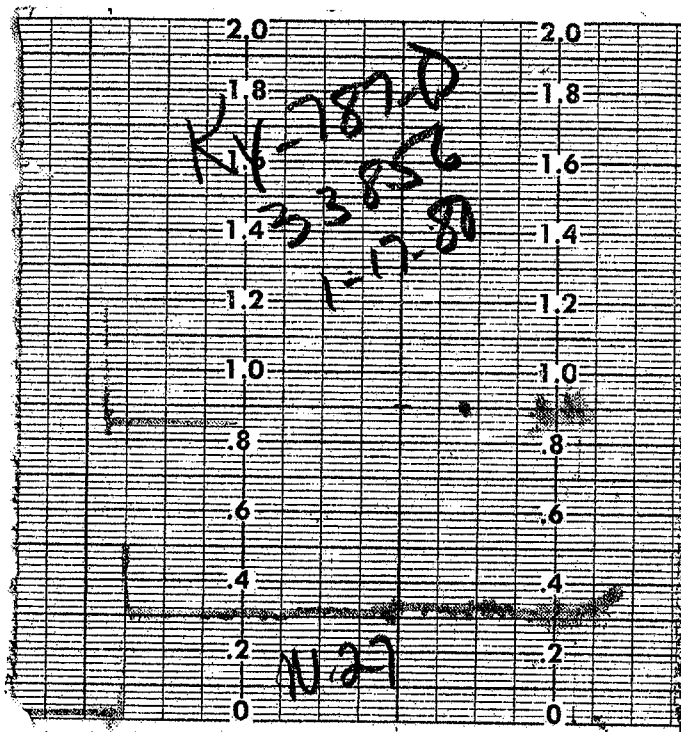
Total Wgt. - 3490#

NON-BLEEDING

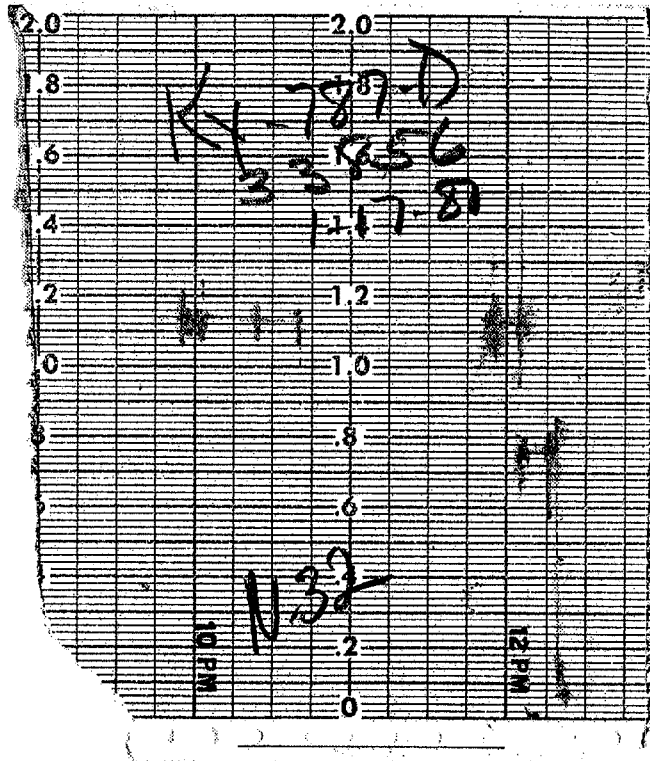
MENT	NAME:	USE LBS.	N CODE	ACCT, LBS.
03	"KROLOR" - YELLOW MEDIUM			
03	1 Run 60" (992 G) water into V-203			
&	2 Weigh in drum & pour in	320	32-D	320
05	3 Pump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start 3:30 PM	1812		
	Fin 4:30 PM	600		
	75" (1275 G)			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water			
	7 Record V-203 Vol " & adj to 60" (2100 G) 263			
	8 Inspect Homog strainer & clean if necessary			
03	9 Run 10" (514 G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-			
SV	Record: Time start 1:00 Total Min 1:15			
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	12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
&	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
CP	14 Record levels and set Raw Materials Counter #1 as follows:			
3	a. 11LG 66% - preset #1 80 Gal		15-A	160
	b. 13LG 64% - preset #6 135 Gal		20-A	135
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.83 GPM		27-D	275
	b. 3FC20 (N-27-D Water) in Manual Local 5.28 GPM			
	c. 3FR10 (N-27-D/Water Ratio) 0.64			
	d. 8FC10 (N-32-D Controller) in Manual 1.08 GPM		32-D	1840
	e. 8FC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water Ratio) 0.83			
SV	16 Operator Step PB			
SP	17 Record Level 2 LG 63%. If below 35% follow solution make-up procedure for N-27-D			
&	18 Adj to 48" (2470 G)			
CP	19 Record: pH 12.6			
4	20 Adj to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% (10 parts water to 1 part N-7-D) Siphon into SV. Record pH 11.25	24	7-D	12
	21 Operator Step PB			

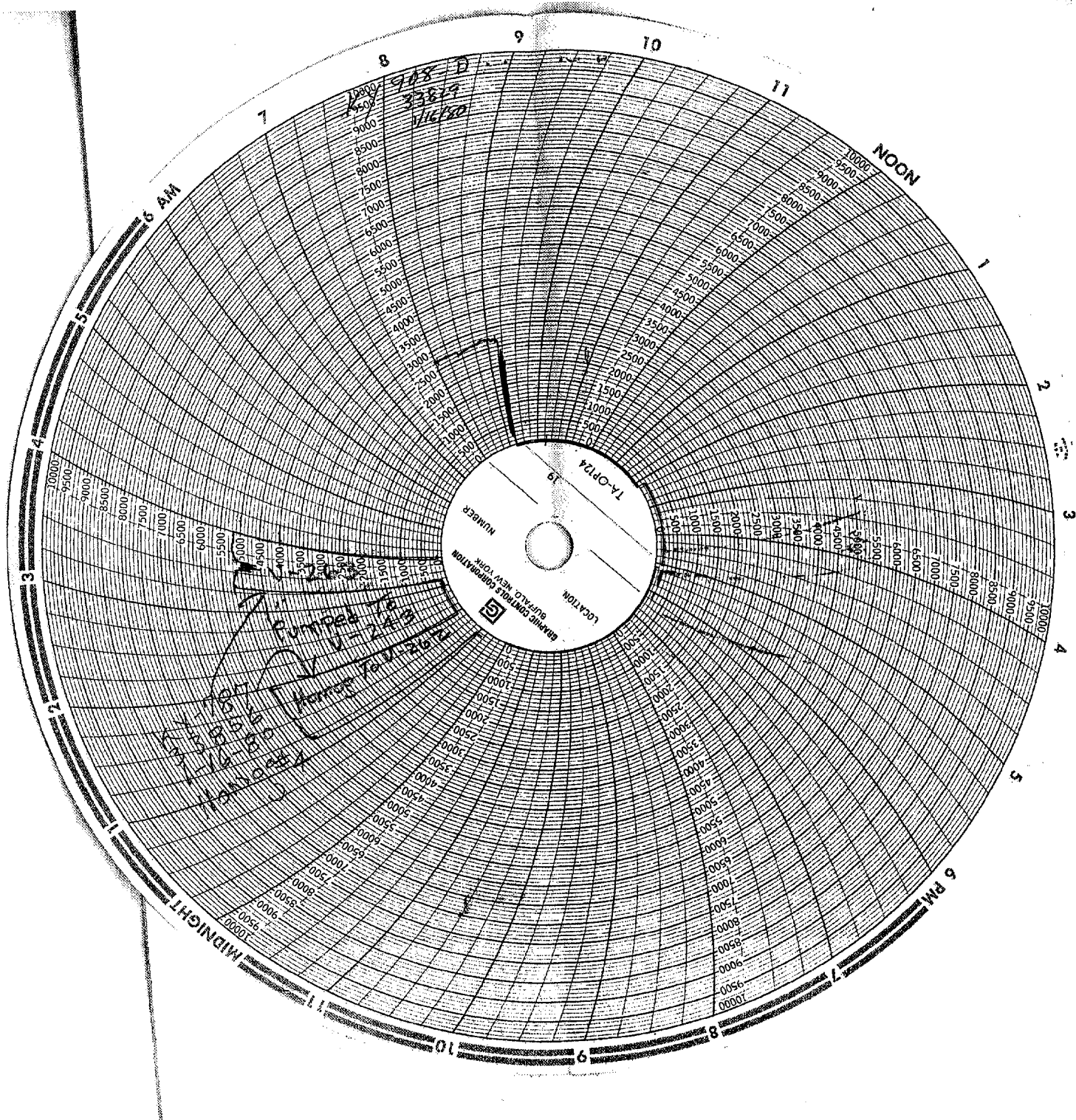
V-243

IPMENT	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 <u>10.1</u> (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-244	pH	Range	Time		
	13/46 (30 min)	<u>9.9</u>	9.0-10.0	<u>6:10</u>	INCREASED N-27	
	14/47 (60 min)	<u>10.0</u>	9.0-10.0	<u>6:40</u>	<u>0.82</u>	
	15/48 (2 hrs)	<u>9.9</u>	9.0-10.0	<u>7:40</u>		
	16/49 (2 hrs 25 min)	<u>9.9</u>	9.0-10.0	<u>8:05</u>		
	17/50 (3 hrs Final)	<u>6.8</u>	7.5-8.5	<u>8:40</u>		
	NOTE: If not as spec. 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	
39	29 While striking, run 30" (234 G) water into V-339					
6	30 Add in 7-8 min			350	530-A	350
	31 Adj to 49" (382 G) at 80 - 100°F					
	32 Stir 5 min & record pH <u>10.1</u> (9.5-10.5)					
	33 Stir 15 min or longer to dissolve for SP Step 26			<u>38.2</u>		
	34 Record Vol <u>4.9</u> & calculate Δ (Vol) x 0.78 = G					
	35 Set preset #8 to <u>38.2</u> G from S 34					
02	36 Add 30" (360 G) water to V-302					
7	37 Add & stir 2 min For S 41 Assume 50%			160	7-D	80
43	38 SP Step 17/50 - After checking pH, Operator Step PB					
	39 SIFT in 2 Bags			100	128-A	100
SP	40 SP Step 23/53 - Record: pH <u>4.0</u> (3.7-4.2)					
&	41 Run in N-7-D from S 37 in 10-12 min & stir 5 min					
CP	42 Record: pH <u>9.3</u> (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-D into SV					
	43 Operator Step PB					
	44 SP Step 29/58 Record: pH <u>9.2</u> (9.0-10.0) Time <u>9:50 A.M.</u>					
	45 Operator Step PB					
	46 SP Step 60 - Batch complete					
	Start Finish Optr					
	Time SP Step Time SP Step					
	<u>1:00 P</u> <u>7:00 A.M.</u>			<u>235</u>	<u>-259</u>	
	<u>1:00 A.M.</u> <u>9:50 A.M.</u>			<u>381.86</u>		



No. 2152





V-243

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE

LOT

PQ

1752

1

7-1

40

1806



72

00

1

100

52

648

7

74

STUMP

TOTAL NET WT.

PKG. N-CODE

PROD. SPVR.

DATE _____

WHSE. OPER.

WKL

114,80

DUP050093230