

S.V. 243 244 (Automated) C.V. _____
 CG 03 CODE KY-907-D PKG. _____
 → 00:3 33401
 EST. WGT. 1080 LBS.
 STD. HRS. _____ TIME 3 P^M

PROCESSES		APPROVED BY	
()	KY-907-D	(D)	EWK 12/12/77
()		()	DCG 12/13/77
()		()	MW 12/15/77
()		()	
TYPED BY			
rj 2/3/78			

14 YC-2-B 93 4 Lot 24075, 40D#
 14 YC-2-B 93 4 Lot 24169, 2080#
 14 YC-2-B 93 4 Lot _____, _____#

CR
H

Homog #4 - 1st Pass

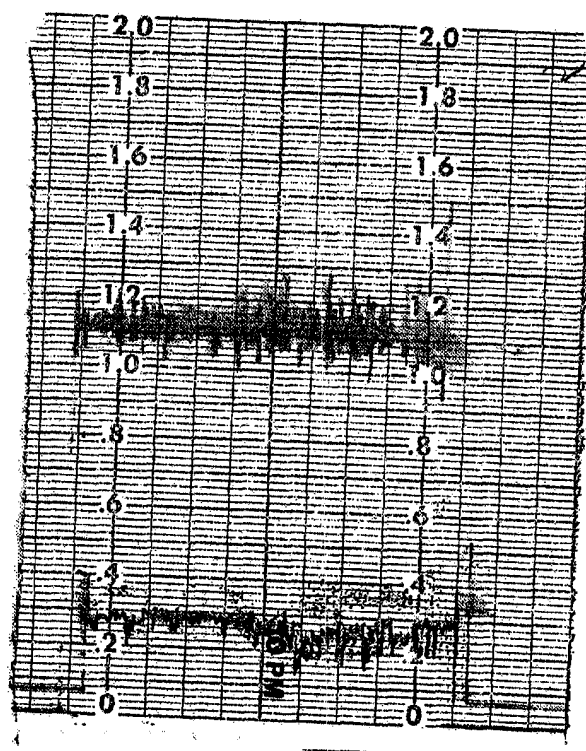
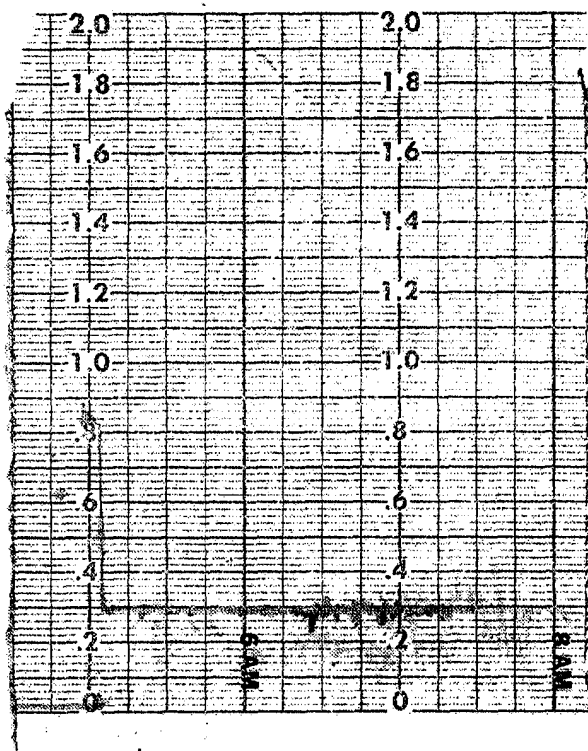
Total Weight - 3480#

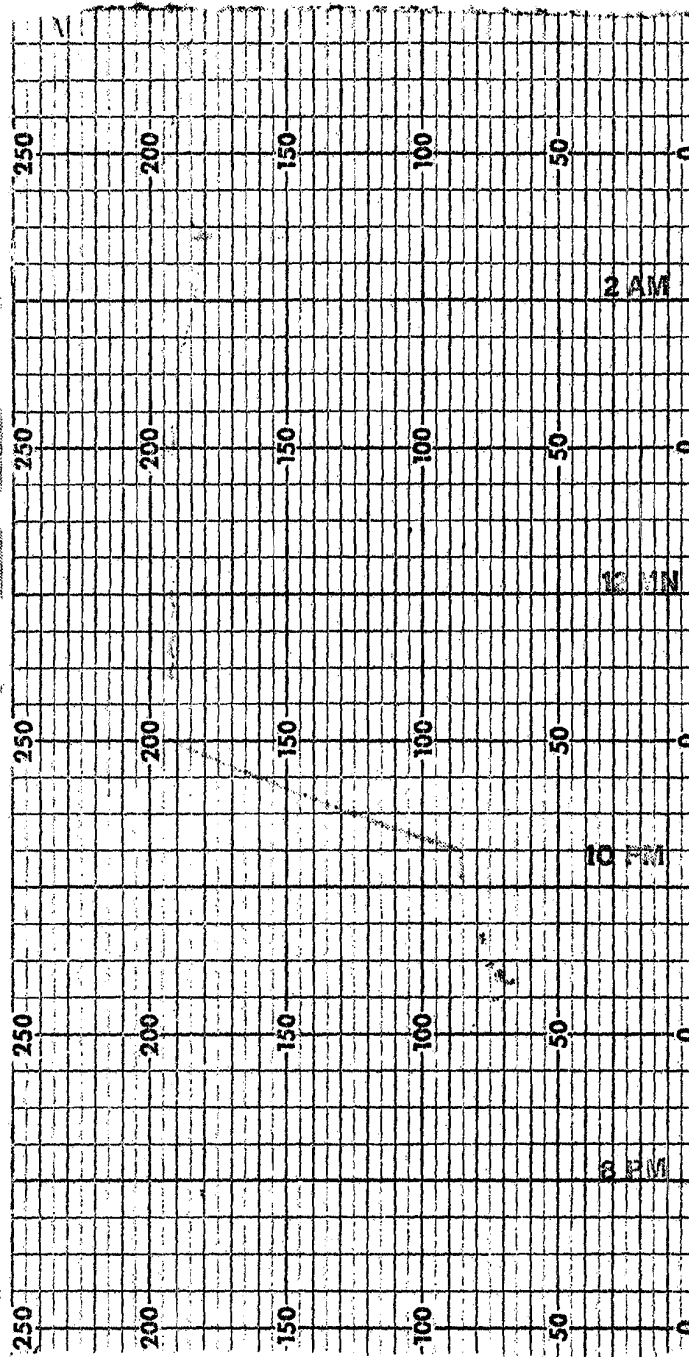
NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	60" (990 G) KROLOR® YELLOW MEDIUM			
&	1 Run 22" (560 G) water into V-203			
205	2 Pour in	320	32-D	320
263	3 Dump in	48 x 50	YC-2-B	2400
75" (1360 G)	Record: Start <u>9:30 PM</u> Lot <u>24075</u>	<u>400</u>		
	Fin <u>10:30 PM</u> <u>24169</u>	<u>3080</u>		
	4 Adj to 70" (1200 G) <u>2400-2600</u>			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 <u>263</u>			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water <u>263</u>			
	7 Record V-205 Vol <u>37</u> " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514 G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
2632	Record: Time Start <u>7:55 AM</u> Total Min <u>120</u>			
	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			
CP	(Temperature is set at 190-194 F)			
3	14 Record levels and set Raw Materials Counter #1 as follows: 11LG 3.3 % - preset #1 80 Gal		15-A	160
	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. 8FR20 (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 8.5 %. If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj to 48" (2470 G)			
4	19 Record: pH <u>10.5</u>			
	20 Adj to 11.1-11.3 using N-7-D diluted to 5% Assume 50%	<u>34</u>	7-D	<u>17</u>
	(10 parts water to 1 part N-7-D)			
	Siphon into SV Record: pH <u>11.3</u>			
	21 Operator Step PB			

EQUIPMENT	PAGE	2 CG 03 CODE KY-907-D (D)	EST. WGT.	3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV SP & CP 5	22	SP Step 06/39 - After heat up Record:	pH 10.1 (9.5-10.0)				
	23	Switch 3FC20, 8FC10, 8FC20 to Auto					
	24	Operator Step PB					
	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits					
	26	Switch 3FC10 to Auto. Operator Step PB					
	27	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch					
	28	3FC20 to Remote					
	29	Operator Step PB					
	30	During strike, Record pH & time as follows:	12:03 PM				
	31	SP Step					
	32	V-243/V-244	pH Range Time				
	33	13/46 (30 min)	9.9 9.0-10.0 12:33 PM				
	34	14/47 (60 min)	9.9 9.0-10.0 1:03 PM				
	35	15/48 (2 hrs)	9.9 9.0-10.0 2:03 PM				
	36	16/49 (2 hrs 25 min)	9.9 9.0-10.0 2:28 PM				
	37	17/50 (3 hrs Final)	8.4 7.5-8.5 3:03 PM				
	38	NOTE: (1) If pH not as specified notify Supervisor & note					
	39	in log (2) If final pH is above 8.5, adj pH to 7.5-8.5 &					
	40	Record: pH Assume 78%					
	41	Sift in		50	27-D	128-A	50
302 3176	42	Add 17" (208 G) water to V-302					
	43	Add & stir 2 min for S58	Assume 50%	100	7-D		50
PT 7	44	During strike pump into PT		318		169-A	318
	45	Pump in		36		155-A	36
	46	Pump in		36		160-A	36
	47	Stir 10 min with lightning mixer for S39					
356 8	48	During strike run 14" (244 G) water into V-356					
	49	Turn on steam					
	50	Adj to 267°F (317 G) at 178-182°F 81-82°C					
	51	Pump PT mixture from S35 thru undersurface					
	52	Distributor AFAP					
	53	Rinse PT with hot water from hot water mixer & pump in					
	54	Shut off pump 81-82°C					
	55	Stir 30 min at 178-182°F for S49					
	56	Do not shut off agitator					
SV & SP 9	57	When S29 complete, heat SV to 198-200°F in 5-10 min					
	58	Close water line & discharge valves at stearate pump					
	59	Open V-356 Discharge valves to stearate pump inlet					
	60	Open water valve at stearate pump & run water thru					
	61	Homog at 2900-3100 psi to sewer					
	62	While Homog water at 2900-3100 psi, open Homog					
	63	Discharge valve to SV & close valve to sewer					
	64	Immediately open stearate pump discharge valve,					
	65	Turn on pump & Homog V-356 to SV at 2900-3100 psi					
	66	Maintain SV at 198-200°F					
	67	While Homog V-356 to SV, shut off water valve at					
	68	Stearate pump ASAP					
	69	When Homog complete, rinse in V-356 with hot water					
	70	From hot water mixer					

EQUIPMENT	PAGE 3 CG 03 CODE KY-907-D (D) EST. WGT.	3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV & SP	52 When S51 complete turn off Homog & stearate pump				
	52 Stir 5 min at 198-200°F				
	54 Shut off steam				
9 Con't	56 When S54 complete, Operator PB				
	56 SP Step 23/53 Record pH 3.5 (3.3-3.7)				
	57 If necessary adj pH to (3.3-3.7) (DOWN ONLY) Record: pH			15-A	
	NOTE: Dissolve extra N-15-A in water at 110-120°F in drum				
	Use + 30 gal of water to 50# N-15-A. Stir SV 5 min after each addition				
	58 Run in N-7-D from S31 in 10-12 min & stir 5 min				
	59 Record: pH 10.3 (4.2-4.4) & if necessary adj pH 4.2-4.4				
	& Record: pH 4.4 Assume 50%			7-D	
	(Dilute 10 parts water to 1 part N-7-D) Assume 78%		30	27-D	
	Siphon N-7-D into SV				
	60 Operator Step PB				
	61 Operator Step PB				
	62 SP Step 60 - Batch complete				
<i>Rump V243 to V240</i>					
START		FINISH		OPTR	
Time	SP Step	Time	SP Step		
11:00 AM		7:00 AM		235-301	
7:00 AM		3:00 PM		409	
3:00 PM		7:15 PM		201-27	





No. 215A350

U.S.A.

