

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

V 243,244 (AUTOMATED) CV APR 3 1980
 CG 03 CODE KY-787-D PKG _____
 → MAK 31 35182
 EST WGT 1090 LBS
 STD HRS 8.9 TIME 3P M
 14 YC-2-B 93 4 LOT 24464, 2000 #
 LOT 24463, 400 #
 LOT _____, _____ #

D V
 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
 Homolog #4 - 1st Pass

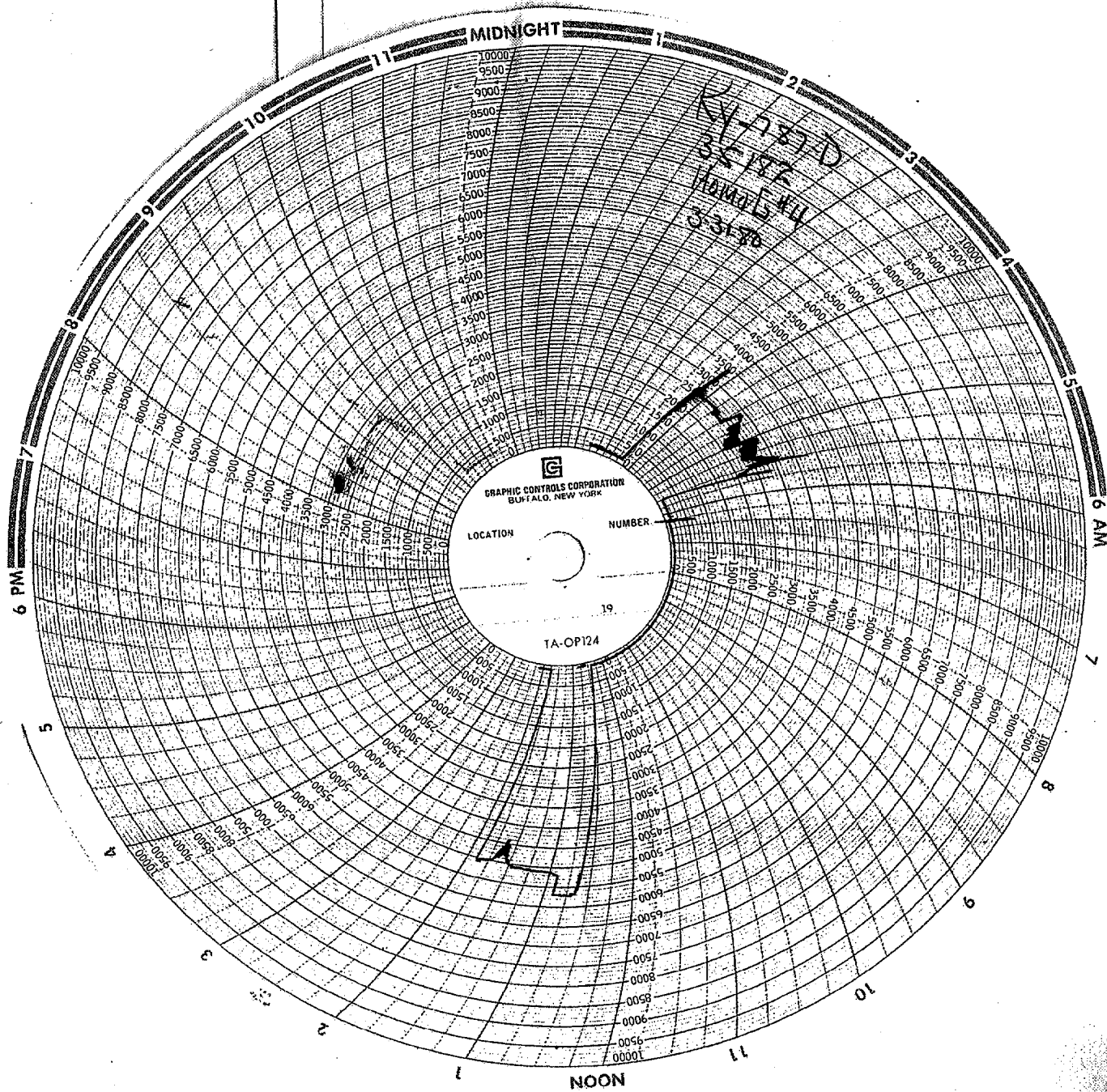
TOTAL WGT 3490#

NON-BLEEDING

SHIPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 1	1 RUN 60" (992 G) WATER INTO V-203, SET AGITATOR ON HIGH SPEED			
	2 WEIGH TN DRUM & POUR IN	320	32-D	320
	3 DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
	RECORD: START <u>24464</u>	<u>2000</u>		
	FIN <u>24463</u>	<u>400</u>		
	4 ADJ TO 75" (2256)			
	5 ADJ TO 70" (1200 G) <u>2400-2600</u>			
	6 PUMP V-203 THRU HOMOG #3 AT 1800-2200 PSI INTO V-203			
	7 WHEN V-203 MTY, WASH COLOR THRU HOMOG AT 1800-2000 PSI USING MINIMUM WATER			
	8 RECORD V-205 VOL <u>✓</u> " & ADJ TO 60" (2100 G)			
	9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	10 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
	11 RUN 10" (514 G) WATER INTO SV. START AGITATOR			
	12 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-205			
	RECORD: TIME START <u>18:50</u> TOTAL MIN <u>11:00</u>			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	13 WHEN V-205 MTY, RUN IN 5" (240 G) WATER AND PUMP THRU HOMOG AT 4800-5200 PSI			
SP & CP 3	14 SP STEP 01 - SET FORMULA SELECTOR TO POSITION #2 (V-243) OR #7 (V-244)			
	15 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
	16 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 61% - PRESET #1 80 GAL		15-A	160
	B. 13LG 84% - PRESET #6 135 GAL		20-A	135
	17 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	A. 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM		27	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. 8FR10 (N-32-D/WATER RATIO) 0.83			
SV SP & CP 4	18 OPERATOR STEP PB			
	19 RECORD LEVEL 2 LG 65% IF BELOW 35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
	20 ADJ TO 48" (2470 G)			
	21 RECORD: pH <u>10.2</u>			
	22 ADJ TO 11.1 - 11.3 USING N-7-D DILUTED TO 5% ASSUME 50% (10 PARTS WATER TO 1 PART N-7-D)			
	23 SIPHON INTO SV. RECORD pH <u>11.25</u>			
	24 OPERATOR STEP PB			

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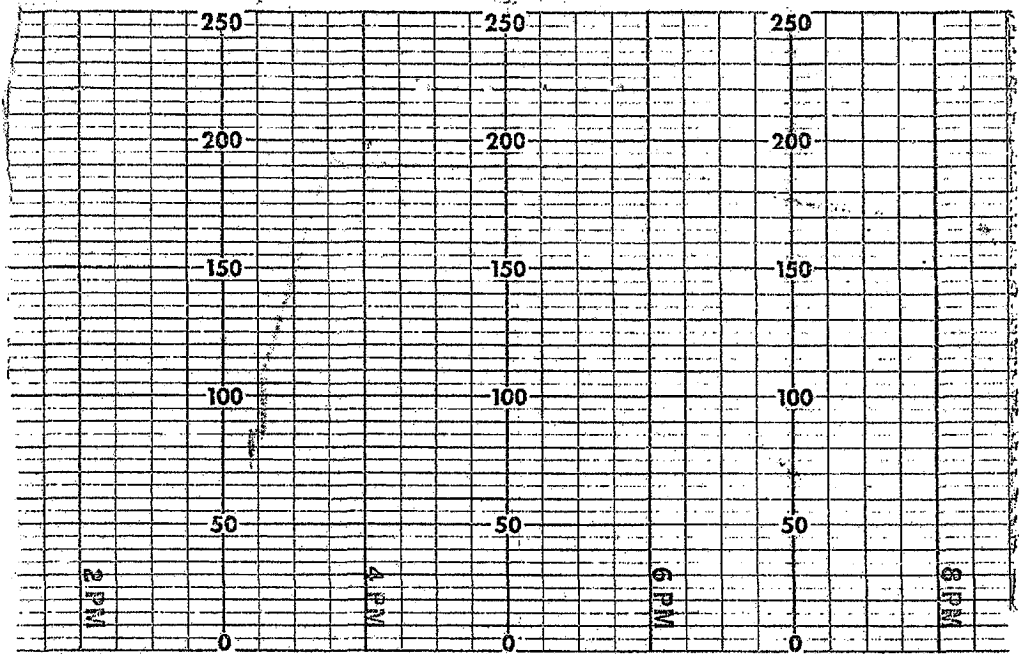
EQUIPMENT	PAGE 2	CG 03	CODE	KY-787-D	EST. WGT.	3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH 10.0 (9.5-10.0)								
SP	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO								
&	24	OPERATOR STEP PB								
CP	25	SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS								
5	25	SWITCH 3FC10 TO AUTO OPERATOR STEP PB								
	26	SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH								
	27	3FC20 TO REMOTE								
	27	OPERATOR STEP PB								
	28	DURING STRIKE, RECORD pH & TIME AS FOLLOWS: 4.00 PM								
		SP STEP								
		V-243/V-244	pH	RANGE	TIME					
		13/46 (30 MIN)	9.8	9.0-10.0	4:30 PM					
		14/47 (60 MIN)	9.8	9.0-10.0	5:00					
		15/48 (2 HRS)	9.8	9.0-10.0	6:00					
		16/49 (2 HRS 25 MIN)	9.8	9.0-10.0	6:25					
		17/50 (3 HRS FINAL)	7.0	7.5-8.5	7:00 PM					
		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 10.1 (9.5-10.5)								
	33	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26								
	34	RECORD VOL 49" & CALCULATE 38.2" (VOL) X 0.78 = 38.2 G								
	35	SET PRESET #8 TO 38.2 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 100 128-A 100								
SP	40	SP STEP 23/53 - RECORD pH 3.5 (3.7-4.2)								
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
CP	42	RECORD: pH 9.0 (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 9.0 (9.0-10.0) TIME 9:30 PM								
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE								
		START		FINISH						
		TIME	SP STEP	TIME	SP STEP	OPTR				
		7:00 PM		9:00 PM		120-27				
						237-320				



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