

(243,244 (Automated)

C.V. PUNCHED & CHECKED

D.V.

CO 03 CODE KY-787-D

PKS.

PROCESSES

APPROVED BY

MAR-1 34540

MAR 4 1980

OK

EST. WGT. 1090 990 LBS.

STD. HRS. 8.9 TIME 11 P M

() KY-787-D () FWK 9/22/76

() () DCG 9/27/76

() () MTW 9/30/76

() ()

TYPED BY

N.E. 2/12/77

14 - YC-2-B 98 4 Lot 24480, 2000 #

Lot

Lot 24066, 400 #

Homog #4-1st Pass

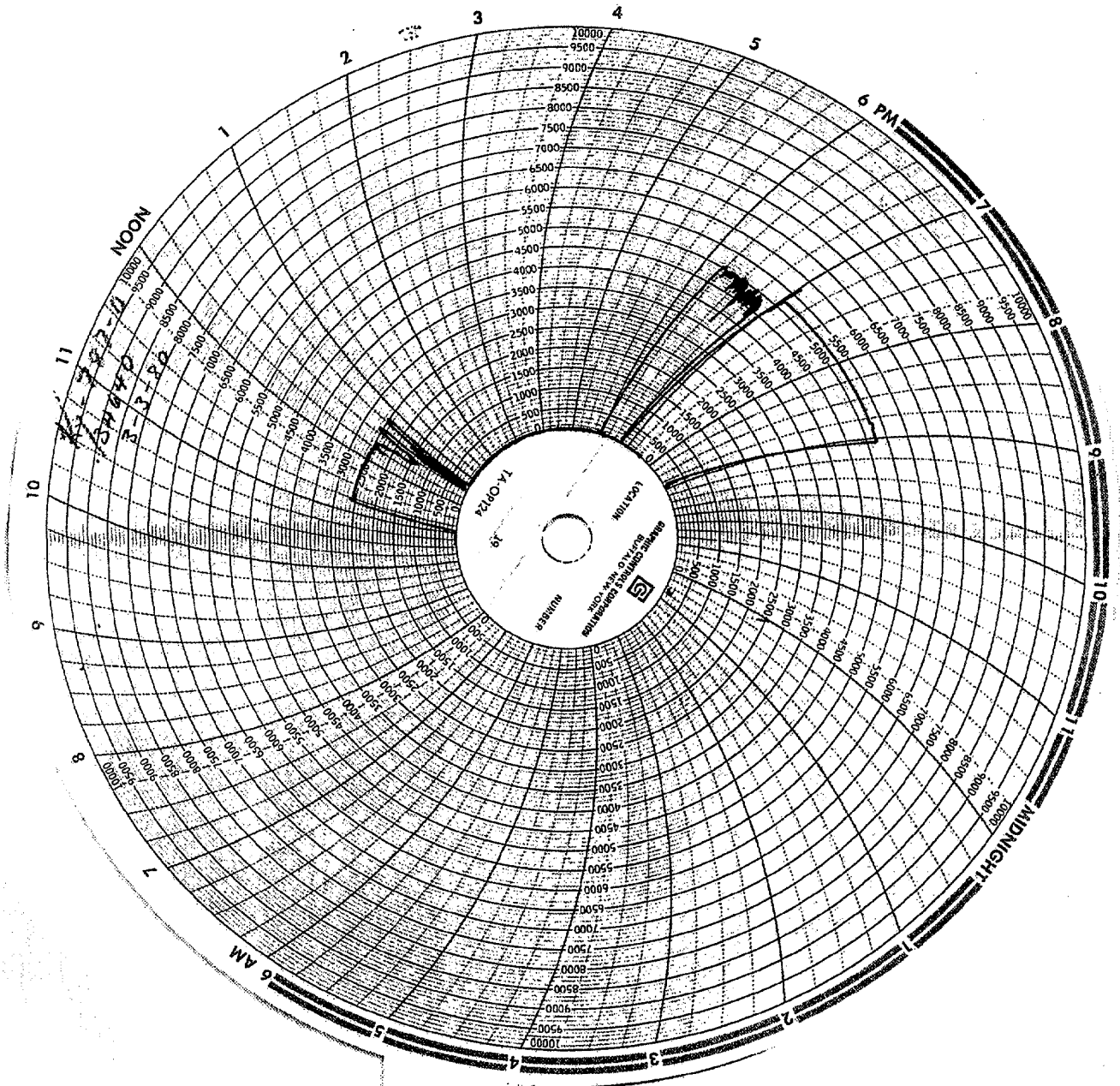
Total Wgt. - 3490# 3390

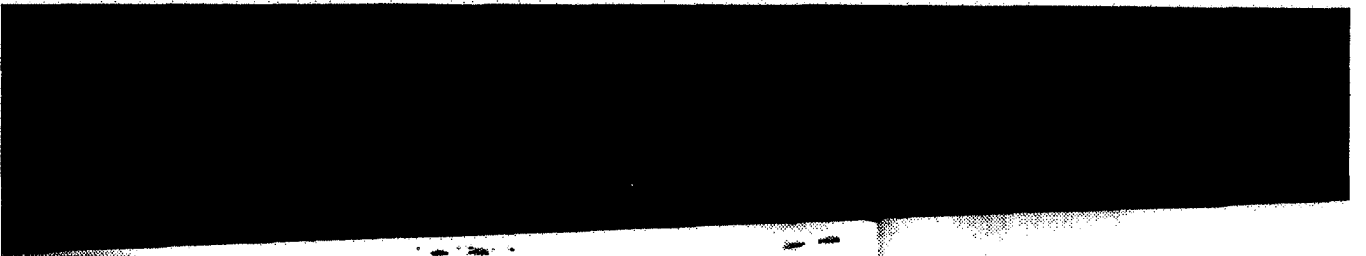
HOT-N-32-D

NON-BLEEDING

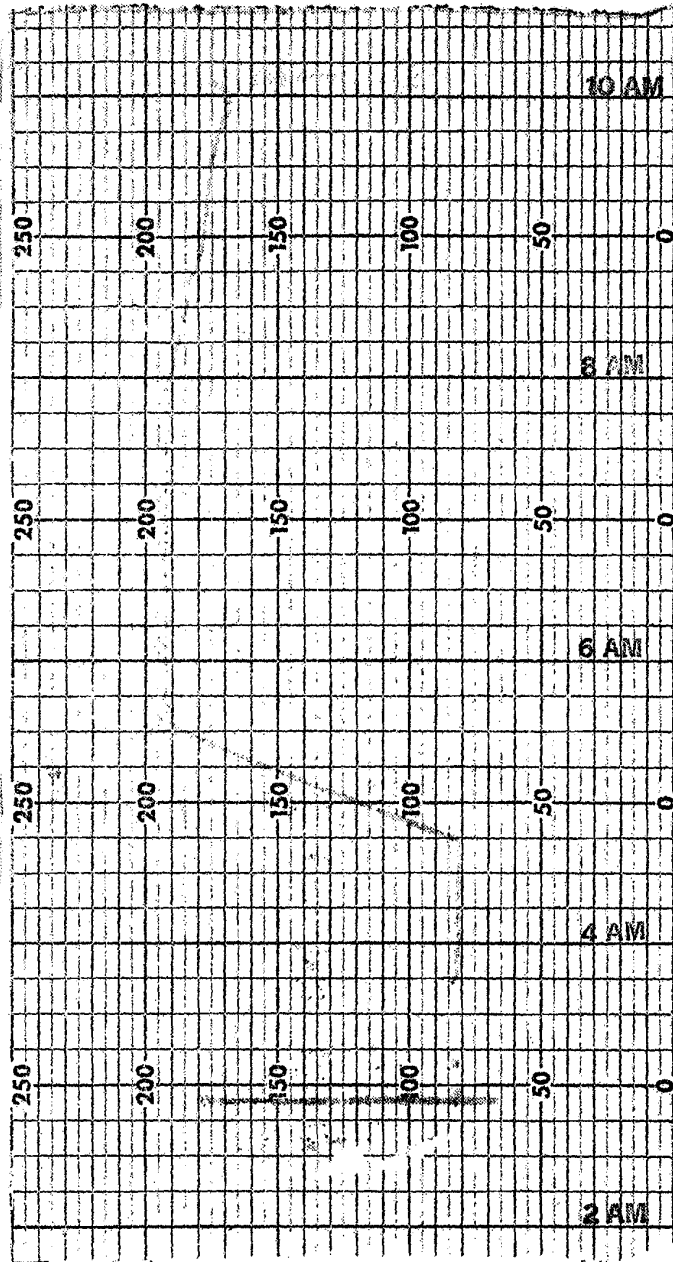
PMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205	"KROLOR" - YELLOW MEDIUM			
1	1 Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED			
	2 Weigh in drum & pour in	320	32-D	320
	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 3-2-80	2000		
	Fin 9:39 AM. 3-3-80	400		
	75" (2756)			
	4 Adj to 78" (1200 G)	2400-2600		
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205	263		
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water	263		
	7 Record V-205 Vol			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205	9 Run 10" (514G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-203	263		
	Record: Time start 10:15 Total Min 170			
	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)			
& CP	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11.6% - preset #1 80 Gal	15-A	160	
	b. 13.0% - preset #6 135 Gal	20-A	135	
	15 Set strike flow controllers as follows:			
	a. 3FC18 (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 68%. If below 55% follow solution make-up procedure for N-27-D			
2	18 Adj to 48" (2470 G)			
& CP	19 Record pH			
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)	22	7-D	11
	Siphon into SV. Record pH			
	21 Operator Step PB			

JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACC LBS.
SV	20	SP Step 06/39 - After heat up Record: pH <u>9.9</u> (9.5-10.0)						
SP	21	Switch 3FC20, 8FC10, 8FC20 to Auto						
8	22	Operator Step PB						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
5	26	Switch 3FC10 to Auto. Operator Step PB						
	27	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>9.75</u>	9.0-10.0	<u>2:50 P</u>			
		14/47 (60 min)	<u>9.7</u>	9.0-10.0	<u>3:20 P</u>			
		15/48 (2 hrs)	<u>9.7</u>	9.0-10.0	<u>4:20 P</u>			
		16/49 (2 hrs 25 min)	<u>9.7</u>	9.0-10.0	<u>4:45 P</u>			
		17/50 (3 hrs Final)	<u>9.9</u>	7.5-8.5	<u>5:20 P</u>			
		NOTE: If not as specified notify Supervisor & note in log						
		If final pH is Above 8.5, add 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				350	530-A	350
	31	Add to 49" (382 G) at 80 - 100°F						
	32	Stir 5 min & record pH <u>9.8</u> (9.5-10.5)						
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol <u>5.1</u> & calculate <u>5.1</u> (Vol) x 0.78 = <u>3.98</u>						
	35	Set preset #8 to <u>37.8</u> 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 <u>3.4</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>9.5</u> (9.0-9.5) & if necessary add pH 9.0-9.5						
8		& Record: pH <u>9.4</u> Assume 77%					27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%				20	7-D	10
		Siphon N-7-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.3</u> (9.0-10.0) Time						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time SP Step	Time SP Step					
		<u>11:00 PM</u>	<u>11:00 AM</u>	<u>128-901</u>				
		<u>11:00 PM</u>	<u>11:00 PM</u>	<u>27-126</u>				
		<u>11:00 PM</u>	<u>11:00 PM</u>	<u>27-126</u>				

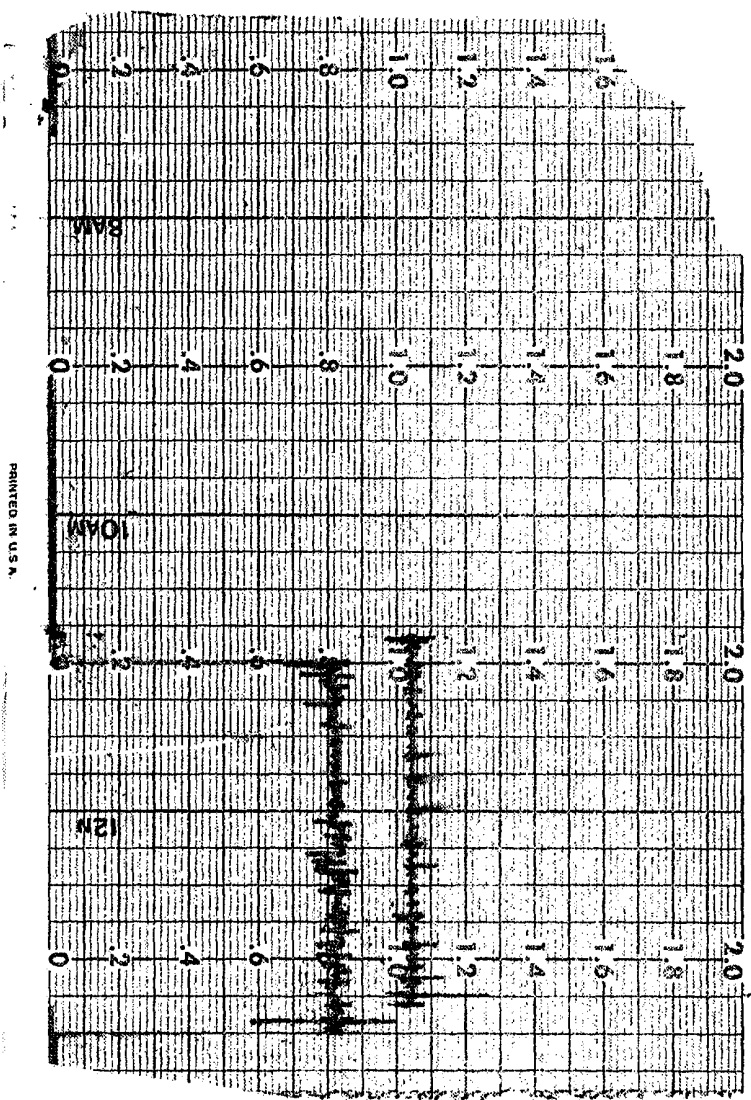


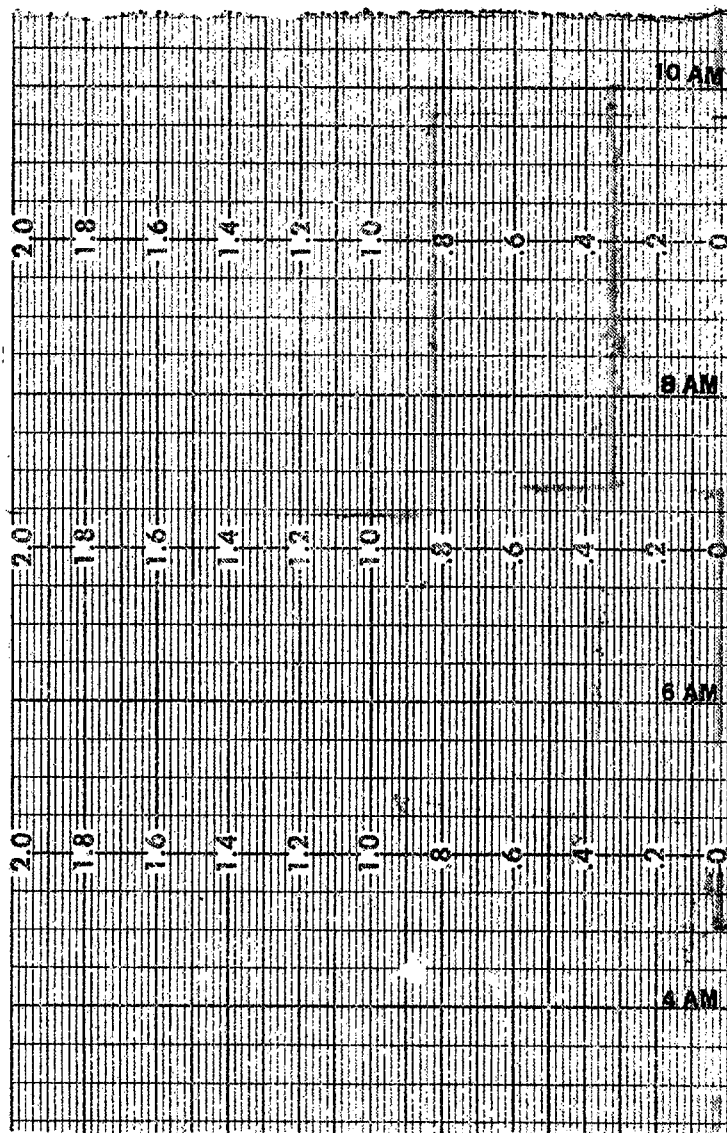


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No. 215A164

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