

PUNCHES 2

JUN 1 1983

MAKING INSTRUCTIONS: BATCH UNIT

SV	CG 03	CODE KY-787-D	PKG	CV	DV
	243	244 (AUTOMATED)			
	JUN 10	36067			
	EST WGT	1090	LBS		
	STD. HRS	8.9	TIME	3 P.M.	
	14	YC-2-B	93	4	
	LOT	24786		2400	
	LOT				
	LOT				

OK
H
Hornoo #4 - 1st Pass
11 44 - 2nd "

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			

TOTAL WGT 3490#

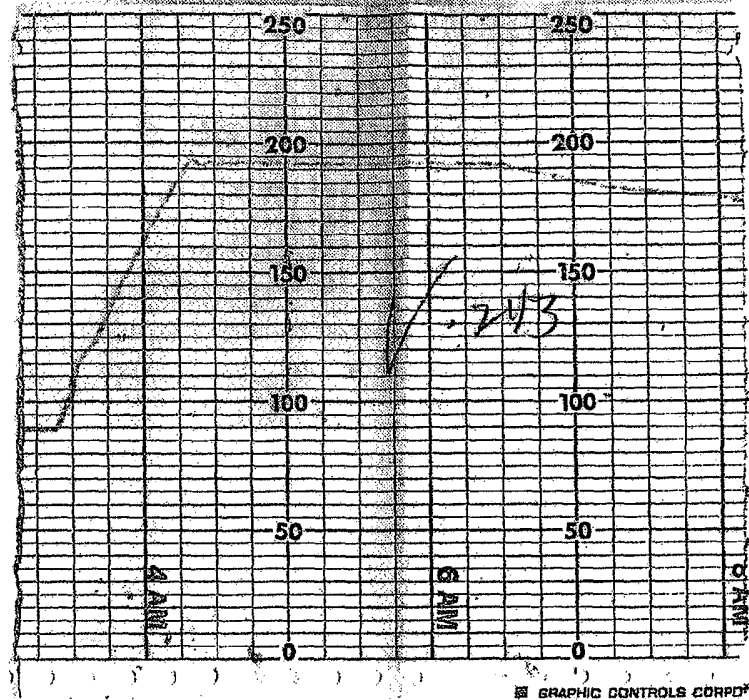
NON-BLEEDING

QUIPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205	1 RUN 60" (992 G) WATER INTO V-203. SET AGITATOR ON HIGH SPEED.			
1	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 8:20 P.M.	24786		
	FIN 9:30 A.M.	2400		
	75" (1275 G)			
	4 ADJ TO 70" (1200 G)			
	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-205 VOL 40 " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	9 DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED			
205 & SV	10 RUN 10" (514 G) WATER INTO SV START AGITATOR			
2	11 PUMP V-205 THRU HOMOG AT 4000-5200 PSI INTO V-243			
	RECORD: TIME START 11:01 A.M. TOTAL MIN 140			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	12 WHEN V-205 MTY, RUN IN 5" (240 G) WATER AND PUMP THRU HOMOG AT 4800-5200 PSI			
SP & CP	13 SP STEP 01 - SET FORMULA SELECTOR TO POSITION #2 (V-243) OR #1 (V-244)			
3	14 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
	15 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 59 % - PRESET #1	80 GAL	15-A	160
	B. 13LG 64 % - PRESET #6	135 GAL	20-A	135
	16 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. 3ER10 (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. 8ER10 (N-32-D/WATER RATIO):	0.83		
SV	17 OPERATOR STEP PB			
SP	18 RECORD LEVEL 2 LG 87 % IF BELOW 35% FOLLOW SOLUTION			
& CP	19 MAKE-UP PROCEDURE FOR N-27-D			
4	20 ADJ TO 48" (2470 G)			
	21 RECORD: pH 10.5			
	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)	20	7-D	10
	23 SIPHON INTO SV. RECORD pH 11.1			
	24 OPERATOR STEP PB			

N32210

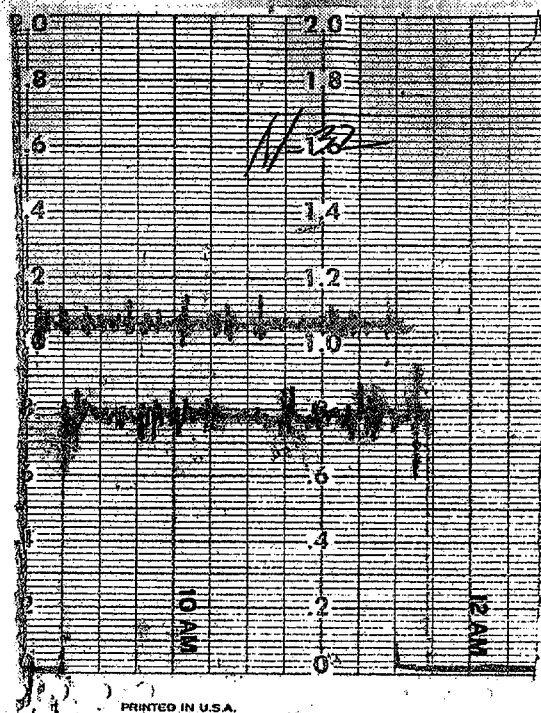
U-243

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	9.9	(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					
		13/46 (30 MIN)	9.7		9.0-10.0					
		14/47 (60 MIN)	9.75		9.0-10.0					
		15/48 (2 HRS)	9.8		9.0-10.0					
		16/49 (2 HRS 25 MIN)	9.7		9.0-10.0					
		17/50 (3 HRS FINAL)	7.1		7.5-8.5					
		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					350		530-A	350
	31	ADJ TO 49" (382 G) AT 80 - 100°F								
	32	STIR 5 MIN & RECORD pH 10.2	(9.5-10.5)							
	33	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26								
	34	RECORD VOL 49" & CALCULATE 49" (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 P.M.							
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE								
		START	FINISH							
		SP STEP	TIME	SP STEP	OPTR					
		11:00 P	7:00 A	235-37						
		10:00 P.M.	3:00 P.M.	381-223						
		3:00 P.M.	9:30 P.M.	54-259						

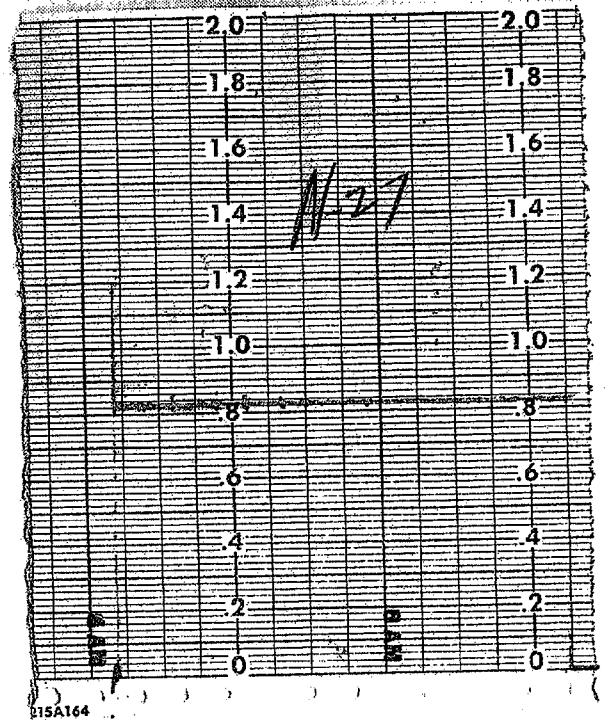


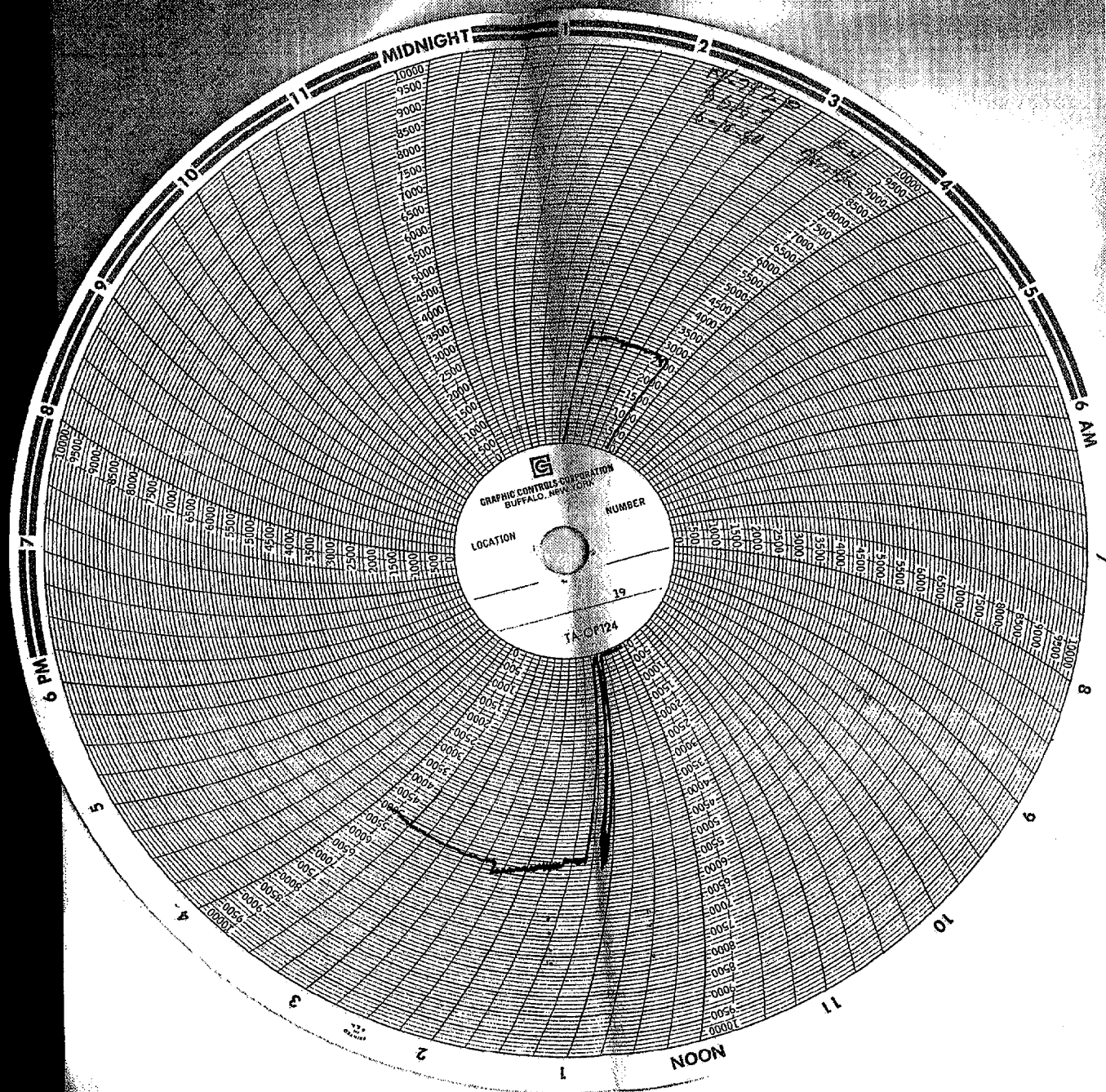
N32210.01

DUP050457086



DUP050457087





N32210.02

DUP050457089