(243) 244 (Automated)

CG 03 CODE KY-788-D PKG. PUNCHED & CHECKED

→ MAR 17 34930

EST. WGT. ~~960~~ 860 LBS.

MAR 20 1980 7:AM

OK KP

STD. HRS. 8.8 TIME

						M
14	YC-3-B	98	4	Lot	24407	2.000
14	YC-3-B	98	4	Lot	24402	50
14	YC-3-B	98	4	Lot	24404	550

PROCESSES		APPROVED BY
( )KY-788-D	(J)	EWK 9/28/76
( )	( )	MTW 9/30/76
( )	( )	DCG 9/30/76
( )	( )	
TYPED BY		
NE 2-18-77		

Homog #4 - 1ST Pass
" #4 - 2nd "

Total Wgt. ~~3560#~~ 3460

NON-BLEEDING

SHIPMENT		NAME: "KROLOR" YELLOW - LIGHT		USE LBS.	N CODE	ACCT LBS.
		~~60" (1500 G)~~				
203	1	Run ~~23" (360 G)~~ water into V-203. SET AGITATOR ON HIGH SPEED				
&	2	Weigh in drum & pour in		345	32-D	345
~~205~~	3	Dump in & stir 5 min	Lot	52 x 50	YC-3-B	2600
1		Record: Start (3:40 PM)	24407	2000		
		Fin 9:45 PM	24402	50		
263		~~75" (1275 G)~~	24404	550		
	4	Adj to ~~70" (1200 G)~~ 2400-2600				
	5	Pump V-203 thru Homog #3 at ~~1800-2200~~ psi into V-~~205~~ 263				
	6	When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimun water 263				
	7	Record: V-~~205~~ Vol ____ "& adj to 60" (2100 G)				
	8	Inspect homog. strainer & clean if necessary				
		DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED				
~~205~~	9	Run 10" (514 G) water into V-~~243~~ & start agitator				
&	10	Pump V-205 thru Homog at 4800-5200 psi into V-~~243~~				
SV		Record: Time Start 2:15 PM total min 160				
2		Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205				
263	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 #3 (V-243) or #8 (V-244)				
&	13	Press SV Cam Reset PB- set 22 TC in Auto Remote. (Temperature is set at 190-194 F)				
CP	14	Record levels and set Raw Material Counter #1 as follows				
3		a. 11LG ~~67~~ % - preset #2	208 Gal		15-A	416
		b. 13LG ~~54~~ % - preset #6	135 Gal		20-A	135
	15	Set strike flow controllers as follows:				
		a. 3FC10 (N-27-D Controller) in Manual	0.54 GPM		27-D	180
		b. 3FC20 (N-27-D Water) in Manual Local	4.4 GPM			
		c. 3FR10 (N-27-D/Water) Ratio	0.8			
		d. 8FC10 (N-32-D Controller) in Manual	~~0.72~~ GPM 0.92		32-D	1215
		e. 8FC20 (N-32-D Water) in Manual Local	3.9 GPM			
		f. 8FC20 (N-32-D Water) in Remote				
		g. 8FR10 (N-32-D/Water) Ratio	1.1			
320	16	Operator Step PB				
243	17	Record Level 21G ~~83~~ %. If below 35% follow solution make-up procedure for N-27-D				
SP	18	Adj SV to 47" (2400 G)				
&	19	Record pH 10.2 . Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		20	7-D	10
CP		Siphon into SV & Record: pH 11.3				
4	20	Operator Step PB				

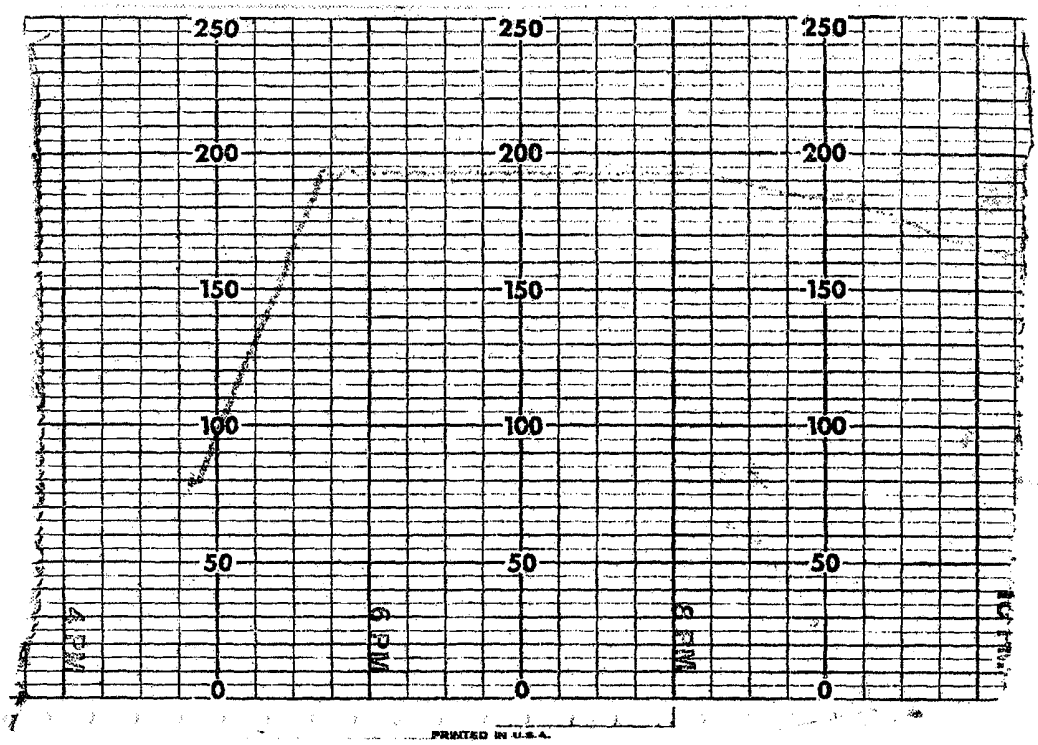
REV.

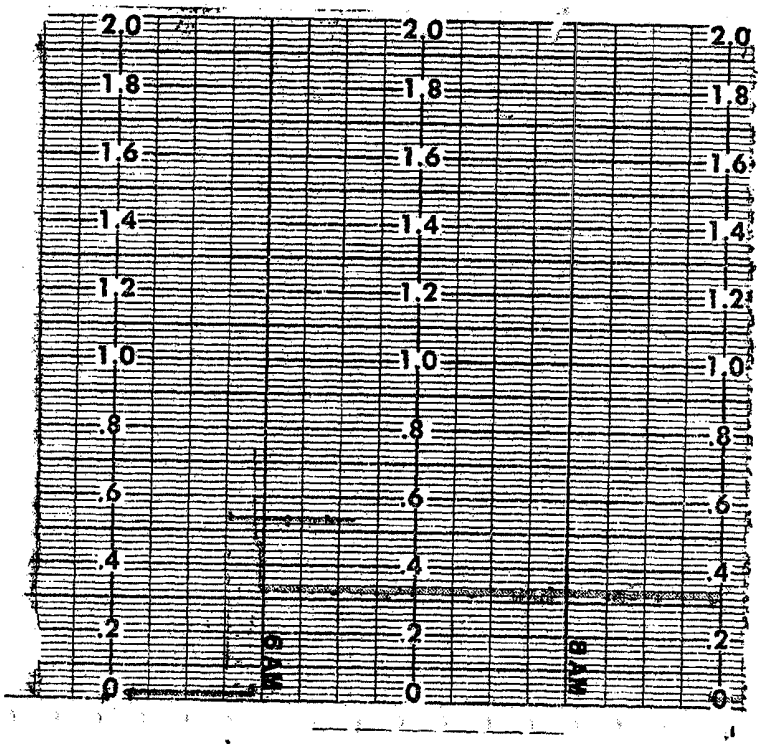
- V-243

UIPMENT		PAGE 2 CG 03 CODE KY-788-D EST. WGT. 3560 LBS.	USE LBS.	N CODE	ACC L
SV	21	SP Step 06/39 - After heat up Record: pH 9.5 (9.5-10.0)			
SP	22	Switch 3FC20, 8FC10, 8FC20 to Auto			
	23	Operator Step PB			
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits.			
5		Swich 3FC10 to Auto. Operator Step PB			
	25	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20			
		to Remote			
	26	Operator Step PB			
	27	During strike, record pH & time as follows: 6:10 PM			
		SP Step			
		V-243/V-244 pH Range Time			
		13/46 (30 min) 9.6 9.3-10.0 6:40			
		14/47 (60 min) 9.8 9.3-10.0 7:10			
		15/48 (2 hrs) 9.9 9.3-10.0 8:10			
		16/49 (2 hrs 25 min) 9.3 9.3-10.0 8:35			
		17/50 (Final 3 hrs) 9.5 7.5-8.5 9:10			
		Note: If not as specified notify Supervisor & Note in log			
		If final pH is above 8.5, adj 7.5-8.5			
		& Record: pH 8.4 Assume 77%	30	27-D	23
339	28	While striking run 30" (234 G) water into V-339			
6	29	Add in 7-8 min	350	530-A	350
	30	Adj to 49" (382 G) at 80-100 °F			
	31	Stir 5 min & record pH 10.1 (9.5-10.5)			
	32	Stir 15 min or longer to dissolve for SP Step 26/56			
	33	Record Vol 49 " & Calculate 49 " (Vol X 0.78= 38.2 G)			
	34	Set preset #8 to 38.2 from S 33			
302	35	Run 40" (440 G) water into V-302			
7	36	Add & stir 2 min for S 40 Assume 50%	360	7-D	180
SV	37	SP Step 17/50 After checking pH. Operator Step PB			
SP	38	Sift in 2 bags	100	128-A	100
	39	SP Step 23/53 Record: pH 3.1 (3.7-4.2			
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min			
	41	Record: pH 9.5 (9.0-9.5) & if necessary adj to pH 9.0-9.5			
		& 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			
	42	Operator Step PB			
	43	SP Step 29 - Record: pH 9.4 (9.0-10.0) Time 10:45 PM			
	44	Operator Step PB			
	45	SP Step 60 - Batch complete			

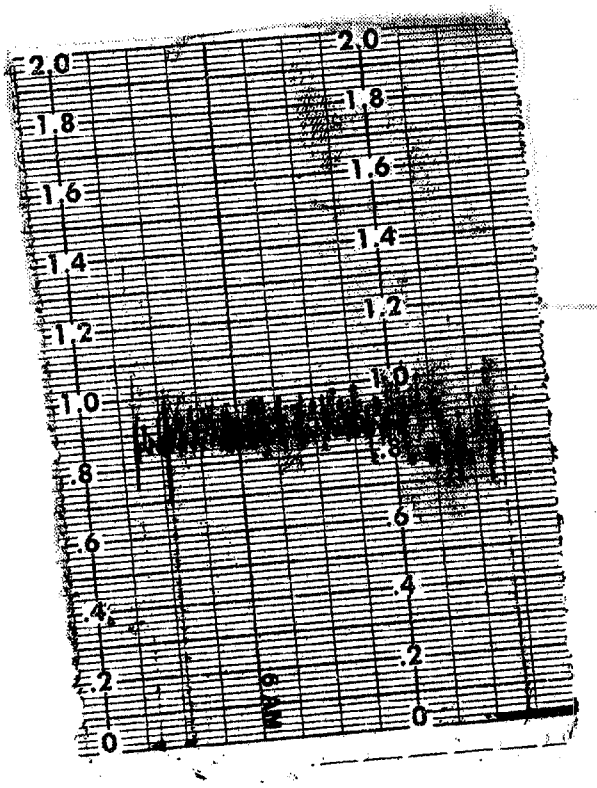
Start Time	Start SP Step	Finish Time	Finish SP Step	Optr
7:00 A		3:00 P		235
3:00 PM		10:45 PM		222

DUP050094593

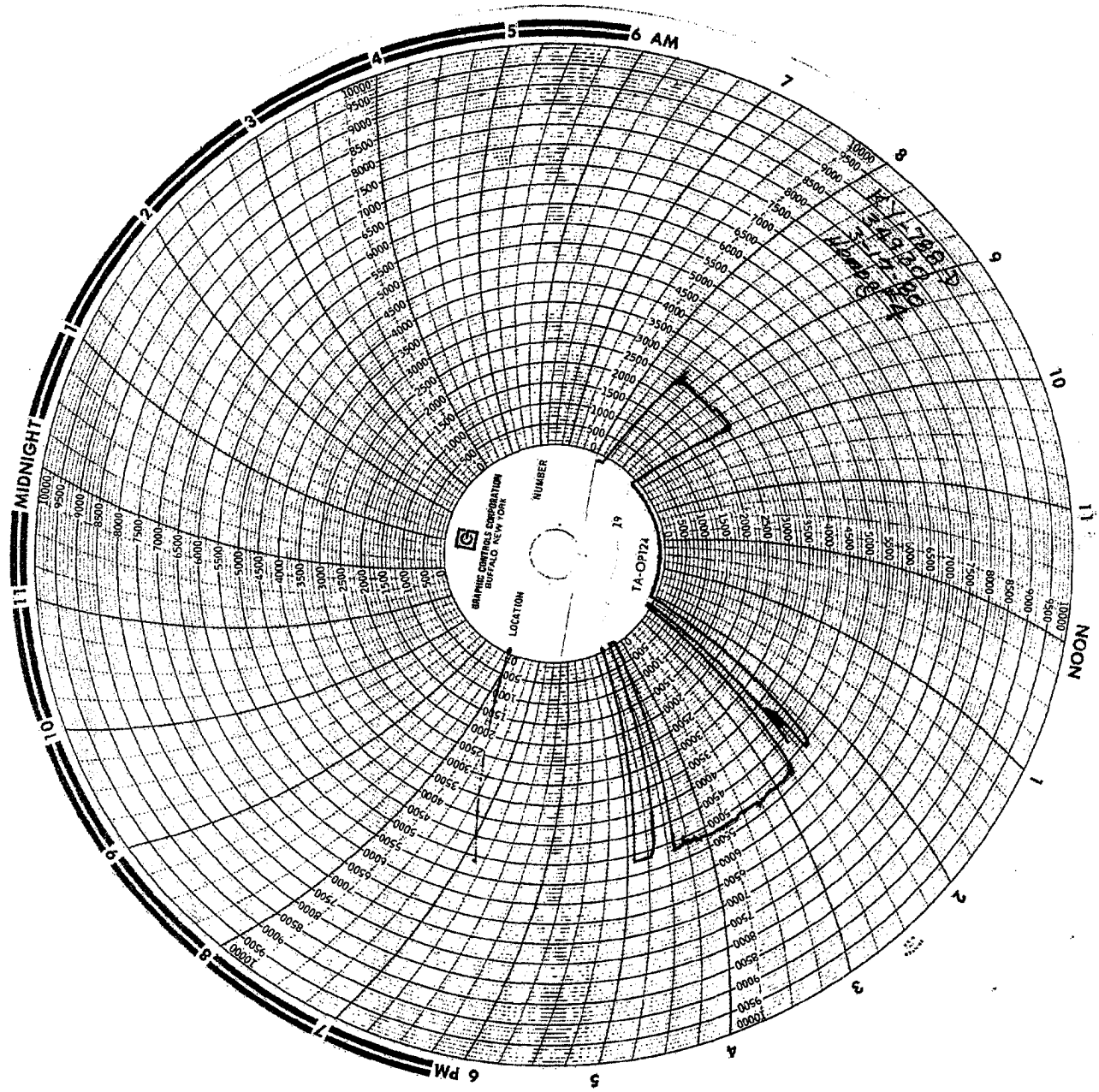




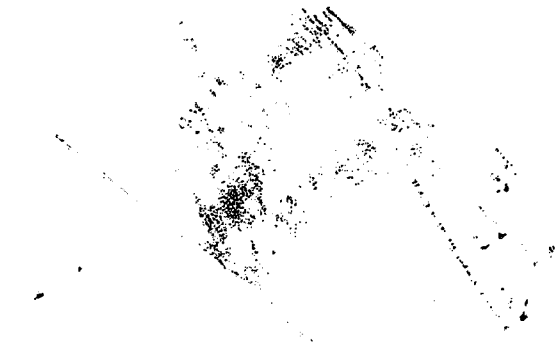
DUP050094594



DUP050094595



DUP050094596



V-243