

CG 03 CODE KY-781-D PKG. _____

→ JAN 26 28 34030

EST. WGT. 1228-1128 LBS.

STD. HRS. _____ TIME 3 P M

14 YC-3-B 93 4 24407 3.200 #

14 YC-3-B 93 4 _____ #

14 YC-3-B 93 4 _____ #

Total Wgt. 4428# (Req _____)

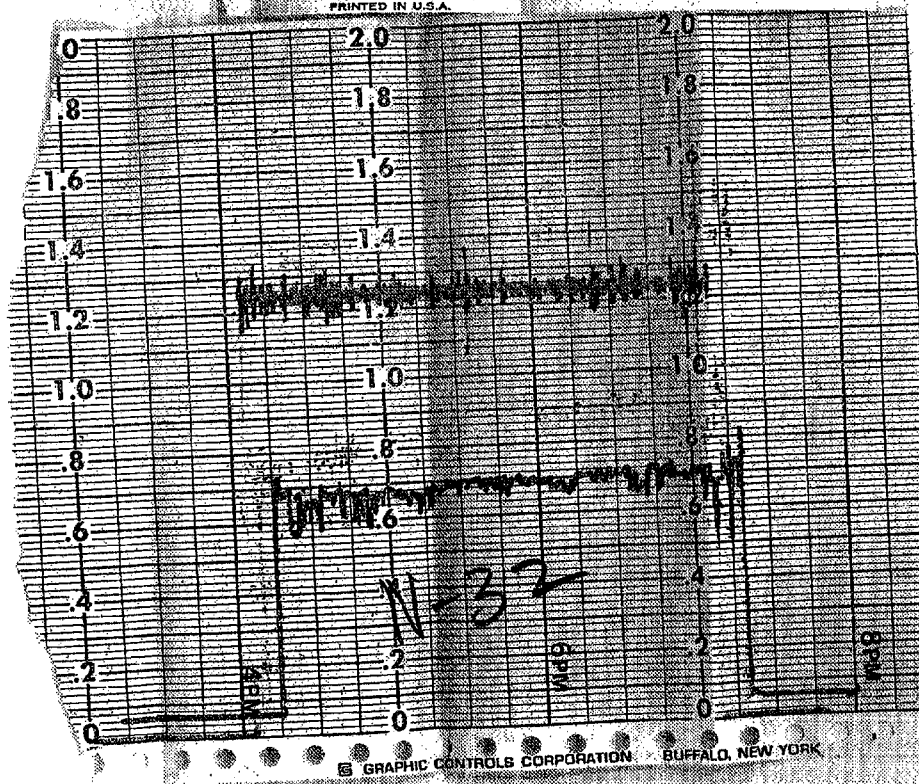
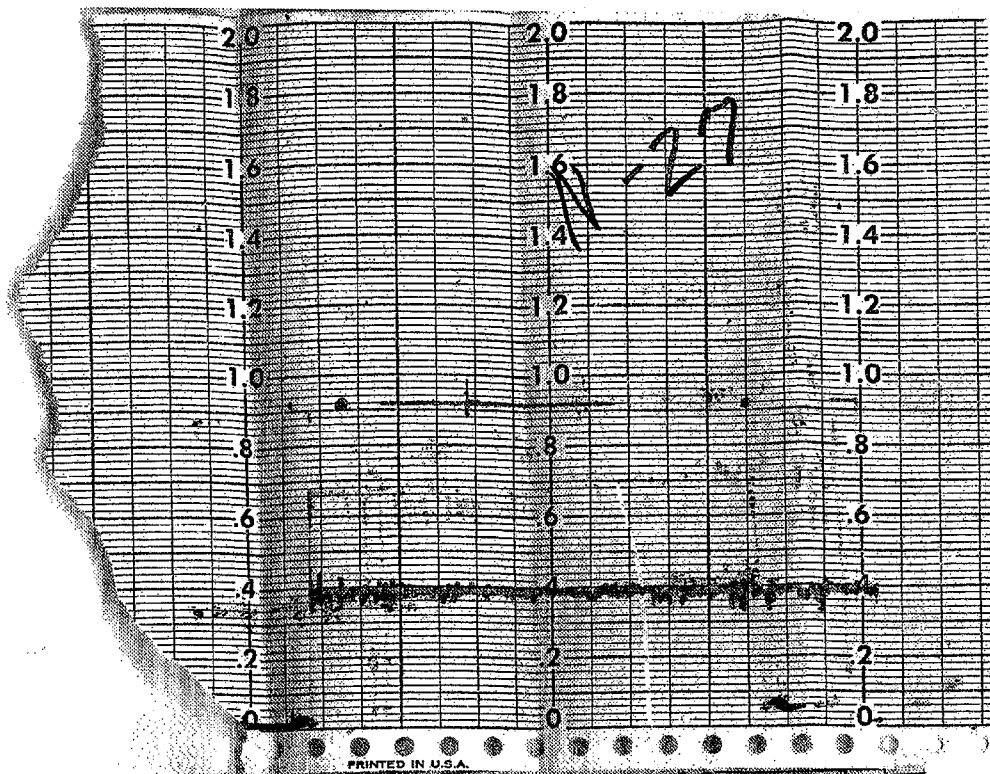
PROCESSES		APPROVED BY
()	KY-781-D (N)	FWP 101378
()	()	AMJ 101378
()	()	
()	()	
TYPED BY		
emw101378		

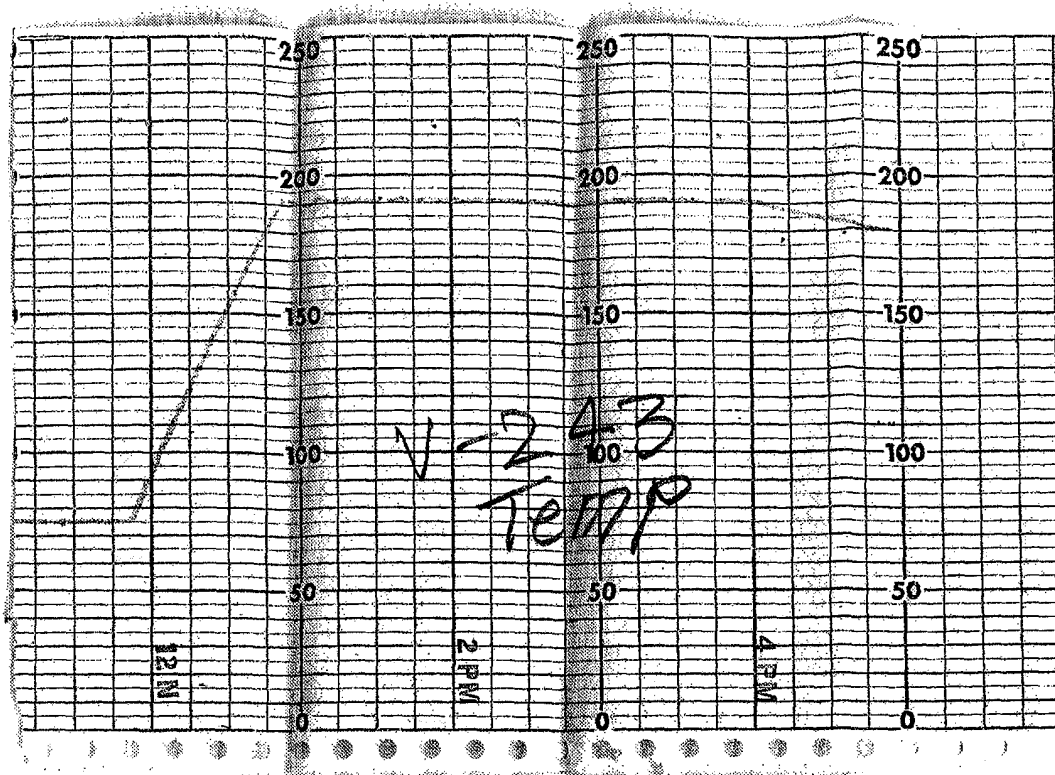
Homog # 4-22^d Pass
NON-BLEEDING

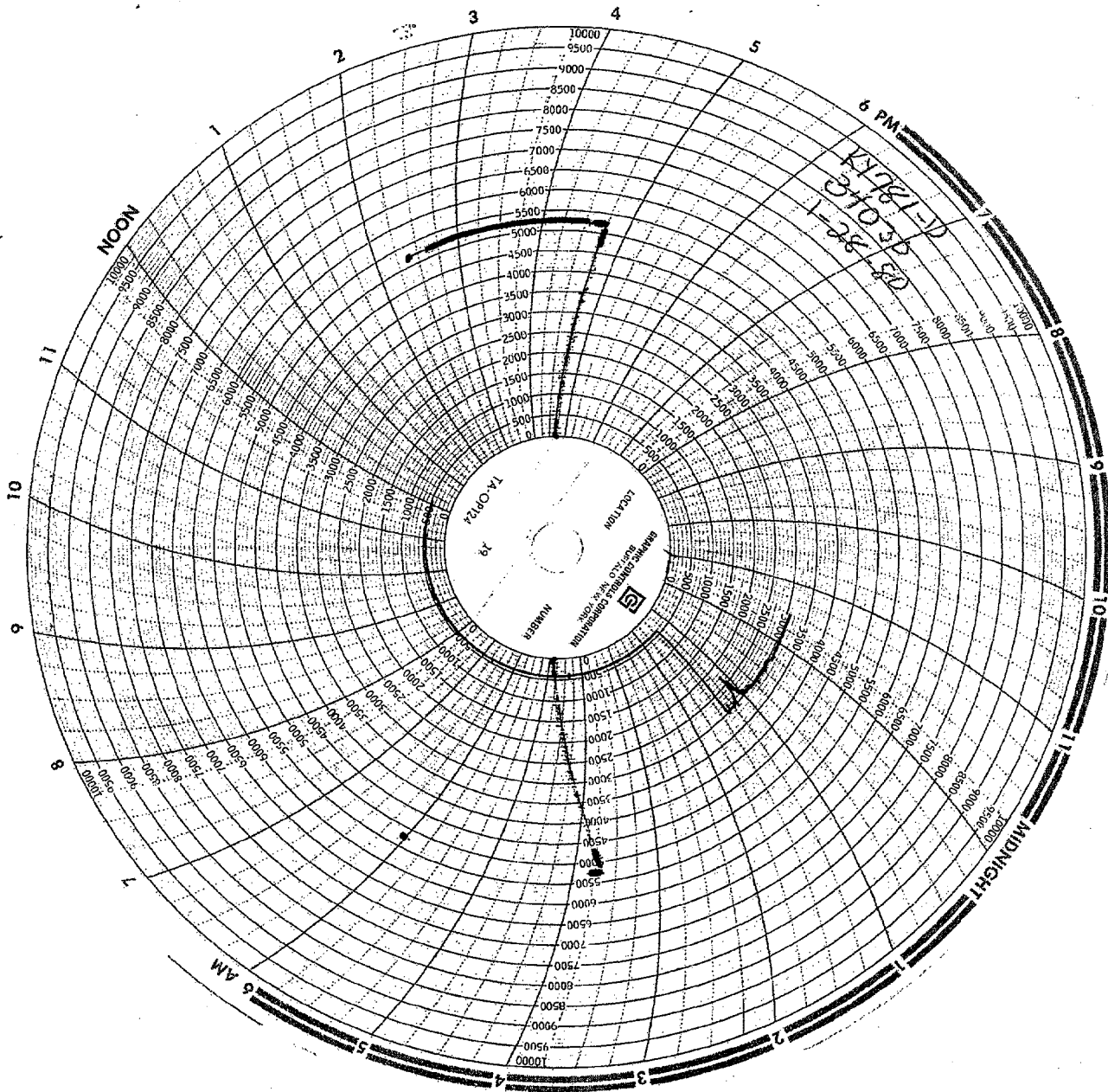
QUIPMENT	NAME:	USE	N	ACCT.
		LBS.	CODE	LBS.
203	Run 60" (992 G) water in V-203 & add	Assume 50%	36	7-D 18
&	2 Weigh in drum & pour in		442	32-D 442
205	3 Dump in & stir 5 min	Lot 64	66 x 50	YC-3-B 3300
1	Record: Start 9.50 PM	24407	3.200	3200
	Fin 10.45 PM			
	75" (12756) 2400-2600			
	4 Adj to 80" (1360 G) & Record: (pH (10.5-11.5)			
	5 Pump V-203 thru Homog # at 1800-2200 psi into V-205			
	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using			
	minimum water			
	7 Record: V-205 Vol 40" & adj to 45" (1662 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 12" (200 G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time Start 1:00 PM Total Min 200			
2	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 #1 (V-243) or			
&	#6 (V-244)			
CP	13 Press SV Cam Reset PB-Set 22TC in Auto Remote			
3	(Temperature is set at 190-194°F)			
	14 Record levels and set Raw Material Counter #1 as follows:			
	a) 11LG-72% - preset #3 187 Gal		15-A	374
	15 Set strike flow controllers as follows:			
	a) 3FC10 (N-27-D Controller) in Manual 0.9 GPM		27-D	373
	b) 3FC20 (N-27-D Water) in Manual Local 6.3 GPM			
	c) 3FR10 (N-27-D / Water Ratio) 0.7			
	d) 8FC10 (N-32-D Controller) in Manual 1.20 GPM		32-D	2527
	e) 8FC20 (N-32-D Water) in Manual Local 5.4 GPM			
	f) 8FC20 (N-32-D Water) in Remote			
	g) 8FR10 (N-32-D / Water Ratio) 0.9			
SV	16 Operator Step PB			
SP	17 Record Level 2LG 63%. If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj SV to 54" (2800 G)			
4	19 Record: pH 10.3			
	20 Adj pH to 11.4-11.6 using Assume 50%	30	7-D	15
	(Dilute to 5% (10 parts water to 1 part N-7-D)			
	Siphon into SV. Record: pH 11.4			
	21 Operator Step PB			

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EQUIPMENT	PAGE 2	CG 03	CODE KY-781-D	N EST. WGT.	1128 LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22	SP	Step 06/39.	After heat up Record: pH 10.0 (9.6-10.2)				
SP	23	Switch	3FC20, 8FC10, 8FC20, to Auto					
&	24	Operator	Step PB					
CP	25	SP	Step 10.43 - When 3FC20, 8FC10, 8FC20 water flow in limits					
5			switch 3FC10 to Auto. Operator Step PB					
	26	SP	Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20					
			to Remote. Operator Step PB					
	27	During	Strike, Record pH & Time as follows:					
		SP Step	pH	Range	Time			
		13/41 (30 min)	9.9	9.3-10.0	7:10			
		14/47 (60 min)	9.9	9.3-10.0	7:40			
		(2 hrs)	9.9	9.3-10.0	8:40			
		(3 hrs)	9.9	9.3-10.0	9:40			
		17.50 (Final)	8.2	7.5- 8.5	10:25			
		NOTE:	If pH not as specified notify Supervisor & note in log. If final pH is above (8.5) Adj to pH 7.5-8.5					
			M		%		27-D	
V-302	28	Add	31" (379 G) water to V-302					
6	29	Add & stir	5 min	Assume 50%	124	7-D	62	
SV	30	SP	Step 17/50 after checking pH. Operator PB					
SP	31	SP	Step 23/53 Record: pH 3.4 (3.3-3.7)					
&	32	If necessary	adj pH (DOWN ONLY) Record: pH				15-A	
CP		NOTE:	Dissolve extra N-15-A in water at 110-120°F in drum					
7			Use ±30 Gal of water to 50# N-15-A. Stir SV 5 min					
			after each addition					
	33	Sift in				✓ 150	128-A	150
	34	Run in	N-7-D from S 29 & stir 5 min					250
	35	Record:	pH 4.2 (4.2-4.4)					
	36	If necessary	adj pH to (4.2-4.4) with dilute N-7-D (10 parts					
			H ₂ O to 1 part N-7-D) or N-27					
				M	%		27-D	
					Assume 50%		7-D	
		Siphon (if N-7-D) into SV. Record: pH						
	37	Operator	Step PB					
	38	SP	Step 24/54 - Add N-978-A & stir 15 min			✓ 20	978-A	20
	39	Operator	Step PB					
	40	SP	Step 60 - Batch Complete					
	41	PUMP	N-243-70V-240					
		START		FIN	OPTR			
		TIME	SP STEP	TIME	SP STEP			
		12 MID		2:00 P		126-27		
		7:00 AM		3:00 PM		244-237		
		3:00 PM		11:00 PM		235-323		
		11:00 PM		12:15 A		27		







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