

V. 243 (Automated) C.V.

CG 03 CODE KY-788-D PKG.

EST. WGT. 980 860 LBS.

STD. HRS. 8.8 TIME 7.1 P M
14 YC-3-B 98 4 Lot 24465 2400
14 YC-3-B 98 4 Lot
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OK
AP

244

PUNCHED & CHECKED

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	

Total Wgt. 3560 3460

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NON-BLEEDING

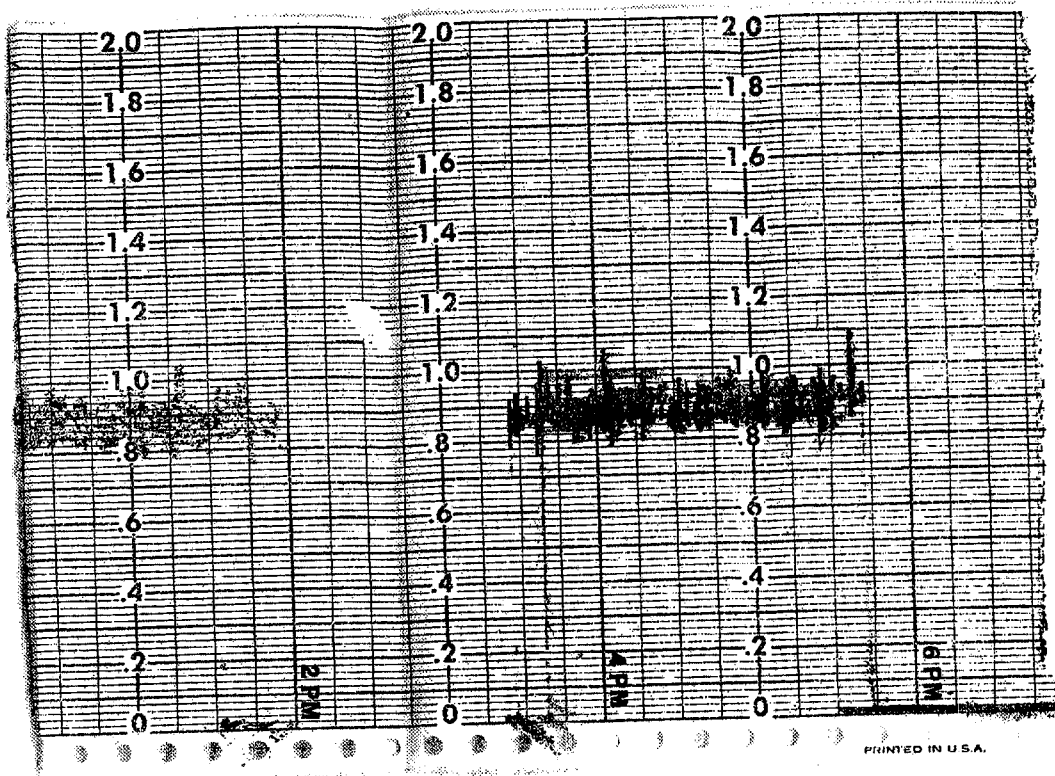
SHIPMENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" (1200 G) "KROLOR" YELLOW - LIGHT			
&	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
205	2 Weigh in drum & pour in	345	32-D	345
1	3 Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
	Record: Start 4:15 pm			
	Fin 5:15 pm 24405 2600			
	75" (1275 G)			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-205 Vol 410 " & adj to 60" (2100 G)			
	8 Inspect homog. strainer & clean if necessary			
	9 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
205	10 Run 10" (514 G) water into V-205 & start agitator.			
SV	11 Pump V-205 thru Homog at 4800-5200 psi into V-204			
2	Record: Time Start 8:30 pm Total min 1:30			
	Note: If Homog pressure falls below 4800 ps., 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	13 SP Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
&	14 Press SV Cam-Reset PB- set 22 TC in Auto Remote			
CP	(Temperature is set at 190-194 F)			
3	15 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 6.9 % - preset #2 208 Gal 15-A 416			
	b. 13LG 7.4 % - preset #6 135 Gal 20-A 135			
	16 Set strike flow controllers as follows:			
	a. 2FC10 (N-27-D Controller) in Manual 0.54 GPM 27-D 180			
	b. 2FC20 (N-27-D Water) in Manual Local 4.4 GPM			
	c. 2FR10 (N-27-D/Water Ratio) 0.8			
	d. 2FC10 (N-32-D Controller) in Manual 8.72 GPM 0.92 32-D 1215			
	e. 2FC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 2FC20 (N-32-D Water) in Remote			
	g. 2FR10 (N-32-D/Water Ratio) 1.1			
320	17 Operator Step PB			
243	18 Record Level 2LG 6.7 %. If below 35% follow solution			
SP	make-up procedure for N-27-D			
&	19 Adj SV to 47" (2400 G)			
CP	20 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%	30	7-D	15
4	Siphon into SV & Record: pH 11.2			
	21 Operator Step PB			

REV.

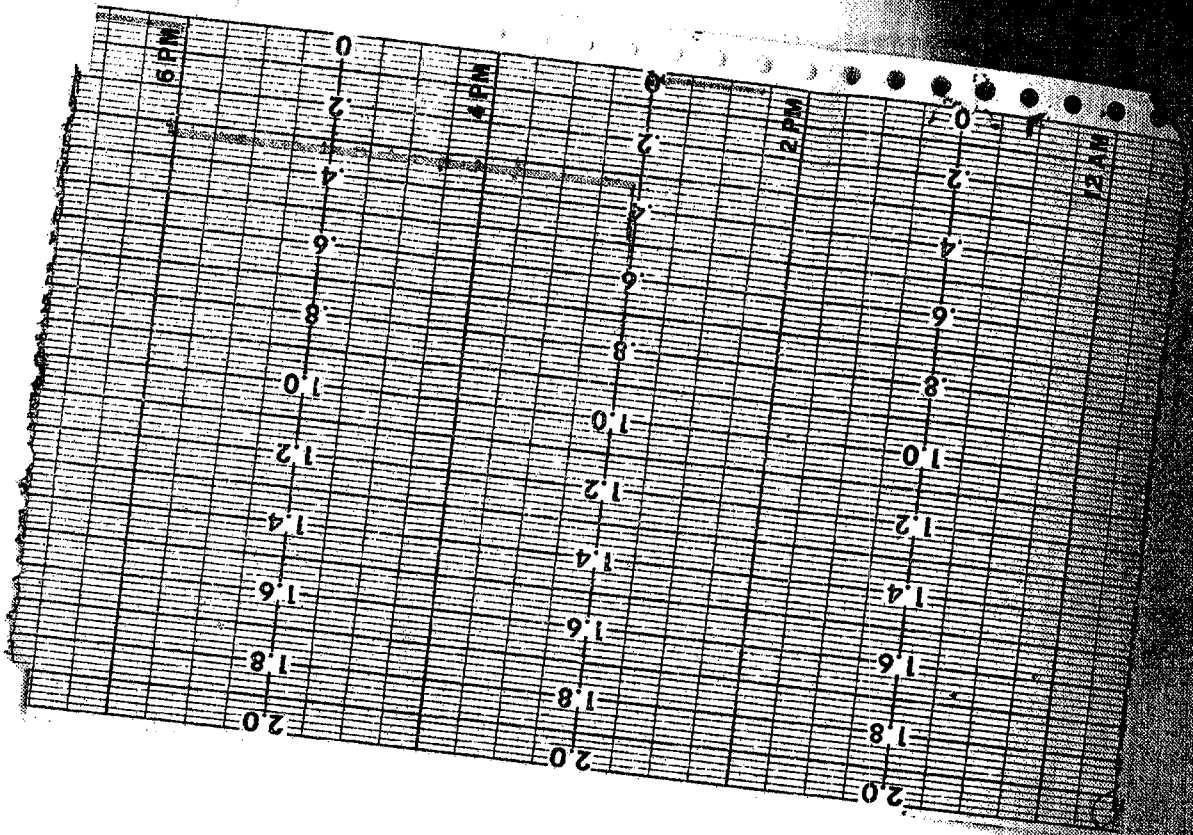
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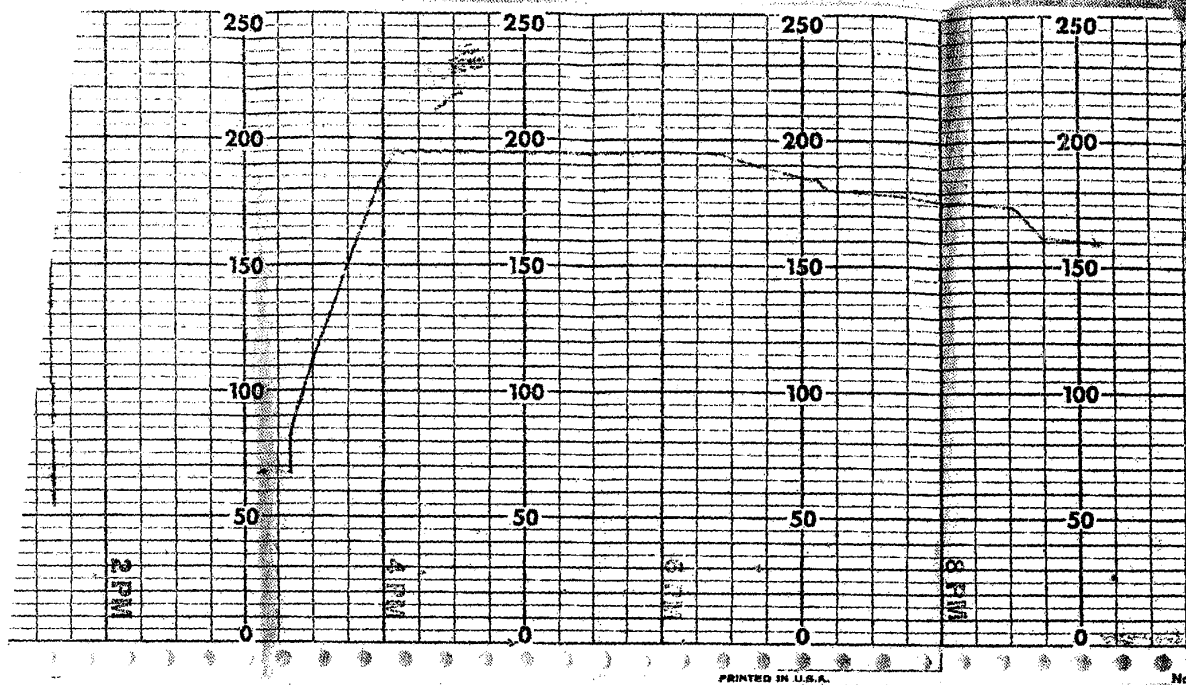
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UIPMENT	PAGE 2 CG 03 CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS
SV	21 SP Step 06/39 - After heat up Record: pH <u>9.9</u> (9.5-10.0)					
SP	22 Switch 3FC20. 8FC10, 8FC20 to Auto					
	23 Operator Step PB					
5	24 SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits					
	Switch 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:					
	SP Step					
	V-339/V-244	pH	Range	Time		
	1/45 (30 min)	<u>9.7</u>	9.3-10.0	<u>13:50 AM</u>		
	14/47 (60 min)	<u>9.7</u>	9.3-10.0	<u>1:30 PM</u>		
	15/48 (2 hrs)	<u>9.7</u>	9.3-10.0	<u>2:20 PM</u>		
	16/49 (2 hrs 25 min)	<u>9.6</u>	9.3-10.0	<u>2:45 PM</u>		
	17/50 (Final 3 hrs)	<u>9.9</u>	7.5-8.5	<u>3:20 PM</u>		
	Note: If not as specified notify Supervisor & Note in log					
	If final pH is above 8.5, adj 7.5-8.5					
	& Record: pH Assume 77%				27-D	
339	28 While striking run 30" (234 G) water into V-339					
6	29 Add in 7-8 min			350	530-A	350
	30 Add to 49" (382 G) at 80-100 °F					
	31 Stir 5 min & record pH <u>9.0</u> (9.5-10.5)					
	32 Stir 15 min or longer to dissolve for SP Step 26/56					
	33 Record Vol <u>49</u> " & Calculate <u>49</u> " (Vol X 0.78= <u>38.22</u> G)					
	34 Set preset #8 to <u>58.2</u> G 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 Stir in 2 bags			100	128-A	100
8	39 SP Step 23/53 Record: pH <u>9.9</u> (3.7-4.2)					
	40 Run in N-7-D from S 36 in 10-12 min & stir 5 min					
	41 Record: pH <u>9.4</u> (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 <u>9.4</u> (9.0-10.0) Time <u>5:30 AM</u>					
	44 Operator Step PB					
	45 SP Step 60 - Batch complete					
	Start	Finish	Optr			
	Time SP Step	Time SP Step				
	<u>11:00 AM</u>	<u>5:40 AM</u>	<u>37</u>			



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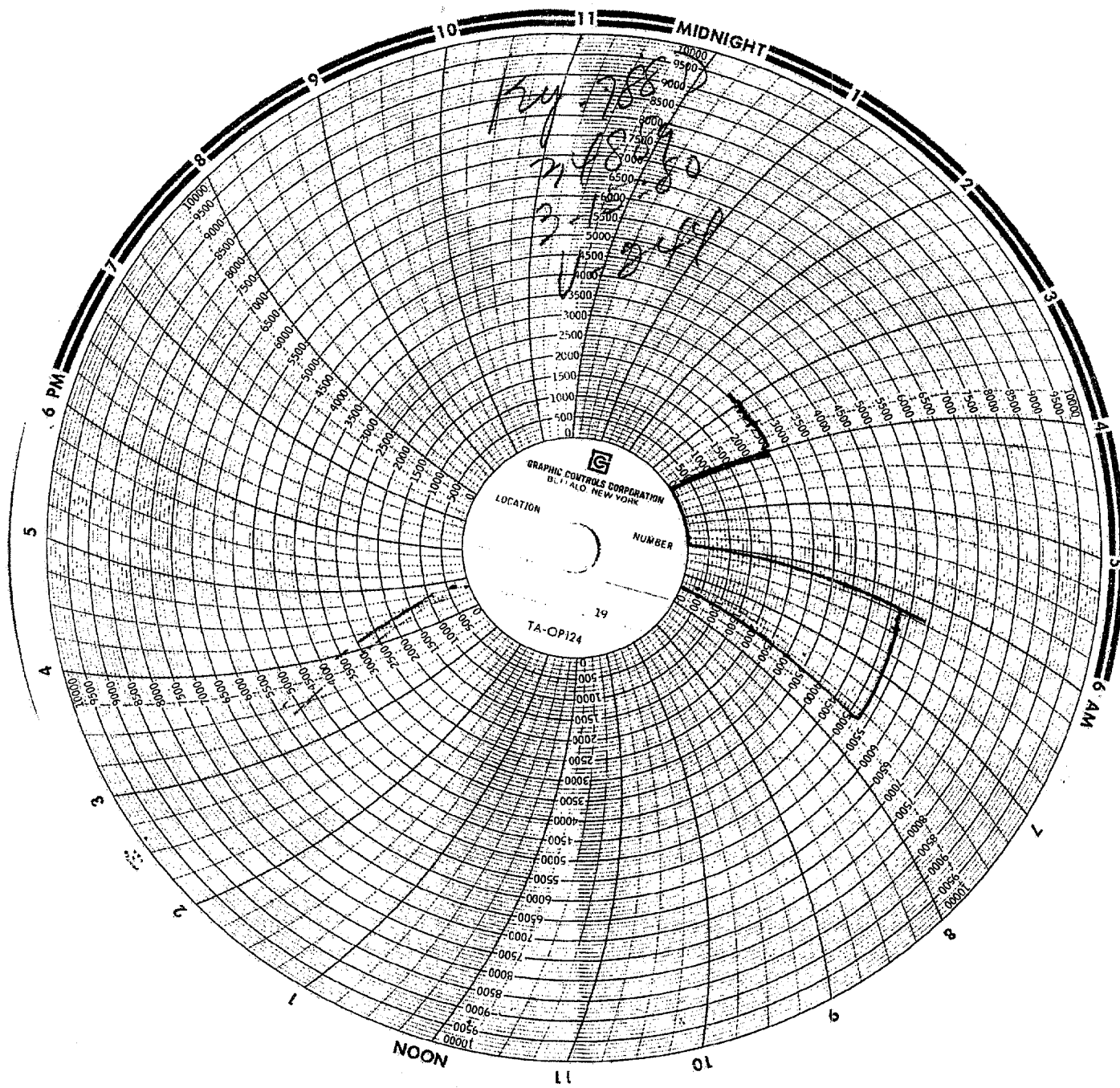




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John W. Smith