

CO 03 CODE KY-787-D PKG. _____

JAN 14 33758

EST. WGT. 1090 LBS.

STD. HRS. 8.9 TIME 11P 24 M14 - YC-2-B 98 4 Lot 24.083, 2000#
Lot 24.082, 100#
Lot _____, _____#

PROCESSES	APPROVED BY
() KY-787-D	() FWK 9/22/76
()	() DCG 9/27/76
()	() MTW 9/30/76
()	()
TYPED BY	
N.E. 2/12/77	

Homog #4 - 2nd Pass

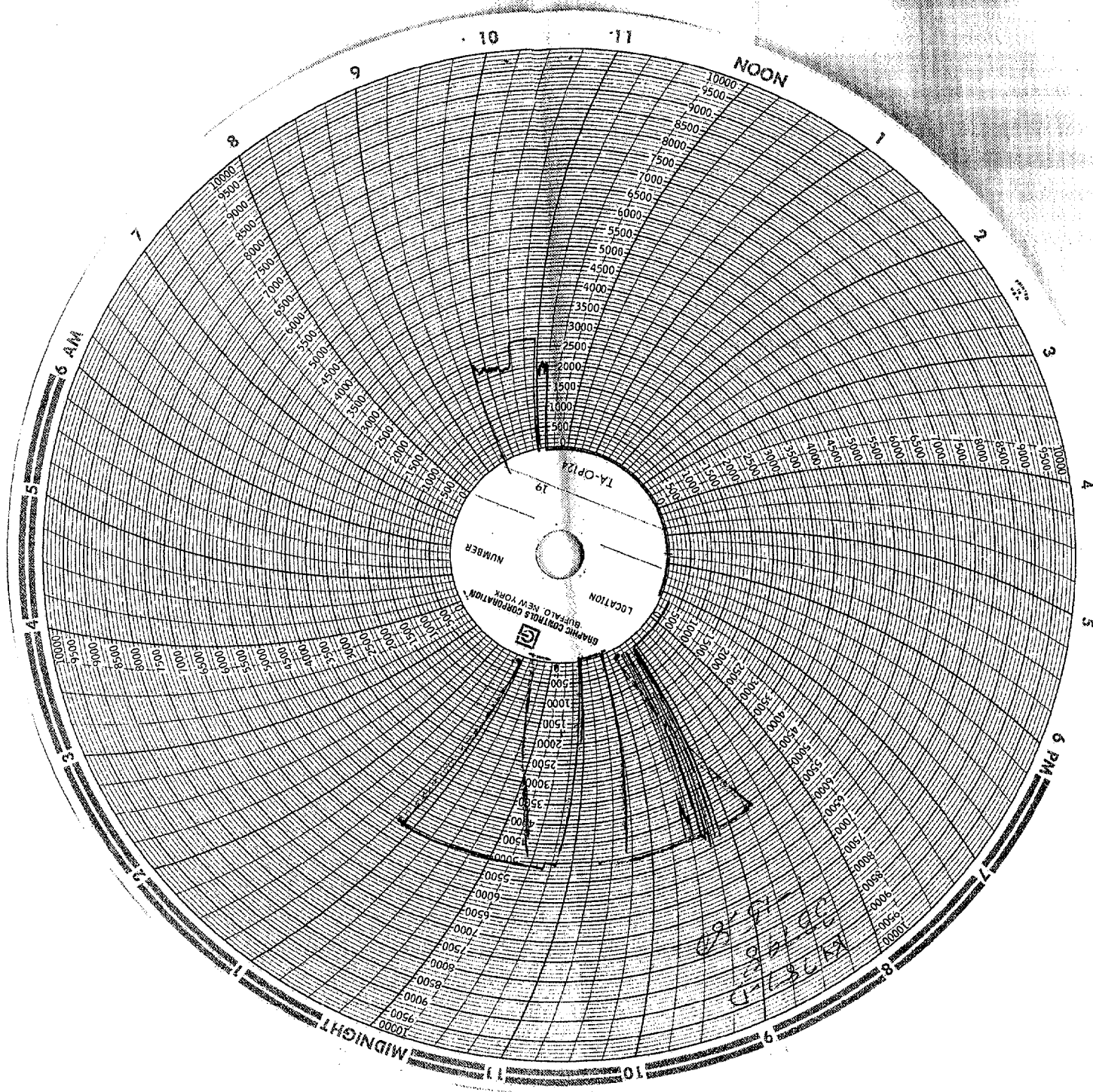
Total Wgt. - 3490#

NON-BLEEDING

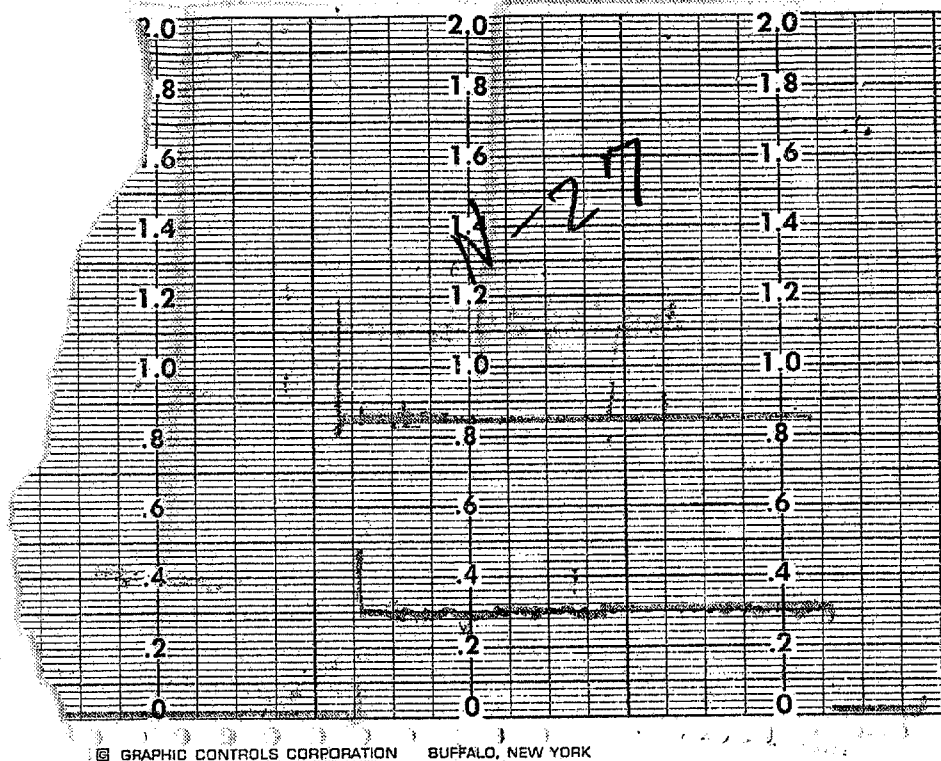
IPMENT	NAME:	USE LBS.	N CODE	ACCT LBS.
203 *	10" "KROLOR" - YELLOW MEDIUM			
205	1 Run 10" (922 G) water into V-203			
1	2 Weigh in drum & pour in	320	32-D	320
	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start <u>7:45 AM</u> Lot <u>24.083</u> <u>2,000</u>			
	Fin <u>9:00 AM</u> <u>24.082</u> <u>400</u>			
	4 Adj to 70" (1200 G) <u>2400-2600</u>			
	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 <u>40</u> " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514G) water into SV & start agitator <u>243</u>			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-			
2	Record: Time start <u>10:40</u> Total Min <u>120</u>			
	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)			
&	13 Press SV Cam Reset PB-set 22TC in Auto Remote			
CP	(Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG <u>82</u> % - preset #1 80 Gal 15-A 160			
	b. 13LG <u>86</u> % - preset #6 135 Gal 20-A 135			
	15 Set strike flow controllers as follows:			
	a. 3FC10 (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 184			
	e. 8FC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8FC20 (N-32-D Water) in Remote 0.83			
	g. 8FR10 (N-32-D/Water Ratio)			
SV	16 Operator Step PB			
SP	17 Record Level 2 LG <u>84</u> %. If below 35% follow solution make-up procedure for N-27-D			
&	18 Adj to 48" (2470 G)			
CP	19 Record pH: <u>10.4</u>			
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) 30 7-D 15			
	Siphon into SV. Record pH <u>11.2</u>			
	21 Operator Step PB			

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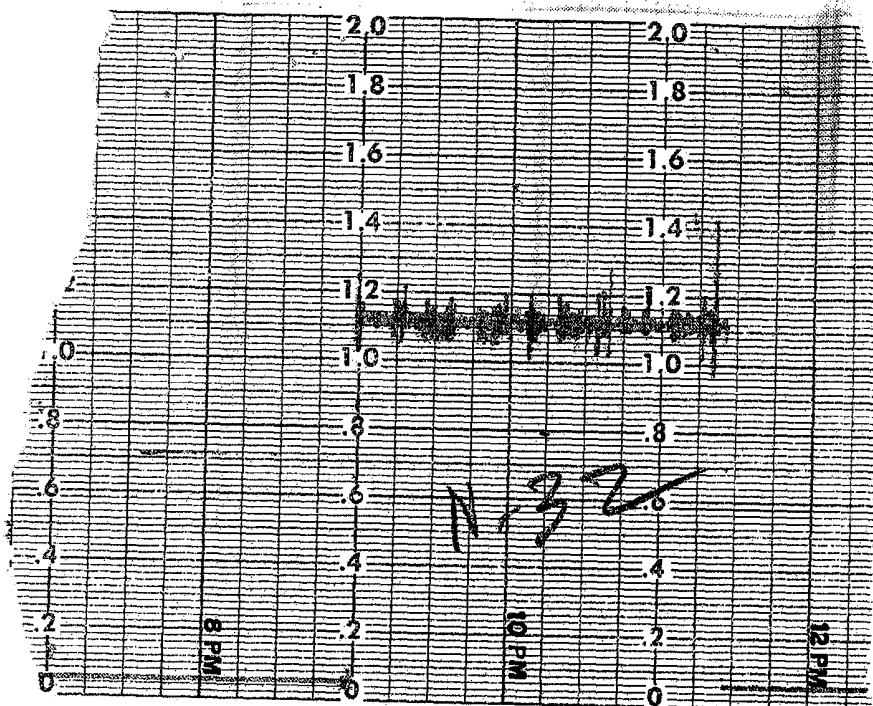
PMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACC LB
SV	22	SP Step 06/39	- After heat up Record: pH	9.9	(9.5-10.0)			
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB						
CP	25	SP Step 10/43	- When 3FC20, 8FC10, 8FC20 water flows in limits					
5		Switch 3FC10 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:					2:15/Am	
		SP STEP						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	9.7	9.0-10.0	2:45			
		14/47 (60 min)	9.7	9.0-10.0	3:15			
		15/48 (2 hrs)	9.7	9.0-10.0	4:15			
		16/49 (2 hrs 25 min)	9.7	9.0-10.0	4:40			
		17/50 (3 hrs Final)	7.0	7.5-8.5	5:15			
		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	10.1	(9.5-10.5)				
	33	Stir 15 min or longer to dissolve for SP Step 26			38.2			
	34	Record Vol 49 " & calculate 49 (Vol) x 0.78 =			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	SIET 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 S37 in 10-12 min & stir 5 min						
CP	42	Record: pH 8.8 (9.0-9.5) & if necessary adj pH 9.0-9.5						
8		& Record: pH 9.2		Assume 77%			27-D	
		(Dilute 10 parts water to 1 part N-7-D)		Assume 50%		10	7-D	5
		Siphon N-7-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58	Record: pH 9.0 (9.0-10.0) Time 6:30 AM					
	45	Operator Step PB						
	46	SP Step 60	- Batch complete					
		Start	Finish	Optr				
		Time: Pm	Time	SP Step				
		11:00P	6:30AM	120-101				
				235-701				



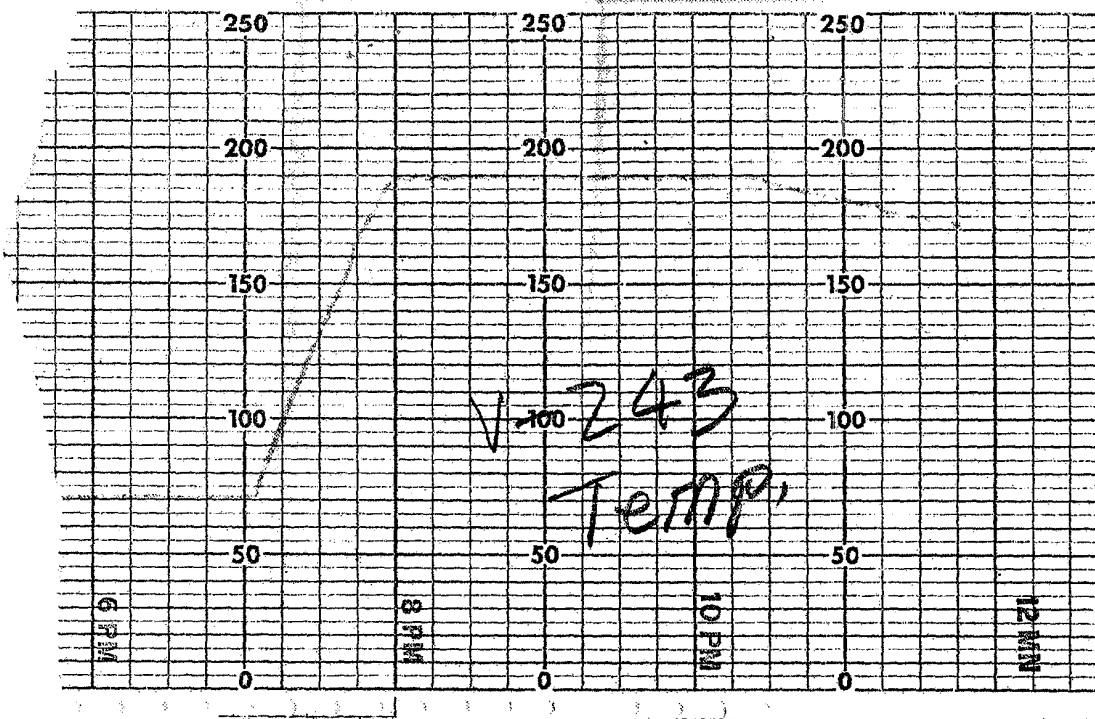
V-243



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