

→ MAR 13 34863
EST. WGT. 960 860 LBS.

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

STD. HRS. 8.8 TIME 7 A M
14 YC-3-B 98 4 Lot 24405 2000
14 YC-3-B 98 4 Lot 24407 600
14 YC-3-B 98 4 Lot

PUNCHED & CHECKED

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

Total Wgt. 3560# 3460

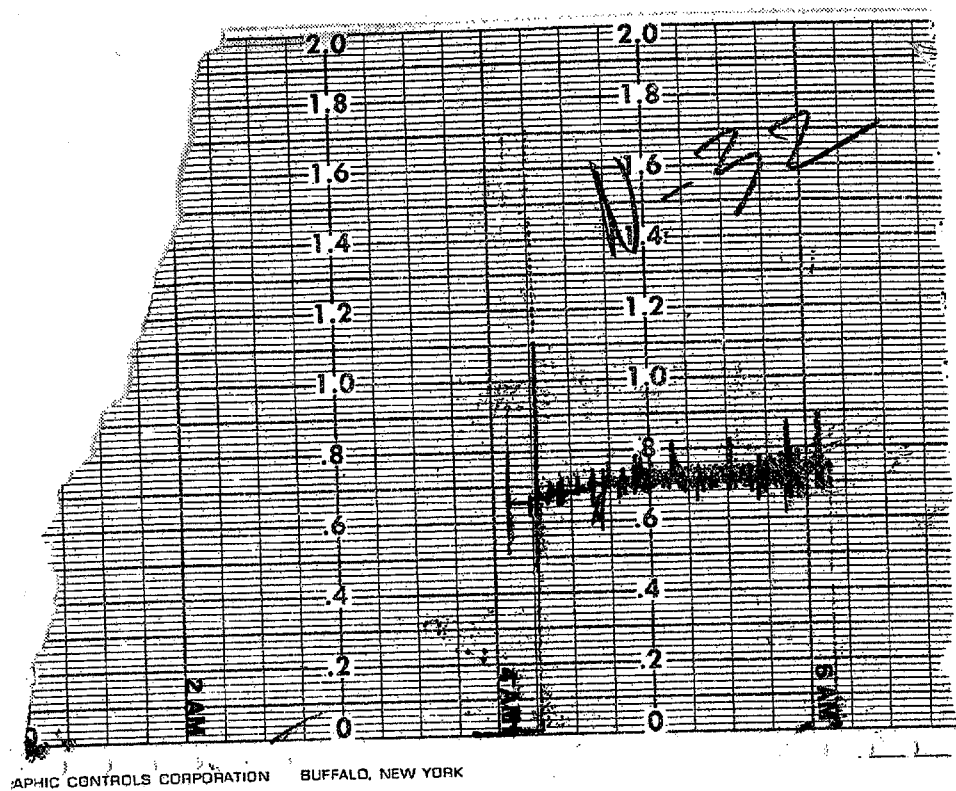
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NON-BLEEDING

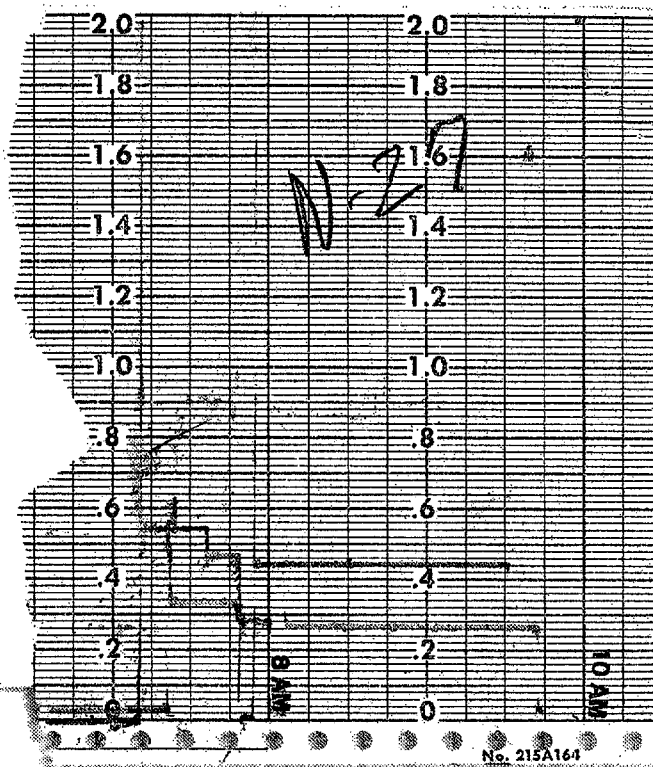
MENT	NAME	USE LBS.	N CODE	ACCT LBS.
60"	"KROLOR" YELLOW - LIGHT			
203	1 Run 23" (360 G) water into V-203 SET AGITATOR ON HIGH SPEED			
8	2 Weigh in drum & pour in	345	32-D	345
205	3 Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
1	Record: Start 4:10 PM			
	Fin 5:30 PM	2000		
	75" (1275 G)	24405		
	Adj to 78" (1200 G) 2400-2600	24407		
	6 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	8 When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimun water			
	7 Record: V-205 Vol 43 " & adi 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			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V- 243			
2	Record: Time Start 11:50 AM total min 11.5			
	Note: If Homog pressure falls below 4800 ps., 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 #3 (V-243) or #8 (V-244)			
8	13 Press SV Cam Reset PB- set 22 TC in Auto Remote			
CP	(Temperature is set at 190-194 F)			
3	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 65% - preset #2 208 Gal		15-A	416
	b. 13LG 72% - 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. 3EC20 (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		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			
20	16 Operator Step PB			
3	17 Record Level 2LG 87%. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.4. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.0		12 72-D	12
	20 Operator Step PB			

V-243

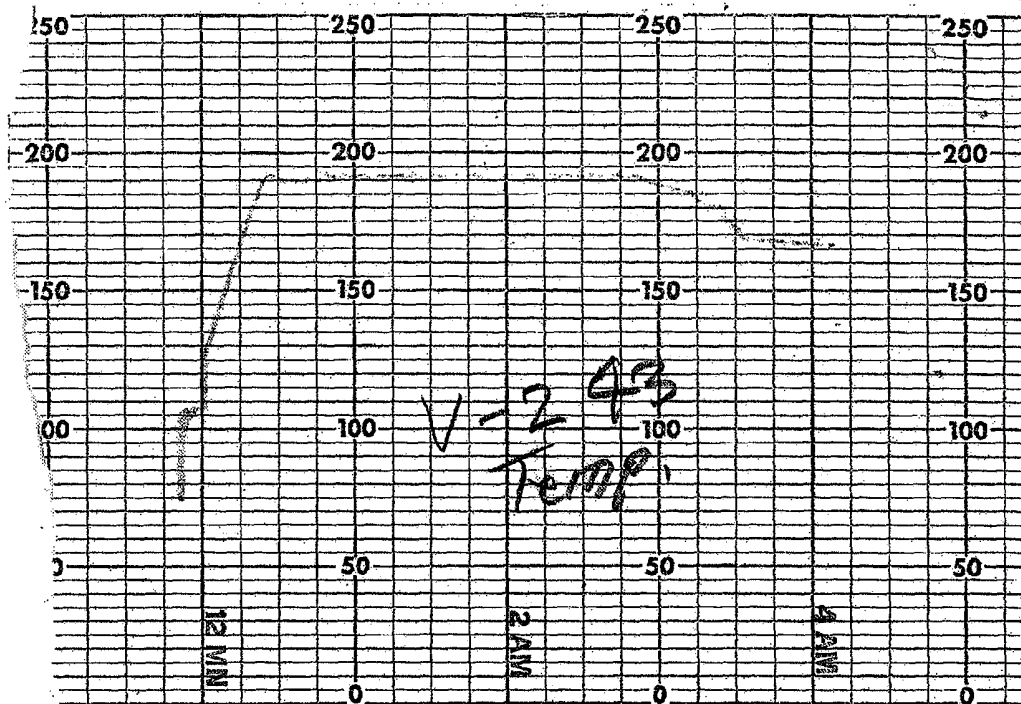
MENT	PAGE 2 CG 03 CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS.
21	SP Step 06/39 - After heat up Record: pH <u>9.7</u> (9.5-10.0)					
22	Switch 3FC20. 8FC10. 8FC20 to Auto					
23	Operator Step PB					
24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits. Switch 3FC10 to Auto. 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-243/V-244	pH	Range	Time		
	13/46 (30 min)	<u>9.3</u>	9.3-10.0	<u>3:20</u>	←	ADSN-27 0.46
	14/47 (60 min)	<u>9.3</u>	9.3-10.0	<u>3:50</u>		
	15/48 (2 hrs)	<u>9.35</u>	9.3-10.0	<u>4:50</u>		
	16/49 (2 hrs 25 min)	<u>9.35</u>	9.3-10.0	<u>5:15</u>		
	17/50 (Final 3 hrs)	<u>7.45</u>	7.5-8.5	<u>5:50</u>		SHUT N-27 OFF
	Note: If not as specified notify Supervisor & Note in log					5 MIN EARLY
	If final pH is above 8.5, adj 7.5-8.5					
	& Record: pH		Assume 77%			27-D
28	While striking run 30" (234 G) water into V-339					
29	Add in 7-8 min			350	530-A	351
30	Adj to 49" (382 G) at 80-100 °F					
31	Stir 5 min & record pH <u>10.1</u> (9.5-10.5)					
32	Stir 15 min or longer to dissolve for SP Step 26/56 <u>38.2</u>					
33	Record Vol <u>49</u> " & Calculate <u>49</u> " (Vol X 0.78 = <u>G</u>)					
34	Set preset #8 to <u>38.2</u> from S 33					
35	Run 40" (440 G) water into V-302			180		
36	Add & stir 2 min for S 40		Assume 50% <u>7.46</u>	<u>200</u>	727-D	181
37	SP Step 17/50 After checking pH. Operator Step PB					
38	Sift in 2 bags			100	128-A	101
39	SP Step 23/53 Record: pH <u>3.3</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>9.3</u> (9.0-10.0) Time					
44	Operator Step PB					
45	SP Step 60 - Batch complete					
46	PUMPED TO V-240					
	Start	Finish	Optr			
	Time	SP Step	Time	SP Step		
	<u>11:00P</u>		<u>7:00AM</u>		<u>235</u>	
	<u>7:00AM</u>		<u>7:45AM</u>		<u>409</u>	



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



No. 215A164



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