

CO 03 CODE KY-787-D PKG. _____

DEC 21 33440

EST. WGT. 1090 LBS.

STD. HRS. 8.9 TIME

14 - YC-2-B 98 4 Lot 241686 500#Lot 241686 250#Lot 24170 1000#

2400

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

Homog #4 - 157 Pags

Total Wgt. - 3490#

NON-BLEEDING

IPMENT	NAME:	USE LBS.	N CODE	ACCT LBS.
203	1 Run 10" (992 G) water into V-203			
8	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start <u>4:15</u>			
	Fin <u>4:40</u>			
	4 Adj to 70" (1200 G) <u>2400-2600</u>			
	5 Pump V-203 thru Homog #3 at 2800-2200 psi into V-205 <u>2673</u>			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water <u>2673</u>			
	7 Record V-205 Vol <u>393</u> " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514G) water into SV & start agitator			
8	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
SV	Record: Time start <u>10:30</u> Total Min			
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 #2 (V-243) or #7 (V-244)			
8	13 Press SV Cam Reset PB-set 22TC in Auto Remote			
CP	temperature is set at 190-194F)			
3	14 Set levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 30% - preset #1 80 Gal		15-A	160
	b. 13LG 40% - 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	1840
	e. 8FC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water Ratio) 0.83			
SV	16 Operator Step PB			
SP	17 Record Level 2 LG <u>84</u> %. If below 35% follow solution			
8	make-up procedure for N-27-D			
CP	18 Adj to 48" (2470 G)			
4	19 Record pH <u>10.6</u>			
	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)	16	7-D	8
	Siphon into SV, Record pH <u>11.1</u>			
	21 Operator Step PB			

(JL)

V-244

JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT.	3490	LBS.	USE LBS.	N CODE	ACC LBS.
SV	22	SP Step 06/39	- After heat up Record: pH	10.0	(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	26	Switch 3FC10 to Auto.	Operator Step PB						
	27	SP Step 11/44	- When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote.						
	28	Operator Step PB							
	28	During strike, record pH & time as follows:							
		SP STEP							
		V-243/V-244	pH	Range	Time				
		13/46 (30 min)	9.7	9.0-10.0	2:25 AM				
		14/47 (60 min)	9.7	9.0-10.0	2:55				
		15/48 (2 hrs)	9.7	9.0-10.0	3:55				
		16/49 (2 hrs 25 min)	9.7	9.0-10.0	4:20				
		17/50 (3 hrs Final)	7.9	7.5-8.5	4:55 AM				
		NOTE: If not as specified notify Supervisor & note in log							
		If final pH is above 8.5, add 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	Add to 49" (382 G) at 80 - 100°F							
	32	Stir 5 min & record pH	9.7	(9.5-10.5)					
	33	Stir 15 min or longer to dissolve for SP Step 26							
	34	Record Vol 49" & calculate 49" (Vol) x 0.78 = 382 G							
	35	Set preset #8 to 382 G from S 34							
302	26	Add 30" (360 G) water to V-302							
7	27	Add & stir 2 min For S 41				Assume 50%	160	7-D	80
243	28	SP Step 17/50 - After checking pH, Operator Step PB							
	29	SIFT in 2 Bags				100	128-A	100	
SP	40	SP Step 23/53 - Record: pH	3.6	(3.7-4.2)					
&	41	Run in N-7-D from S 37 in 10-12 min & stir 5 min							
CP	42	Record: pH 9.4 (9.0-9.5) & if necessary add pH 9.0-9.5							
8		& 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							
	43	Operator Step PB							
	44	SP Step 29/58 Record: pH	9.4	(9.0-10.0)	Time 6:00 AM				
	45	Operator Step PB							
	46	SP Step 60 - Batch complete							
		Start	Finish						
		Time	SP Step	Time	SP Step				
		9:15 A		3:00 P		235 - 54			
		11:00 PM		6:00 AM		237-322			



