

S.V. 243 (244) Automated

C.V.

D.V.

MAKING INSTRUCTIONS: BATCH UNIT

CG 03 CODE KY-781-D PKG.

→ JAN 22 33961

EST. WGT. 1328 1128 LBS.

STD. HRS. TIME 11:00 M

14 YC-3-B 93 4 23357

14 YC-3-B 93 4 80365

14 YC-3-B 93 4 24420

Total Wgt. 4428# (Req

3.100)

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

V-244 MIT 12:30/PM

H01708 #3-20d Pass NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	1 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 62	66 x 50	YC-3-B 3300
1	Record: Start			3/00
	Fin			
	4 Add 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 37" & adj to 45" (1662 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 12" (200 G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
263	Record: Time Start 2:40 PM Total Min 2:40			
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 & CP	12 SP Step 01 - Set Formula Selector to position #1 (V-243) or #6 (V-244)			
3	13 Press SV Cam Reset PB-Set 22TC in Auto Remote (Temperature is set at 190-194°F)			
	14 Record levels and set Raw Material Counter #1 as follows:			
	a) 111G, 26% - 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) 8PC10 (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) 8FR20 (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 92% If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj SV to 54" (2800 G)			
4	19 Record: pH 9.7			
	20 Adj pH to 11.4-11.6 using Assume 50%	60	7-D	30
	(Dilute to 5% (10 parts water to 1 part N-7-D)			
	Siphon into SV. Record: pH 11.5			
	21 Operator Step PB			

N 27583

V-244

EQUIPMENT	PAGE	CG	03	CODE	KY-781-D	N	EST. WGT.	1128	LBS.	USE	N	ACCT
										LBS.	CODE	LBS.
SV	22	SP	Step 06/39.	After heat up Record:	pH	7.6	(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)	9.4	9.3-10.0	12:30						
			14/47 (60 min)	9.4	9.3-10.0	1:00 A						
			(2 hrs)	9.4	9.3-10.0	2:00 A						
			(3 hrs)	9.4	9.3-10.0	3:00 A						
			17.50 (Final)	9.4	7.5-8.5	3:45 A						
		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									
											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					✓	350-150		128-A		150
	34	Run in N-7-D from S 29 & stir	5 min									350
	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%	1.5		7-D		
		Siphon (if N-7-D) into SV. Record:	pH 4.25									
	37	Operator	Step PB									
	38	SP	Step 24/56 - Add N-978-A & stir 15 min					✓	20		978-A	20
	39	Operator	Step PB									
	40	SP	Step 60 - Batch Complete									
		START		FIN		OPTR						
		TIME	SP STEP	TIME	SP STEP							
		3:00 PM		11:00 PM		488-407						
		7:00 A		3:00 P		235						
		3:00 PM		11:00 P		407						
		11:00 P		5:00 A		126-201						
		Changed Input Valve - could not hold pressure										

