

MAR 12 34852

EST. WGT. 960 860 LBS.

STD. HRS. 8.8 TIME 7 A M
 14 YC-3-B 98 4 Lot 23860
 14 YC-3-B 98 4 Lot 24402
 14 YC-3-B 98 4 Lot

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

PUNCHED & CHECKED

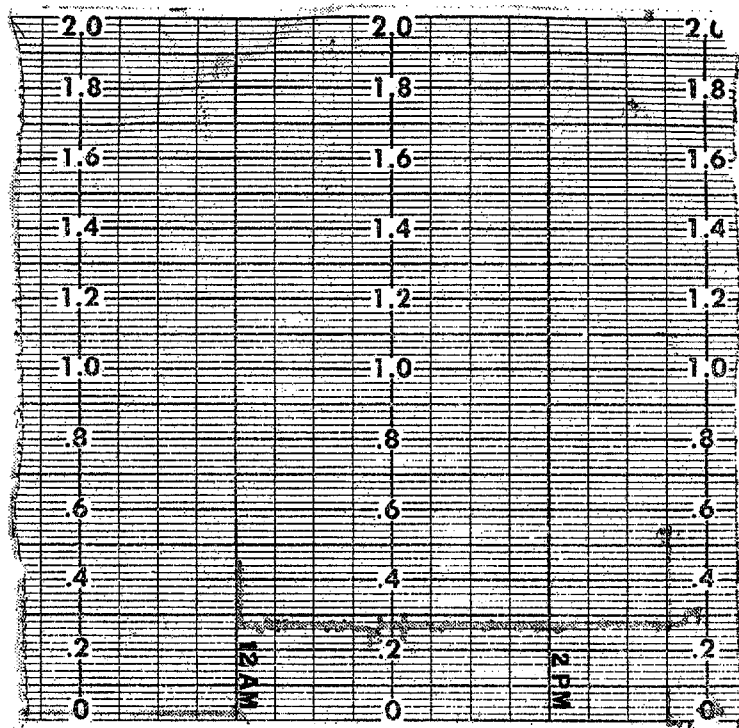
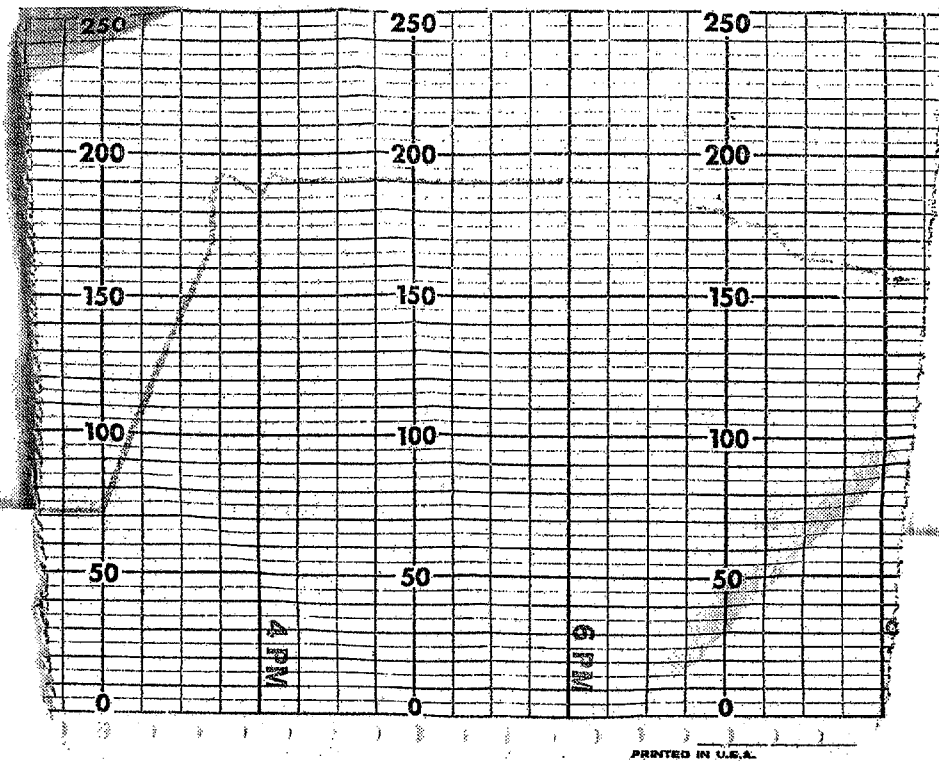
Total Wgt. 3560# 3460

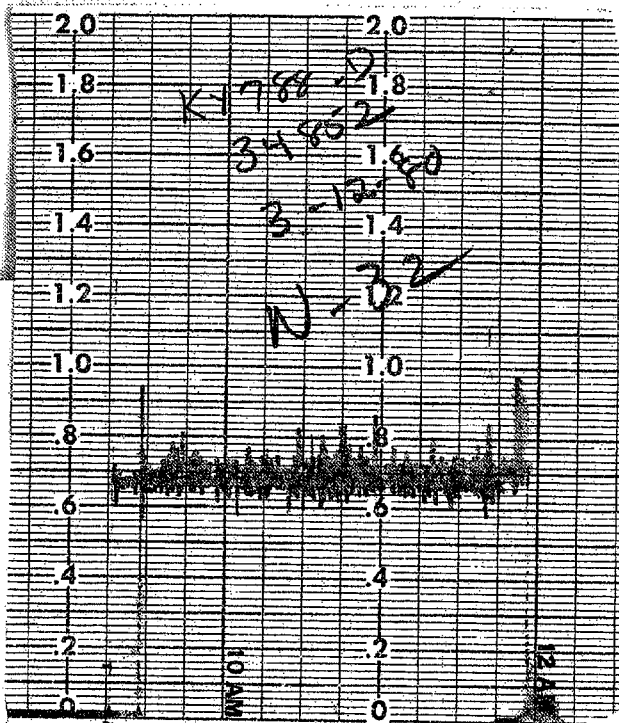
NON-BLEEDING

MENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" (4700 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	52 x 50	YC-3-B	2600
	Record: Start 2:40 AM 23860			
	Fin 5:30 AM 24402			
	75" (1275 G)			
	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 48 " & adj 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			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V- 243			
SV	Record: Time Start 8: AM total min 150			
2	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)			
&	13 Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
CP	14 Record levels and set Raw Material Counter #1 as follows			
3	a. 11LG 61 % - preset #2 208 Gal 15-A 416			
	b. 13LG 45 % - 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. 3FC20 (N-27-D Water) in Manual Local 4.4 GPM			
	c. 3FR10 (N-27-D/Water) Ratio 0.8			
	d. 8EC10 (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			
43	17 Record Level 21G 60 %. If below 35% follow solution			
SP	make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
CP	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%	28	7-D	14
	Siphon into SV & Record: pH 11.2			
	20 Operator Step PB			

V-243

ENT	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>9.6</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>9.5</u>	9.3-10.0	<u>12:30</u>		
	14/47 (60 min)	<u>7.5</u>	9.3-10.0	<u>1:00</u>		
	15/48 (2 hrs)	<u>9.5</u>	9.3-10.0	<u>2:00</u>		
	16/49 (2 hrs 25 min)	<u>7.5</u>	9.3-10.0	<u>2:25</u>		
	17/50 (Final 3 hrs)	<u>8.2</u>	7.5-8.5	<u>3:00</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 <u>7.5</u> Assume 77%				27-D	
28	While striking run 30" (234 G) water into V-339					
29	Add in 7-8 min			350	530-A	350
30	Adj to 49" (382 G) at 80-100 °F					
31	Stir 5 min & record pH <u>10.2</u> (9.5-10.5)					
32	Stir 15 min or longer to dissolve for SP Step 26/56					
33	Record Vol <u>51</u> " & Calculate <u>51</u> " (Vol X 0.78 = <u>39.8</u> G)					
34	Set preset #8 to <u>39.8</u> G from S 33					
35	Run 40" (440 G) water into V-302					
36	Add & stir 2 min for S 40 Assume 50%			360	7-D	180
37	SP Step 17/50 After checking pH. Operator Step PB					
38	Sift in 2 bags			-100	128-A	100
39	SP Step 23/53 Record: pH <u>3.7</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 <u>7.5</u> 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>7.0</u> (9.0-10.0) Time <u>4:30 PM</u>					
44	Operator Step PB					
45	SP Step 60 - Batch complete					
	Start	Finish	Optr			
	Time	Time	Time			
	<u>5:50 AM</u>	<u>7:00 AM</u>	<u>2:35</u>			
	<u>7:00 AM</u>	<u>2:00 PM</u>	<u>223-40</u>			
	<u>3:00 PM</u>	<u>4:30 PM</u>	<u>322</u>			





No. 215A164