

CG 03 CODE KY-788-D PKG.

MAR 11 34618 PUNCHED & CHECKED

EST. WGT. 960 860 LBS.

STD. HRS. 8.8 TIME
 14 YC-3-B 98 4 Lot 24403 450
 14 YC-3-B 98 4 Lot 24402 2150
 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		

Homog #3 - 1st Pass
 " " #3 - 2nd " "

Total Wgt. 3560# 3460

NON-BLEEDING

MENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" (2006) "KROLOR" YELLOW - LIGHT			
203	1 Run 23" (360 G) water into V-203- RUN AGITATOR ON HIGH SPEED			
203	2 Weigh in drum & pour in	345	32-D	345
203	3 Dump in & stir 5 min	52 x 50	YC-3-B	2600
	Record: Start 2:20 AM Lot 24403 450			
	Fin 3:55 AM 24402 2150			
	75" (12756)			
	Adj to 75" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 263			
	6 When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water 263			
	7 Record: V-205 Vol " & 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			
205	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time Start 5:10 AM total min 90			
	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			
CP	(Temperature is set at 190-194 F)			
3	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 5.3% - preset #2 208 Gal 15-A 416			
	b. 13LG 6.7% - 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. 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			
	16 Operator Step PB			
	17 Record Level 21G 88%. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.2. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% 20 7-D 10			
	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
24	SP Step 06/39 - After heat up Record: pH 9.8 (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)	9.6	9.3-10.0	10:15 A.M.				
	14/47 (60 min)	9.6	9.3-10.0	10:45 A.M.				
	15/48 (2 hrs)	9.6	9.3-10.0	11:45 A.M.				
	16/49 (2 hrs 25 min)	9.6	9.3-10.0	12:10 P.M.				
	17/50 (Final 3 hrs)	6.5	7.5-8.5	12:45 P.M.				
	Note: If not as specified notify Supervisor & Note in log							
	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	350
30	Adj to 49" (382 G) at 80-100 °F							
31	Stir 5 min & record pH 10.1 (9.5-10.5)							
32	Stir 15 min or longer to dissolve for SP Step 26/56							
33	Record Vol 4.9 " & Calculate 4.9 " (Vol X 0.78 = 38.2 G)							
34	Set preset #8 to 38.2 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	Stir in 2 bags					100	128-A	100
39	SP Step 23/53 Record: pH 3.8 (3.7-4.2)							
40	Run in N-7-D from S 36 in 10-12 min & stir 5 min							
41	Record: pH 9.3 (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 9.3 (9.0-10.0) Time 1:40 P.M.							
44	Operator Step PB							
45	SP Step 60 - Batch complete							
	Start	Finish	Optr					
	Time SP Step	Time SP Step						
	7:00 A.M.	7:00 A.M.	235-342					
		2:00 P.M.	381-223					
	Pump To VAT 240							





