

S.V. 243, 244 Automated

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 03 CODE KY-781-D

PUNCHED & CHECKED

→ FEB 23 34500

EST. WGT. 1128 LBS.

FEB 26 1980

OIC
K/P

STD. HRS. TIME 30 M

14 YC-3-B 93 4 2423 2000 #

14 YC-3-B 93 4 23864 1100 #

14 YC-3-B 93 4 #

Total Wgt. 4428# (Req)

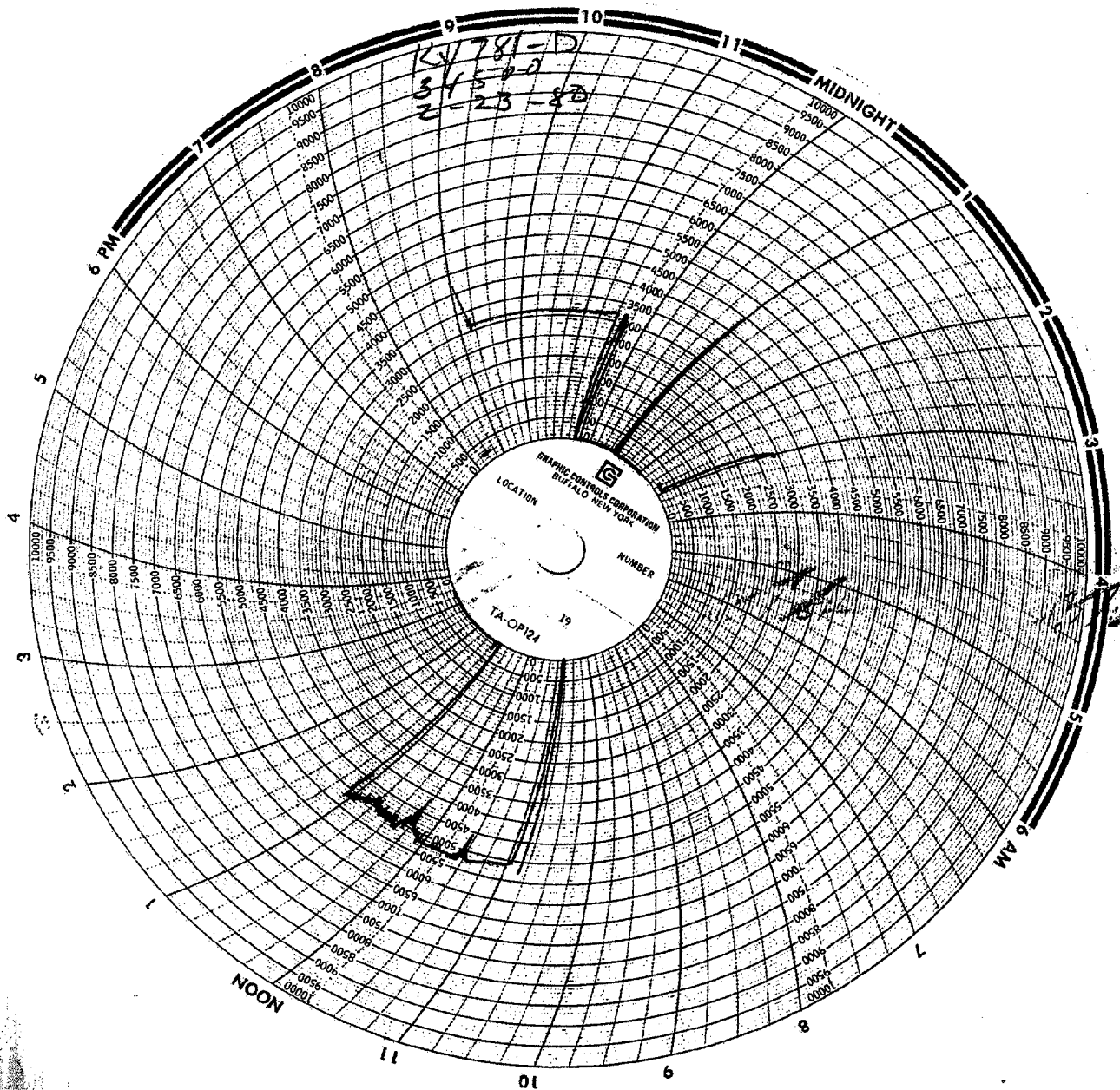
NON-BLEEDING

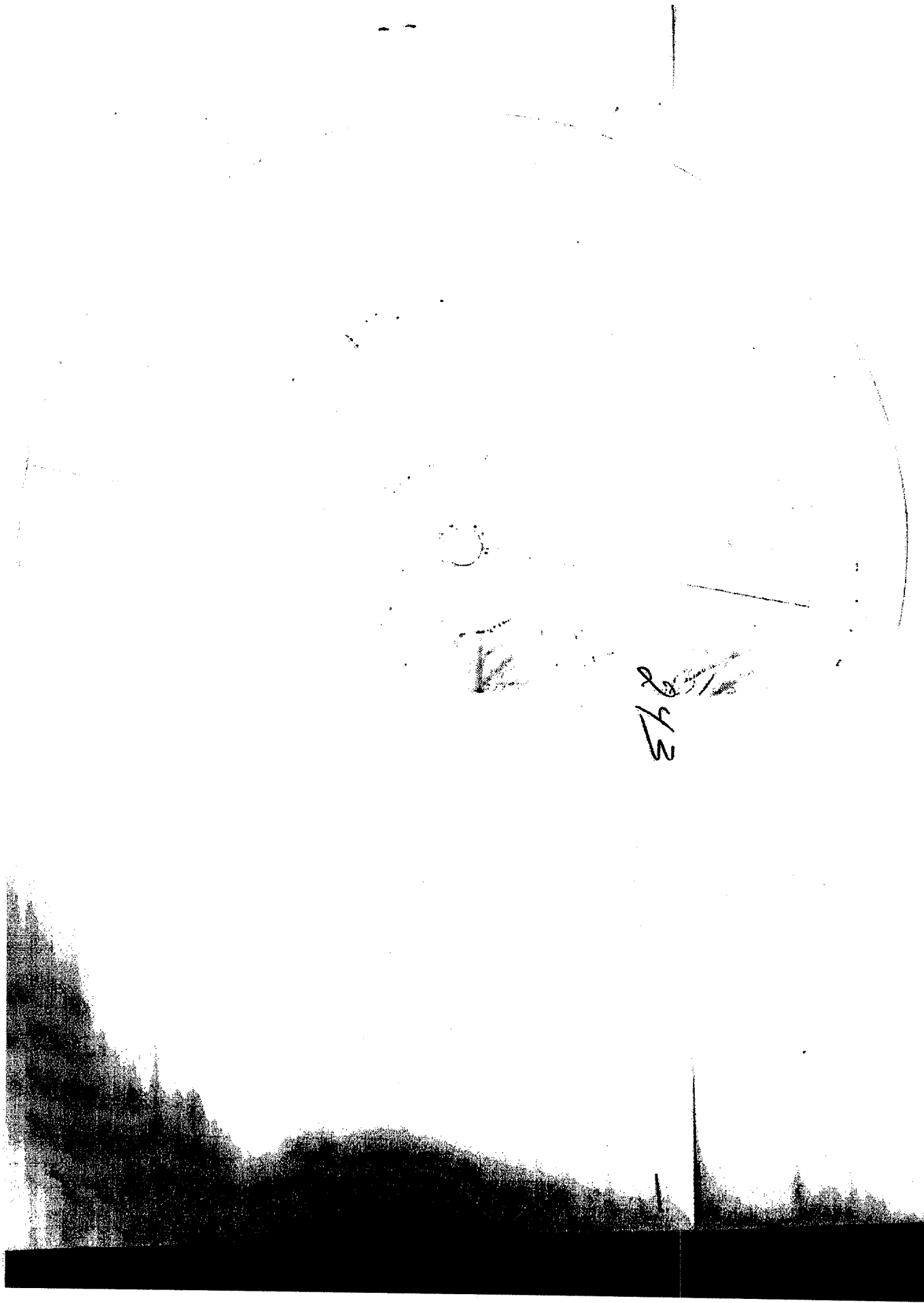
EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	Run 60" (992 G) water in V-203 & add	Assume 50%	36	7-D 18
&	2 Weigh in drum & pour in		442	32-D 442
205	3 Dump in & stir 5 min with agitator on high speed	Lot 62	68 x 50	YC-3-B 2300
1	Record: Start 6:35 PM	24,422	2,000	3,100
	Fin 7:45 PM	23,864	1,100	
	75" (2756) #2400-2600			
	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 54" & adj to 45" (1662 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED			
205	9 Run 12" (200 G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
2	Record: Time Start 1:15 PM Total Min 135			
	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 #1 (V-243) or #6 (V-244)			
CP	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) 11G 70% - 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) 8FC10 (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) 8FC20 (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 68%. If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj SV to 54" (2800 G)			
	19 Record: pH 10.3			
	20 Adj pH to 11.4-11.6 using Assume 50%	30	7-D	15
	(Dilute to 5% (10 parts water to 1 part N-7-D))			
	Siphon into SV. Record: pH 11.5			
	21 Operator Step PB			

N 27567

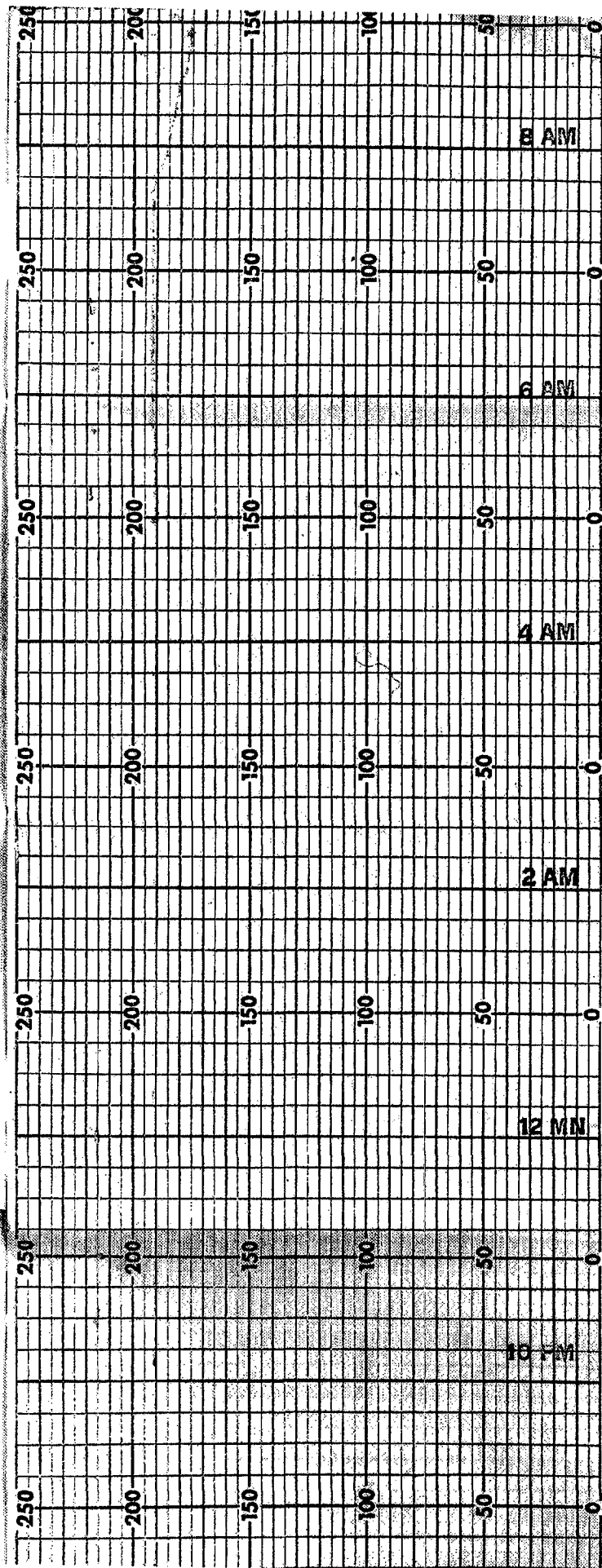
243

EQUIPMENT	PAGE 2 CG 03 CODE KY-781-D N EST. WGT.	1128 LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22 SP Step 06/39. After heat up Record: pH 7.9 (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	713.0 A			
	27 During Strike, Record pH & Time as follows:				
	SP Step pH Range Time				
	13/41 (30 min) 7.9 9.3-10.0 8:00 AM				
	14/47 (60 min) 7.8 9.3-10.0 8:30				
	(2 hrs) 7.8 9.3-10.0 9:30				
	(3 hrs) 7.8 9.3-10.0 10:30				
	17.50 (Final) 8.2 7.5- 8.5 11:15 AM				
	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				
	M %			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	300 150	128-A	450	
	34 Run in N-7-D from S 29 & stir 5 min			350	
	35 Record: pH 4.4 (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%			7-D	
	Siphon (if N-7-D) into SV. Record: pH				
	37 Operator Step PB				
	38 SP Step 24/54 - 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				
	8 PM 11:00 AM 11 PM 7:00 AM	282-438			
	7:00 AM	237.37			





26/43



BUFFALO

GRAPHIC CONTROLS CORPORATION

No. 315A350