

PUNCHED &amp; CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

s.v. 243, 244, Automated

APR 25 1980

D.V.

CG 03 CODE KY-781-D PKG.

APR 23 35491

EST. WGT. 1128 LBS.

STD. HRS. TIME 7P M

14 YC-3-B 93 4 24696 2000 #

14 YC-3-B 93 4 24729 1300 #

14 YC-3-B 93 4 #

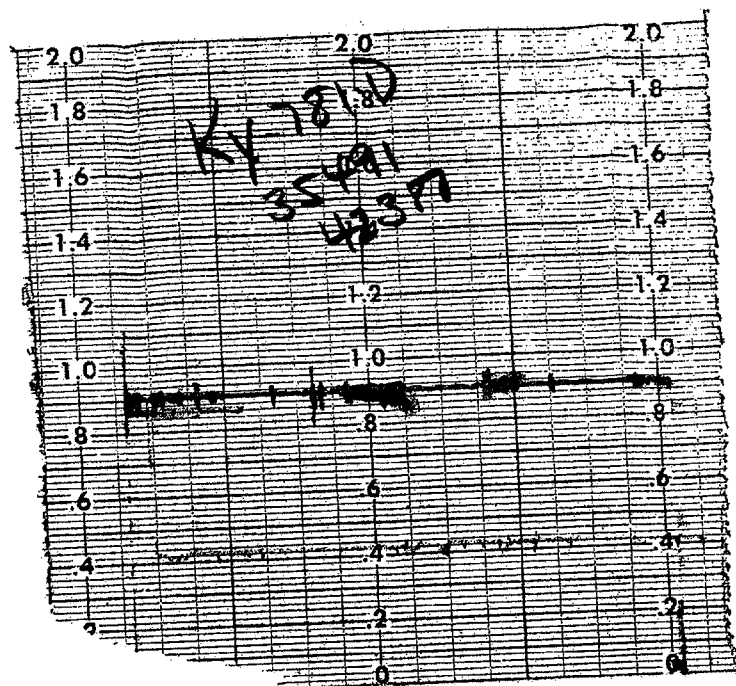
Total Wgt. 4428# (Req )

NON-BLEEDING

| EQUIPMENT  | NAME                                                                                       | USE LBS. | N CODE | ACCT. LBS. |
|------------|--------------------------------------------------------------------------------------------|----------|--------|------------|
| 203        | KROLO® YELLOW LIGHT                                                                        |          |        |            |
| 203        | 1 Run 60" (492 G) water in V-203 & add Assume 50%                                          | 36       | 7-D    | 18         |
| 203        | 2 Weigh in drum & pour in                                                                  | 442      | 32-D   | 442        |
| 203        | 3 Dump in & stir 5 min Lot                                                                 | 66 x 50  | YC-3-B | 3300       |
| 203        | Record: Start 4:PM                                                                         | 24696    | 2000   |            |
| 203        | Fin 5:PM                                                                                   | 24729    | 1300   |            |
| 203        | 75" (127561) 2466-2666                                                                     | 3300     |        |            |
| 203        | 4 Add to 80" (1360 G) & Record: pH 10.5 (10.5-11.5)                                        |          |        |            |
| 203        | 5 Pump V-203 thru Homog # at 1800-2200 psi into V-205                                      |          |        |            |
| 203        | 6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water                |          |        |            |
| 203        | 7 Record: V-205 Vol & adj to 45" (1662 G)                                                  |          |        |            |
| 203        | 8 Inspect Homog strainer & clean if necessary                                              |          |        |            |
| 203        | DURING HOMOG. RUN V-203 AGITATOR ON LOW SPEED                                              |          |        |            |
| 205        | 9 Run 12" (200 G) water into SV & start agitator                                           |          |        |            |
| 205        | 10 Pump V-205 thru Homog at 4800-5200 psi into V-243                                       |          |        |            |
| 205        | Record: Time Start 10:15 PM Total Min 120                                                  |          |        |            |
| 205        | NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205 |          |        |            |
| 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)         |          |        |            |
| 3          | 14 Record levels and set Raw Material Counter #1 as follows:                               |          |        |            |
| 3          | a) 11G 15% - preset #3 187 Gal                                                             |          | 15-A   | 374        |
| 3          | 15 Set stroke flow controllers as follows:                                                 |          |        |            |
| 3          | a) 3FC10 (N-27-D Controller) in Manual 0.9 GPM                                             |          | 27-D   | 373        |
| 3          | b) 3FC20 (N-27-D Water) in Manual Local 6.3 GPM                                            |          |        |            |
| 3          | c) 3FR10 (N-27-D / Water Ratio) 0.7                                                        |          |        |            |
| 3          | d) 3FC10 (N-32-D Controller) in Manual 1.20 GPM                                            |          | 32-D   | 2527       |
| 3          | e) 3FC20 (N-32-D Water) in Manual Local 5.4 GPM                                            |          |        |            |
| 3          | f) 3FC20 (N-32-D Water) in Remote                                                          |          |        |            |
| 3          | g) 3FR10 (N-32-D / Water Ratio) 0.9                                                        |          |        |            |
| SV SP & CP | 16 Operator Step PB                                                                        |          |        |            |
| 4          | 17 Record Level 2LG 73%: If below 35% follow solution make-up procedure for N-27-D         |          |        |            |
| 4          | 18 Adj 5V SV to 54" (2800 G)                                                               |          |        |            |
| 4          | 19 Record: pH 10.6                                                                         |          |        |            |
| 4          | 20 Adj pH to 11.4-11.6 using Assume 50%                                                    | 30       | 7-D    | 15         |
| 4          | (Dilute to 5% (10 parts water to 1 part N-7-D) Siphon into SV. Record: pH 11.4             |          |        |            |
| 4          | 21 Operator Step PB                                                                        |          |        |            |

V-243

| EQUIPMENT | PAGE 2 | CO 03                                                                                                                            | CODE                                     | KY-781-B | N EST. WGT. | 1128 LBS. | USE LBS. | N CODE | ACCT. LBS. |
|-----------|--------|----------------------------------------------------------------------------------------------------------------------------------|------------------------------------------|----------|-------------|-----------|----------|--------|------------|
| SV        | 22     | SP Step 06/39.                                                                                                                   | After heat up Record: pH 10.1 (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         | 26     | switch 3FC10 to Auto. Operator Step PB                                                                                           |                                          |          |             |           |          |        |            |
|           | 27     | SP Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20                                                                  |                                          |          |             |           |          |        |            |
|           | 28     | to Remote. Operator Step PB                                                                                                      |                                          |          |             |           |          |        |            |
|           | 29     | During Strike, Record pH & Time as follows:                                                                                      |                                          |          |             |           |          |        |            |
|           |        | SP Step                                                                                                                          | pH                                       | Range    | Time        | 3:50 A.M. |          |        |            |
|           |        | 13/41 (30 min)                                                                                                                   | 10.0                                     | 9.3-10.0 | 3:30 A.M.   |           |          |        |            |
|           |        | 14/47 (60 min)                                                                                                                   | 9.8                                      | 9.3-10.0 | 4:00 A.M.   |           |          |        |            |
|           |        | (2 hrs)                                                                                                                          | 9.9                                      | 9.3-10.0 | 5:00 A.M.   |           |          |        |            |
|           |        | (3 hrs)                                                                                                                          | 9.9                                      | 9.3-10.0 | 6:40 A.M.   |           |          |        |            |
|           |        | 17:50 (Final)                                                                                                                    | 7.4                                      | 7.5- 8.5 | 6:45 A.M.   |           |          |        |            |
|           |        | 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         |
|           | 30     | SP Step 17/50 after checking pH. Operator PB                                                                                     |                                          |          |             |           |          |        |            |
|           | 31     | SP Step 23/53 Record: pH 3.4 (3.3-3.7)                                                                                           |                                          |          |             |           |          |        |            |
|           | 32     | If necessary adj pH (DOWN ONLY) Record: pH                                                                                       |                                          |          |             |           |          | 15-A   |            |
|           |        | NOTE: Dissolve extra N-15-A in water at 110-120°F in drum. Use ±30 Gal of water to 50% N-15-A. Stir 5V 5 min after each addition |                                          |          |             |           |          |        |            |
|           | 33     | SP Step 18                                                                                                                       |                                          |          |             |           | ✓ 150    | 128-A  | 150        |
|           | 34     | Run in N-7-D from S 29 & stir 5 min                                                                                              |                                          |          |             |           |          |        |            |
|           | 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 <sub>2</sub> O to 1 part N-7-D) or N-27                           |                                          |          |             |           |          |        |            |
|           |        |                                                                                                                                  |                                          |          |             |           |          | 27-D   |            |
|           |        |                                                                                                                                  |                                          |          | Assume 50%  |           |          | 7-D    |            |
|           |        | Strapon (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      |             | QPTR      |          |        |            |
|           |        | TIME                                                                                                                             | SP STEP                                  | TIME     | SP STEP     |           |          |        |            |
|           |        | 8:00 P                                                                                                                           |                                          | 11:00 P  |             | 235-237   |          |        |            |
|           |        | 11:00 A.M.                                                                                                                       |                                          | 2:00 P   |             | 381-30    |          |        |            |
|           |        | 1:00 P                                                                                                                           |                                          |          |             | 123-201   |          |        |            |

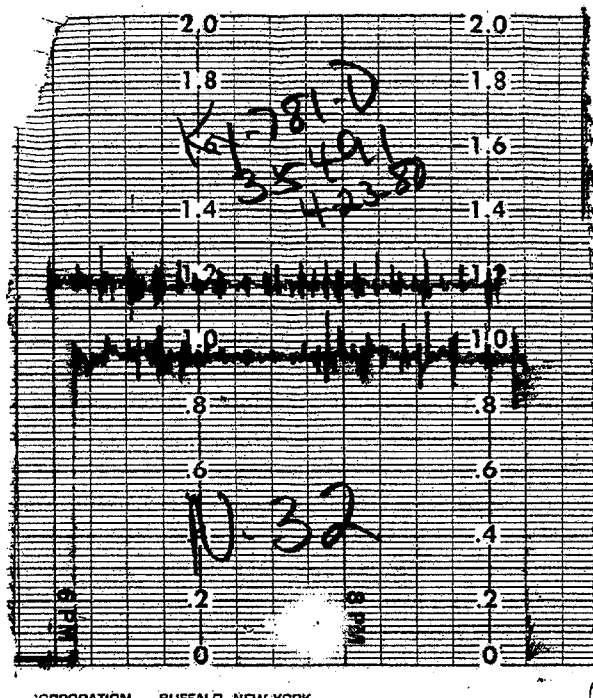


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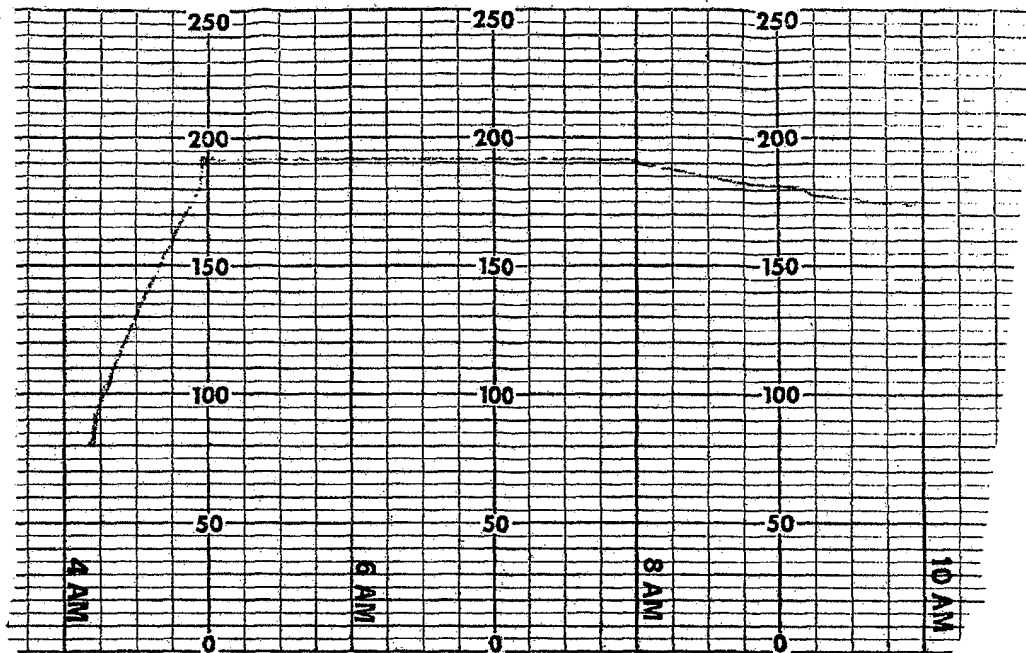
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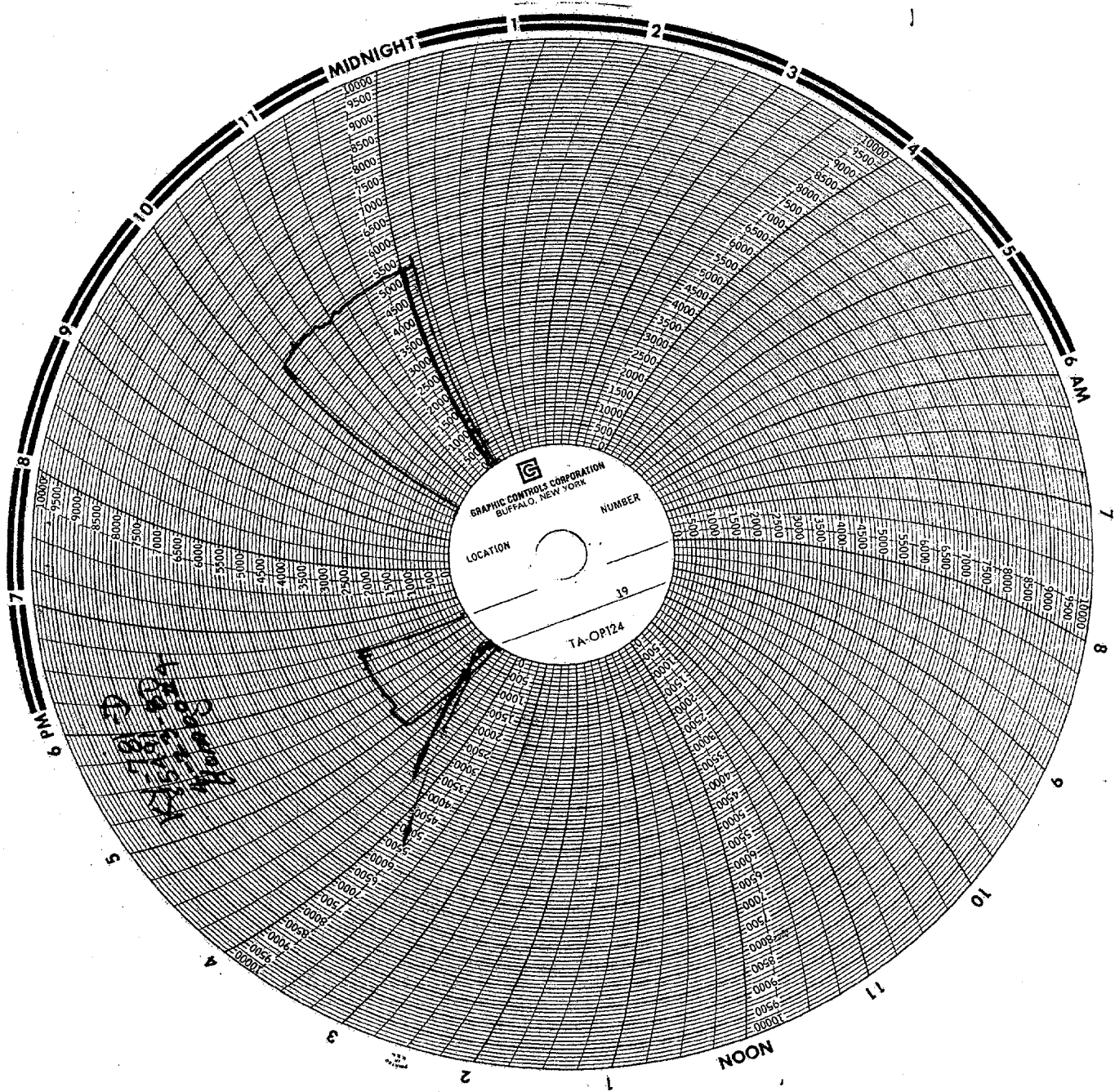
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