

S.V. 243 244. Automated

C.V.

D.V.

CG 03 CODE KY-781-D PKG
 → FEB23 34501
 EST. WGT. 1328 LBS.

PUNCHED & CHECKED

FEB 26 1980

STD. HRS. TIME

14 YC-3-B 93 4 24417 3100 #
 14 YC-3-B 93 4 #
 14 YC-3-B 93 4 #

PROCESSES	APPROVED BY
() KY-781-D(N)	FWP 101378
()	() AMJ 101378
()	()
()	()
TYPED BY	
EMW101378	

Total Wgt. 4428# (Req)

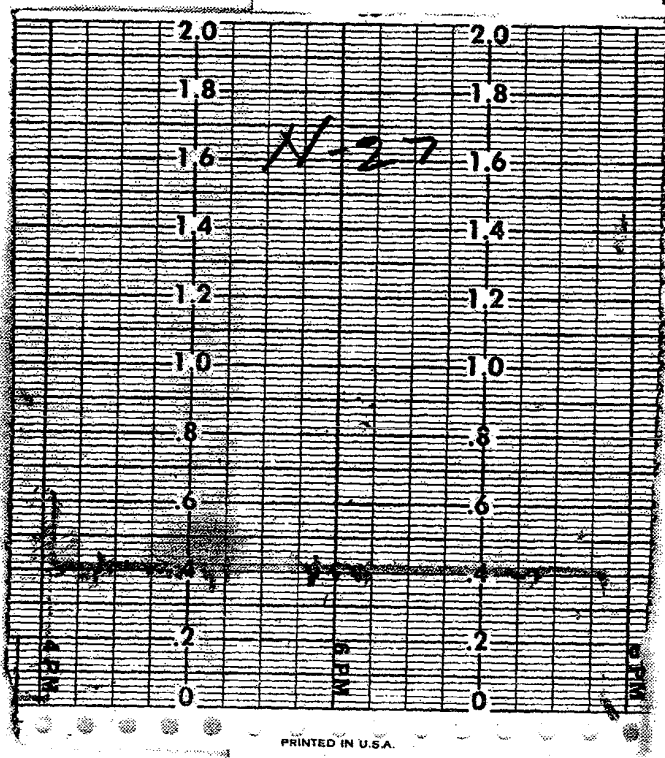
NON-BLEEDING

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 with Agitator on high speed.	Lot 62	68x50	YC-3-B 3300
1	Record: Start 11:15 PM			3100
	Fin 12:30 AM			
	75" (12256)			
	Adj to 60" (1260 G) & Record: pH (10.5-11.5)			
	4 Pump V-203 thru Homog # at 1800-2200 psi into V-205			
	5 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water			
	6 Record: V-205 Vol 40" & adj to 45" (1662 G)			
	7 Inspect Homog strainer & clean if necessary			
	DURING HOMOG. RUN V-203 Agitator on low speed.			
205	8 Run 12" (200 G) water into SV & start agitator			
&	9 Pump V-205 thru Homog at 4800-5200 psi into V- 243			
SV	Record: Time Start 12:15 PM Total Min			
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) 11LG 43% - 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 & CP	17 Record Level 2LG 38%. If below 35% follow solution make-up procedure for N-27-D			
4	18 Adj SV to 54" (2800 G)			
	19 Record: pH 10.3			
	20 Adj pH to 11.4-11.6 using Assume 50%	32	7-D	16
	(Dilute to 5% (10 parts water to 1 part N-7-D)			
	Siphon into SV. Record: pH 11.4			
	21 Operator Step PB			

PUMP TO 240VET

EQUIPMENT	PAGE 2	CG 03 CODE KY-781-D	N EST. WGT. 1128 LBS.	USE LBS.	N CODE	ACCT LBS.
SV SP & CP 5	22	SP Step 06/39. After heat up Record: pH <u>9.9</u> (9.6-10.2)				
	23	Switch 3FC20, 8FC10, 8FC20, to Auto				
	24	Operator Step PB				
	25	SP Step 10.43 - When 3FC20, 8FC10, 8FC20 water flow in limits				
	26	Switch 3FC10 to Auto. Operator Step PB				
	26	SP Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20				
	27	to Remote. Operator Step PB				
	27	During Strike, Record pH & Time as follows:				
		SP Step	pH	Range	Time	
		13/41 (30 min)	<u>9.8</u>	9.3-10.0	<u>4:00</u>	
V-302 6	14/47 (60 min)	<u>9.8</u>	9.3-10.0	<u>4:30</u>		
		(2 hrs)	<u>9.8</u>	9.3-10.0	<u>5:30</u>	
		(3 hrs)	<u>9.8</u>	9.3-10.0	<u>6:30</u>	
		17.50 (Final)	<u>7.5</u>	7.5-8.5	<u>7:15</u>	
		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
	28	Add 31" (379 G) water to V-302				
	29	Add & stir 5 min <u>DR</u>				
				Assume 50%	124	7-D 62
	30	SP Step 17/50 after checking pH. Operator PB				
SV SP & CP 7	31	SP Step 23/53 Record: pH <u>3.7</u> (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 SV 5 min				
		after each addition				
	33	Sift in				352-150 128-A 150
	34	Run in N-7-D from S 29 & stir 5 min				352
	35	Record: pH <u>4.2</u> (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			
		<u>7:00 AM</u>	<u>7:00 AM</u>	<u>27</u>		
		<u>3:00 PM</u>	<u>3:00 PM</u>	<u>237-1320</u>		
				<u>438-709</u>		
PUMP TO 240 VET						

DUP050094822



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