S.V. 243, (244) Automated C.V. D.V.

CG 03 CODE KY-781-D PKG. ____

→ JAN 19 33894

EST. WGT. 1178 ~~1128~~ LBS.

STD. HRS. ____ TIME 11P M

PROCESSES	APPROVED BY
( ) KY-781-D (N)	FWP 101378
( ) ( )	AMJ 101378
( ) ( )	
( ) ( )	
TYPED BY emw101378	

OK FP SL

14 YC-3-B 93 4 24425 3100 #

14 YC-3-B 93 4 24421 200 #

14 YC-3-B 93 4 ____ ____ #

Homog #4 - 1ST Pass

4478 Total Wgt. ~~4428~~# (Req ____)

NON-BLEEDING

QUIPMENT		NAME: KROLOR® YELLOW LIGHT		USE LBS.	N CODE	ACCT. LBS.
203 & 205	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
	3	Dump in & stir 5 min	Lot	66 x 50	YC-3-B	3300
263 1		Record: Start 945 AM	24425	3100		
		Fin 11:30 AM	24421	200		
		75" (1375 G) (2400-2600)				
	4	Adj to ~~80" (1360 G)~~ & Record: pH (10.5-11.5)				
	5	Pump V-203 thru Homog # at ~~1800-2200~~ psi into V-~~205~~ 263				
	6	When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water 263				
	7	Record: V-~~205~~ Vol 39 " & adj to 45" (1662 G)				
	8	Inspect Homog strainer & clean if necessary				
205	9	Run 12" (200 G) water into SV & start agitator				
263 & 8V 2	10	Pump V-205 thru Homog at 4800-5200 psi into V-244				
		Record: Time Start 10:45 pm Total Min 210				
		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 3	12	SP Step 01 - Set Formula Selector to position #1 (V-243) or #6 (V-244)				
	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 66 % - 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 SP & CP 4	16	Operator Step PB				
	17	Record Level 2LG 60 %. If below 35% follow solution make-up procedure for N-27-D				
	18	Adj 50 SV to 54" (2800 G)				
	19	Record: pH 10.7				
	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 11.4				
	21	Operator Step PB				

SL

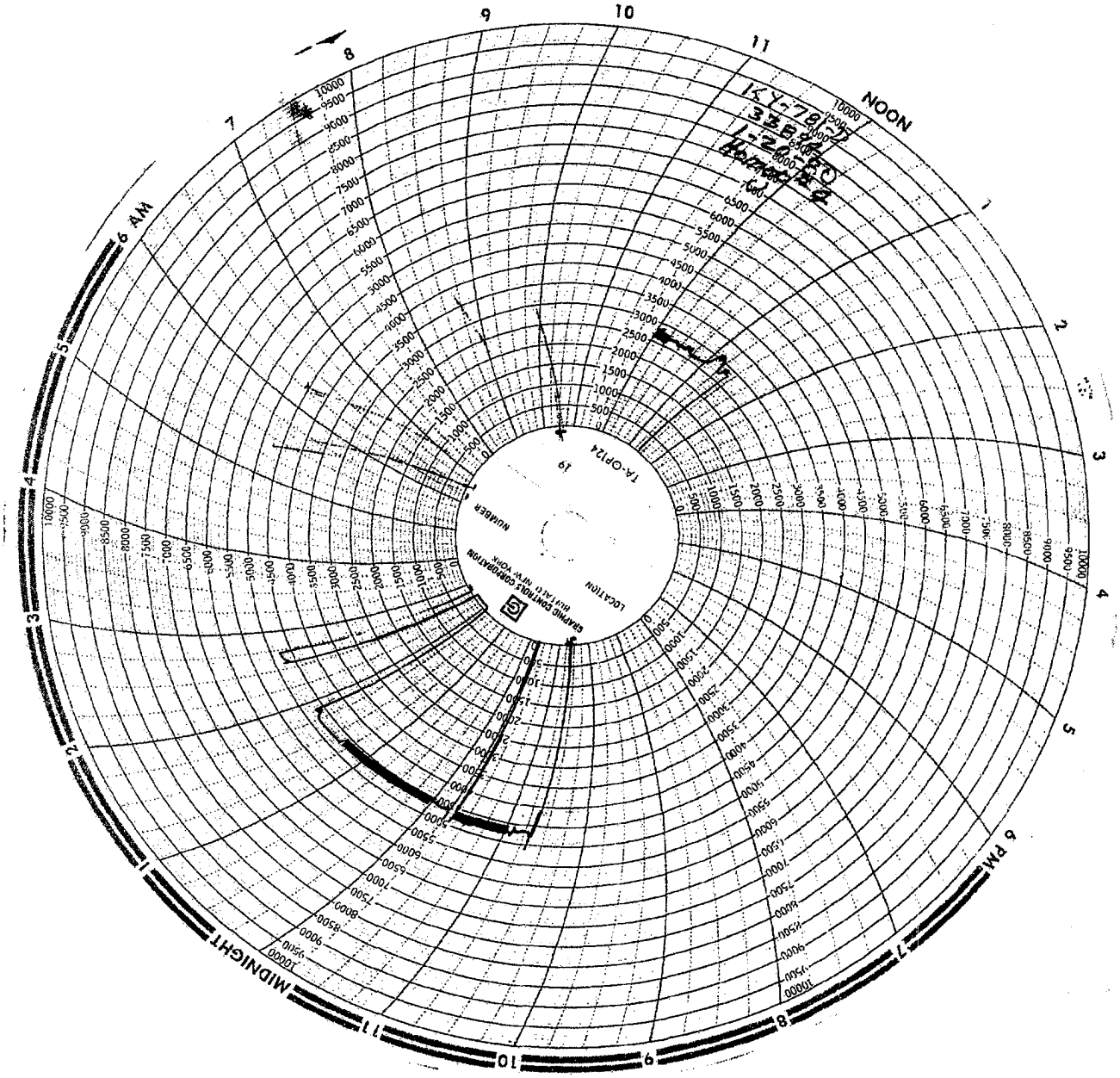
N 264

V-244

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 10.0 (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 4:15 AM			
	27	During Strike, Record pH & Time as follows:			
		SP Step / pH / Range / Time			
		13/41 (30 min) 10.0 9.3-10.0 4.45 AM			
		14/47 (60 min) 10.0 9.3-10.0 5.15 AM			
		(2 hrs) 10.0 9.3-10.0 6.15 AM			
		(3 hrs) 10.0 9.3-10.0 7.15 AM			
		17.50 (Final) 7.9 7.5- 8.5 8.00 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 3.45 (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			200
	33	Sift in 200 ~~150~~	200 ~~150~~	128-A	~~150~~
	34	Run in N-7-D from S 29 & stir 5 min			
	35	Record: pH 4.0 (4.2-4.4)			
	36	If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts H_2O to 1 part N-7-D) or N-27			
		M ____ . ____ %		27-D	
		Assume 50%	18	7-D	9
		Siphon (if N-7-D) into SV. Record: pH 4.2			
	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	
11:30A		3:00PM		235
7:00AM		8:50AM		235

DUP050094224



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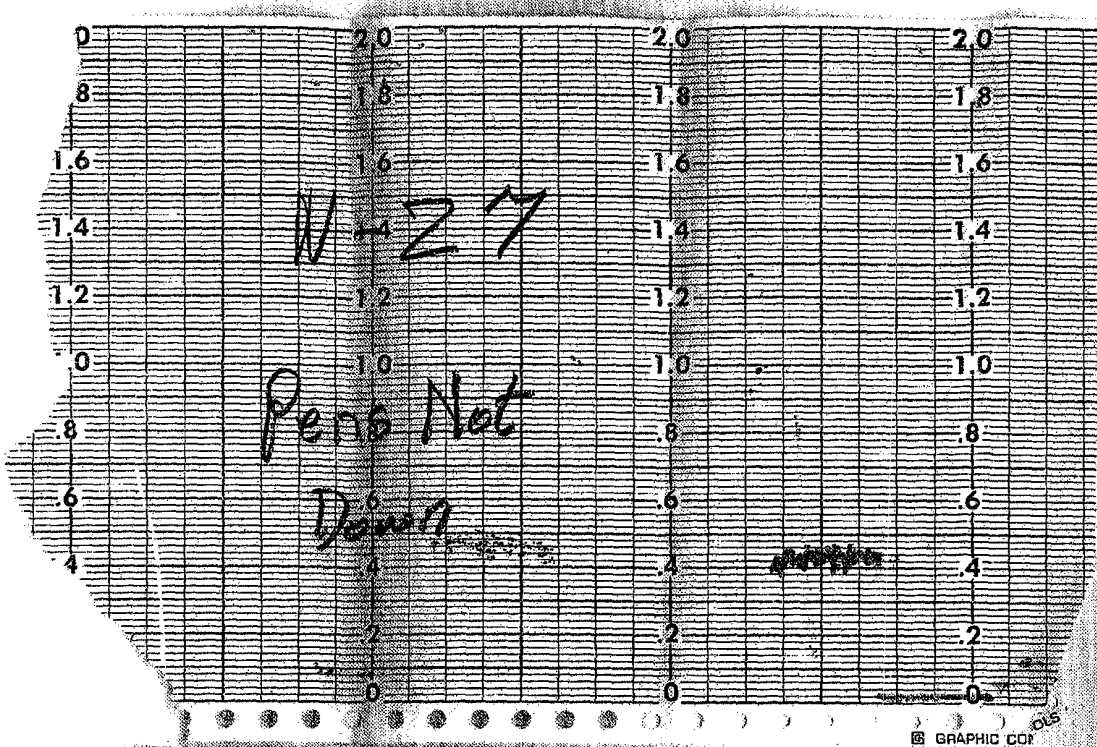

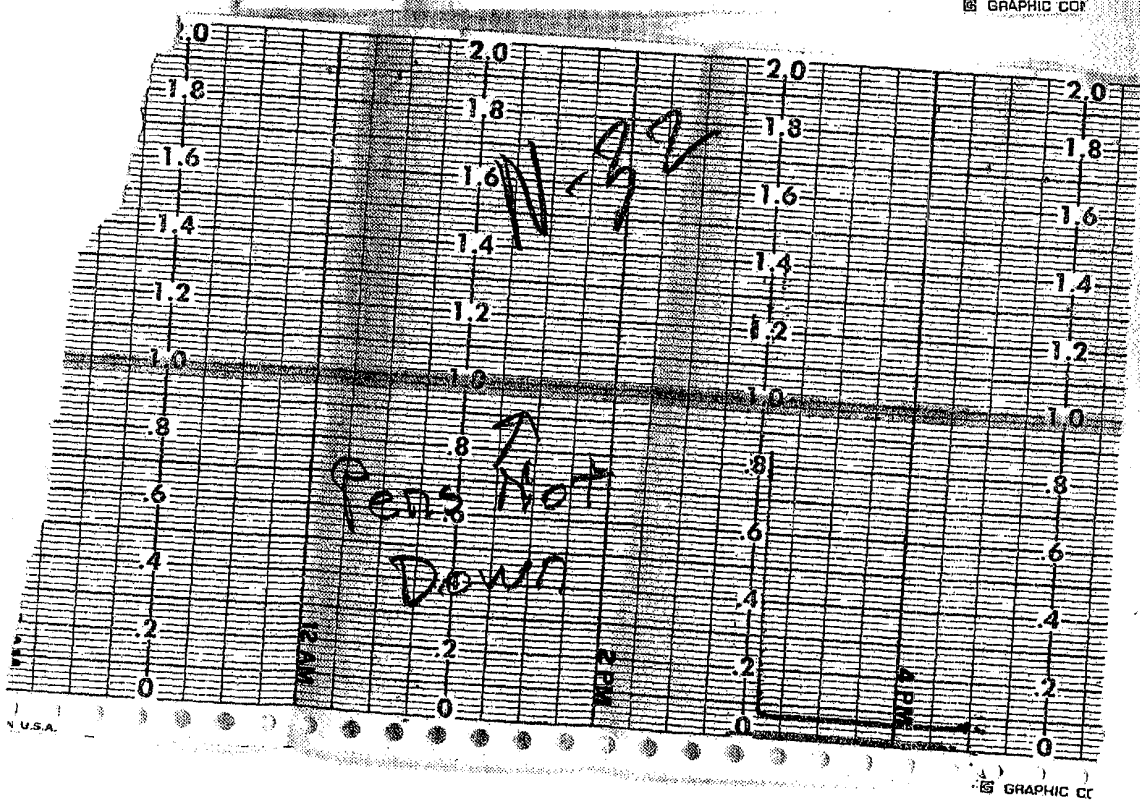

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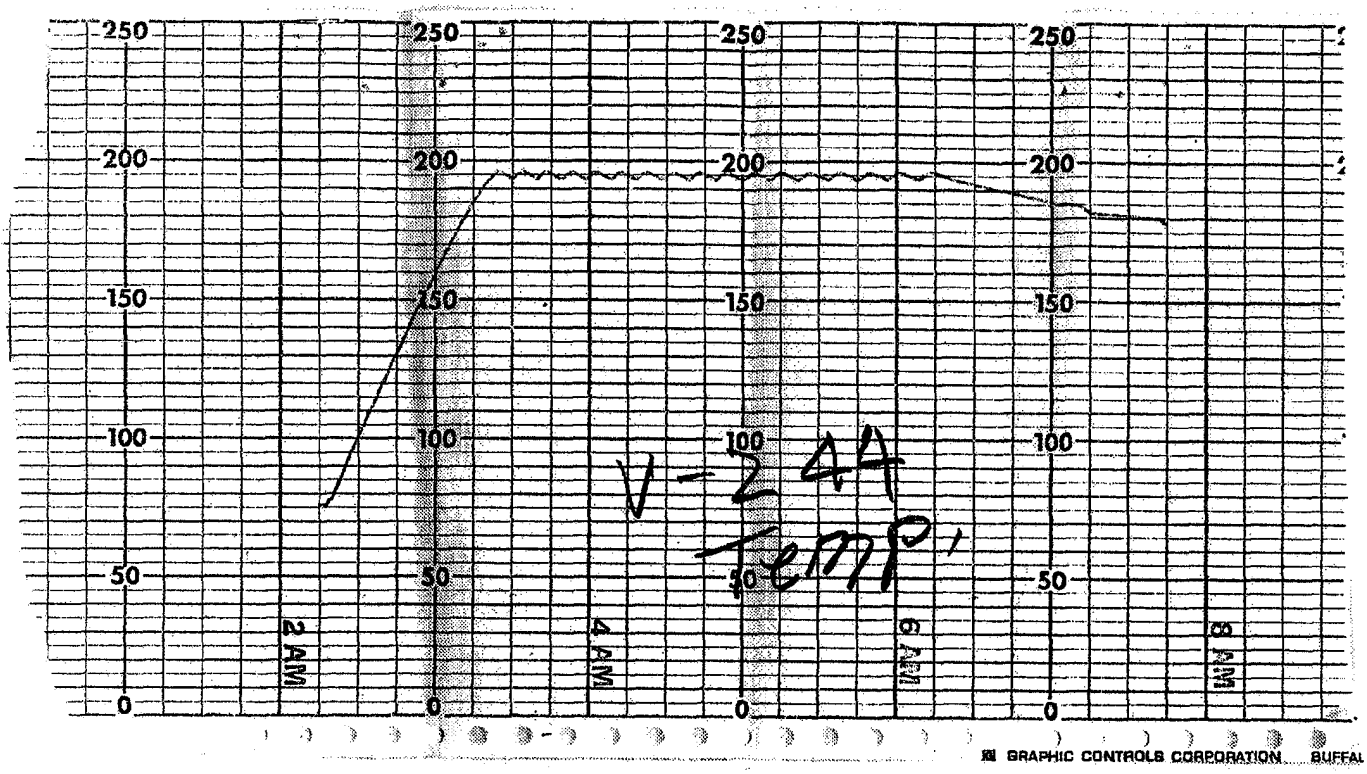
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200
150
100
50
0
2 AM
4 AM
6 AM
8 AM
V-2 AA
Temp
GRAPHIC CONTROLS CORPORATION BUFFAL