

MAICE 1ST PASS+HOLD TILL 4/28 V-205

MAKING INSTRUCTIONS: BATCH UNIT

243 (244) (Automated)

CG 03 CODE KY-795-D PKG.

PUNCHED & CHECKED

1ST. WGT 880 1110 1B

STO. HRS 8.2 TIME 3:00 M

14 YC-2-B 93 4 Lot 24769, 2000#

14 YC-2-B 93 4 Lot 24775, 1500#

14 YC-2-B 93 4 Lot _____, _____#

Total Wgt. 4612# 4380

D.V.

PROCESSES

() KY-795-D

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TYPED BY

emw122278

APPROVED BY

() LWK 10-05-76

() DCG 10-07-76

() MIW 10-11-76

() FWP 12-22-78

Homog# 3-1ST Pass

APR 28 1980

NON-BLEEDING

PMENT	NAME: KROLOR® YELLOW MEDIUM	USE LBS.	N	ACCT. LBS.
203 & 205	1 Run 60" (992 G) water into V-203 SET AGITATOR ON HIGH SPEED			
	2 Weigh in drum & pour in	475	32-D	475
	3 Dump in & stir 5 min	70 x 50	YC-2-B	3500
1	Record: Start 3:30 P.M.	24769		
	Fin 5: P.M.	24775		
	75" (1275 G)	2000		
	4 Adj to 78" (1328 G)	3500		
	5 Pump V-203 thru Homog at 2400-2600 psi into V-205			
	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7 Record: V-205 Vol 42" & adj to 51" (1874 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 Run 10" (514 G) water into V-244 & start agitator			
205 & SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
	Record: Time Start 7:10 AM Total Min 120			
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. Rinse in using Hot Water			
SP & CP	12 SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (V-244)			
	13 Press SV Cam Reset PB set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
3	14 Record levels and set Raw Material Counter #1 as follows:			
	a. 11 LG 72 % - preset #1	104 Gal	15-A	208
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.71 0.95 GPM		27-D	296
	b. 3FC20 (N-27-D Water) in Manual Local 5.8 7.7 GPM			394
	c. 3FR10 (N-27-D / Water Ratio)	0.8		1885
	d. 8FC10 (N-32-D Controller) in Manual 0.90 1.27 GPM		32-D	2075
	e. 8FC20 (N-32-D Water) in Manual Local 5.4 6.2 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D / Water) Ratio	1.0		
SV & CP	16 Operator: Step PB			
	17 Record Level 2LG 86 % if below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 68" (3495 G)			
4	19 Record: pH 10.2 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
	Siphon N-7-D into SV & Record: pH 11.4			
	20 Operator: Step PB			

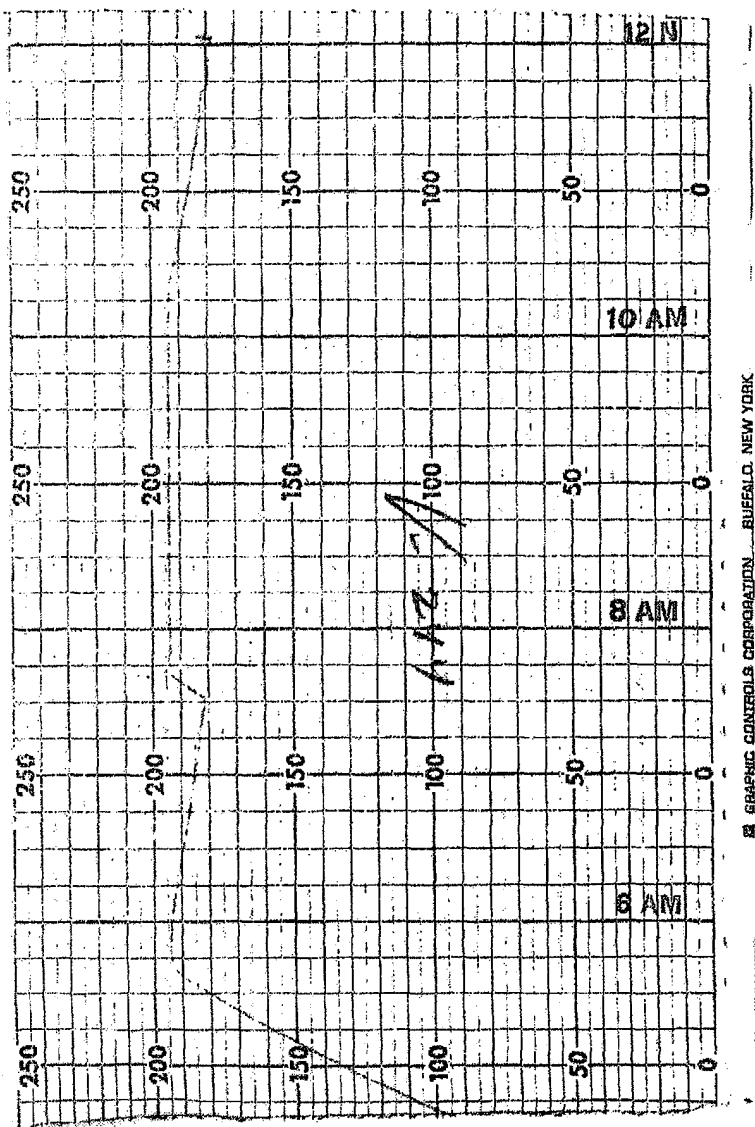
REV.

DUID050456237

244

AT 3:55 PM ADVANCE
TO STEP 48 FOR FILLINGADVANCE TO STEP 50 AT 4:21 PM
4612 LBS.

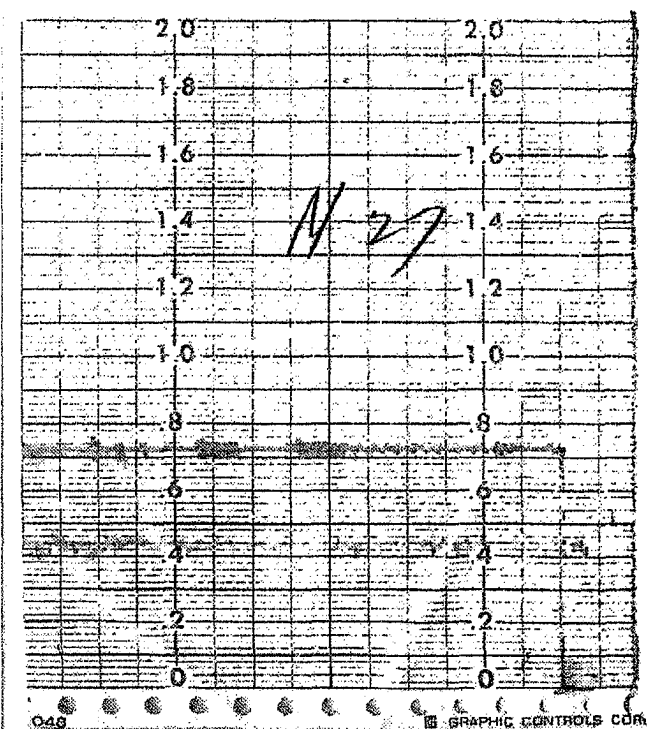
EQUIPMENT		PAGE 2	CG 03 CODE KY-795-D (H) EST. WGT.		4612 LBS.	USB LBS.	N CODE	ACC LBS
SV SP & CP	5	21	SP Step 06/39 - After heat up Record: pH 10.0 (9.5-10.0)					
		22	Switch 3FC20, 8FC10, 8FC20, to Auto					
		23	Operator Step PB					
		24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits switch 3FC10 to Auto, Operator Step PB					
		25	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote					
Drum	7	26	Operator Step PB					
		27	During Strike, Record pH & Time as follows:					
			SP Step					
			V-243/V-244	pH	Range	Time/2:35		
			13/46 (30 min)	10.0	9.0-10.0	1:05 PM		
SV SP & CP	8			14/47 (60 min)	10.0	9.0-10.0	1:35 PM	
				15/48 (2 hrs)	10.0	9.0-10.0	2:35 PM	
				16/49 (3 hrs)	10.0	9.0-10.0	3:35 PM	
				17/50 (Final)	8.5	7.5-8.5	4:20 PM	
			NOTE: If not as specified notify Supervisor & note in log					
Drum	7		If final pH above 8.5 adj to 7.5-8.5					
			& Record: pH			Assume 77%	27-D	
		28	Weigh into 55 Gal Drum			Assume 50%	56	7-D 28
		29	Fill with water & stir 2 min					
SV SP & CP	8	30	SP Step 17/50 - After checking pH, Operator Step PB					
		31	Step 23/53 - Record: pH 3.3 (3.3-3.7)					
		32	If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH				15-A	
		33	Sift in 3 bags			150	128-A	150
		34	Siphon in N-7-D from S 29 in 10-12 min & stir 5 min					
Drum	7	35	Record: pH 7.2 (4.0-4.2) & if necessary adj to pH 4.0-4.2					
			& 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					
		36	Operator Step PB					
SV SP & CP	8	37	SP Step 24/54 - Pour in & stir 15 min			22	978-A	22
		38	Operator Step PB					
		39	SP Step 60 - Batch complete					
			START	FINISH	OPTR			
			TIME SP STEP	TIME SP STEP				
			5:00 P	11:00 P	2:35-141			
			7:00 P		2:32-201			
			3:00 P	3:45 P	2:39-120			



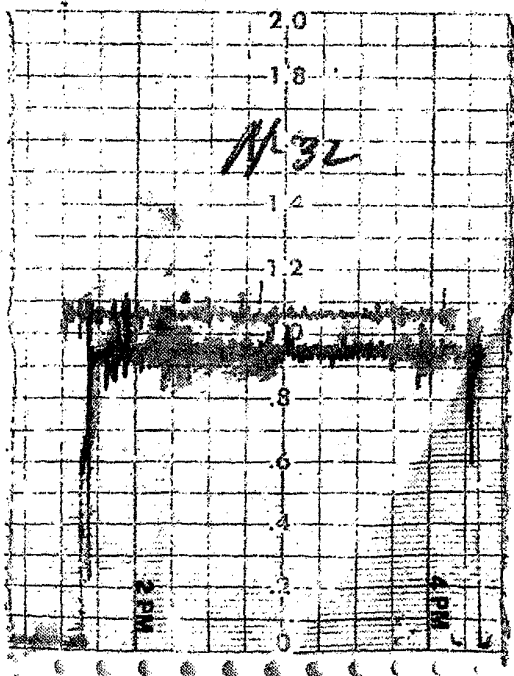
GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

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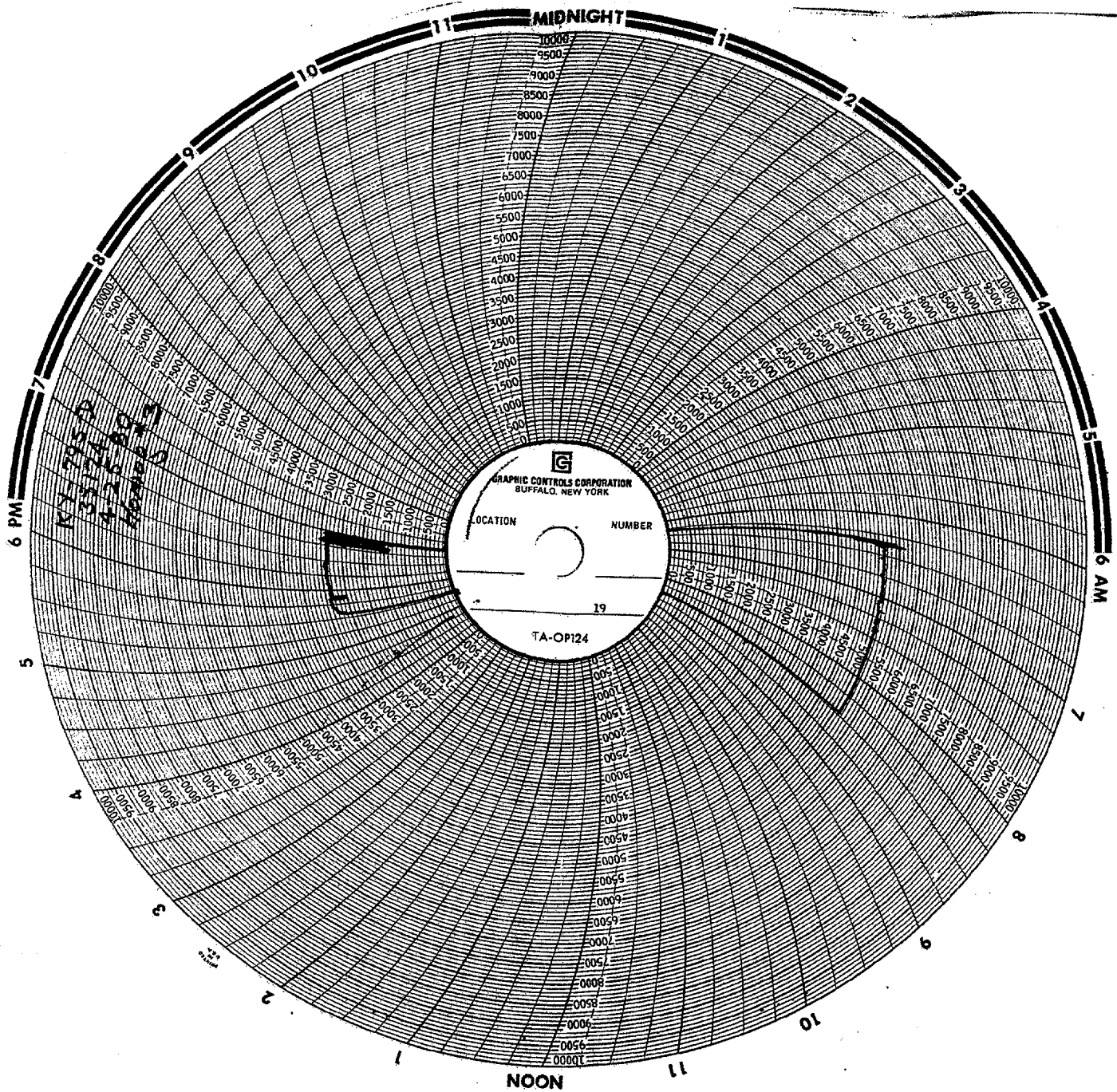
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DUP050456340



DUP050456341



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