

CG 03 CODE KY-788-D

MAR 14 34875

PUNCHED & CHECKED

EST. WGT. 960 860 LBS.

STD. HRS. 8.8

TIME

14 YC-3-B 98 4

Lot

14 YC-3-B 98 4

Lot

14 YC-3-B 98 4

Lot

MAR 19 1980

PROCESSES		APPROVED BY	
() KY-788-D	()	()	EWK 9/28/76
()	()	()	MTW 9/30/76
()	()	()	DCG 9/30/76
TYPED BY			
NE 2-18-77			

Homog #3 - 1st Pass

Total Wgt. 3560# 3460

NON-BLEEDING

MENT	NAME	USE LBS.	N CODE	ACC LBS.
03	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED			
05	2 Weigh in drum & pour in	345	32-D	345
1	3 Dump in & stir 5 min Lot 24406	52 x 50	YC-3-B	2600
	Record: Start 12:30 p			
	Fin 1:10 p			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-205 Vol 44 "& adj to 60" (2100 G)			
	8 Inspect homog. strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
05	9 Run 10" (514 G) water into V-244 & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
	Record: Time Start 3:35 p.m. total min 12.5			
	Note: If Homog pressure falls below 4800 ps., 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			
P	12 SP Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
&	13 Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
P	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 55 % - preset #2 208 Gal		15-A	416
	b. 13LG 68 % - preset #6 135 Gal		20-A	135
	15 Set strike flow controllers as follows:			
	a. 3EC10 (N-27-D Controller) in Manual 0.54 GPM		27-D	180
	b. 3EC20 (N-27-D Water) in Manual Local 4.4 GPM			
	c. 3ER10 (N-27-D/Water) Ratio 0.8			
	d. 8EC10 (N-32-D Controller) in Manual 0.82 GPM .084		32-D	1215
	e. 8EC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 8EC20 (N-32-D Water) in Remote			
	g. 8ER10 (N-32-D/Water) Ratio 1.1			
	16 Operator Step PB			
	17 Record Level 21G 95 %. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.7. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
	Siphon into SV & Record: pH 11.3			
	Operator Step PB			

V-244

ENT	PAGE 2 CG 03 CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS
21	SP Step 06/39 - After heat up Record: pH <u>9.8</u> (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 is limits. Switch 3FC10 to Auto. Operator Step PB					
25	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote					
26	Operator Step PB					
27	During strike, record pH & time as follows:					
	SP Step					
	V-243/V-244	pH	Range	Time		
	13/46 (30 min)	<u>9.6</u>	9.3-10.0	<u>8:05 PM</u>		
	14/47 (60 min)	<u>9.3</u>	9.3-10.0	<u>8:35 PM</u>		
	15/48 (2 hrs)	<u>9.3</u>	9.3-10.0	<u>9:35 PM</u>		
	16/49 (2 hrs 25 min)	<u>9.5</u>	9.3-10.0	<u>10:00 PM</u>		
	17/50 (Final 3 hrs)	<u>10.5</u>	7.5-8.5	<u>10:35 PM</u>		
	Note: If not as specified notify Supervisor & Note in log					
	If final pH is above 8.5, adj 7.5-8.5					
	& Record: pH _____ Assume 77%				27-D	
28	While striking run 30" (234 G) water into V-339					
29	Add in 7-8 min			350	530-A	350
30	Adj to 49" (382 G) at 80-100 °F					
31	Stir 5 min & record pH <u>10.2</u> (9.5-10.5)					
32	Stir 15 min or longer to dissolve for SP Step 26/56					
33	Record Vol <u>53</u> " & Calculate <u>53</u> " (Vol X 0.78 = <u>41.3</u> G)					
34	Set preset #8 to <u>41.3</u> G from S 33					
35	Run 40" (440 G) water into V-302					
36	Add & stir 2 min for S 40 Assume 50%			360	7-D	180
37	SP Step 17/50 After checking pH. Operator Step PB					
38	Stir in 2 bags			100	128-A	100
39	SP Step 23/53 Record: pH <u>3.1</u> (3.7-4.2)					
40	Run in N-7-D from S 36 in 10-12 min & stir 5 min					
41	Record: pH <u>9.0</u> (9.0-9.5) & if necessary adj to pH 9.0-9.5					
	& 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					
42	Operator Step PB					
43	SP Step 29 - Record: pH <u>9.0</u> (9.0-10.0) Time <u>12:30 PM</u>					
44	Operator Step PB					
45	SP Step 60 - Batch complete					
	Start	Finish	Optr			
	Time	Time	SP Step			
	<u>1:00 PM</u>	<u>3:00 PM</u>	<u>235</u>			
	<u>3:00 PM</u>	<u>11:00 PM</u>	<u>201</u>			
	<u>11:00 PM</u>	<u>12:30 PM</u>	<u>320</u>			

NOTE
IF PH
DROPS
INCREASE
SILICONE
SETTING
IN 102
THERMOMETER







