

V 243,244 (AUTOMATED) C V
 CG 03 CODE KY-787-D PKG
 → APR 1 35193
 EST WGT 1090 LBS

D V
 PROCESSES APPROVED BY
 () KY-787-D () FWK 9-22-76
 () () DCG 9-27-76
 () () MTW 9-30-76
 RE TYPED BY
 CJH 2-8-80

STD HRS 8.9 TIME 11P M

14 YC-2-B 93 4 LOT 24770, 2000
 LOT 24968, 400
 LOT , #

PUNCHED & CHECKED

APR 3 1980

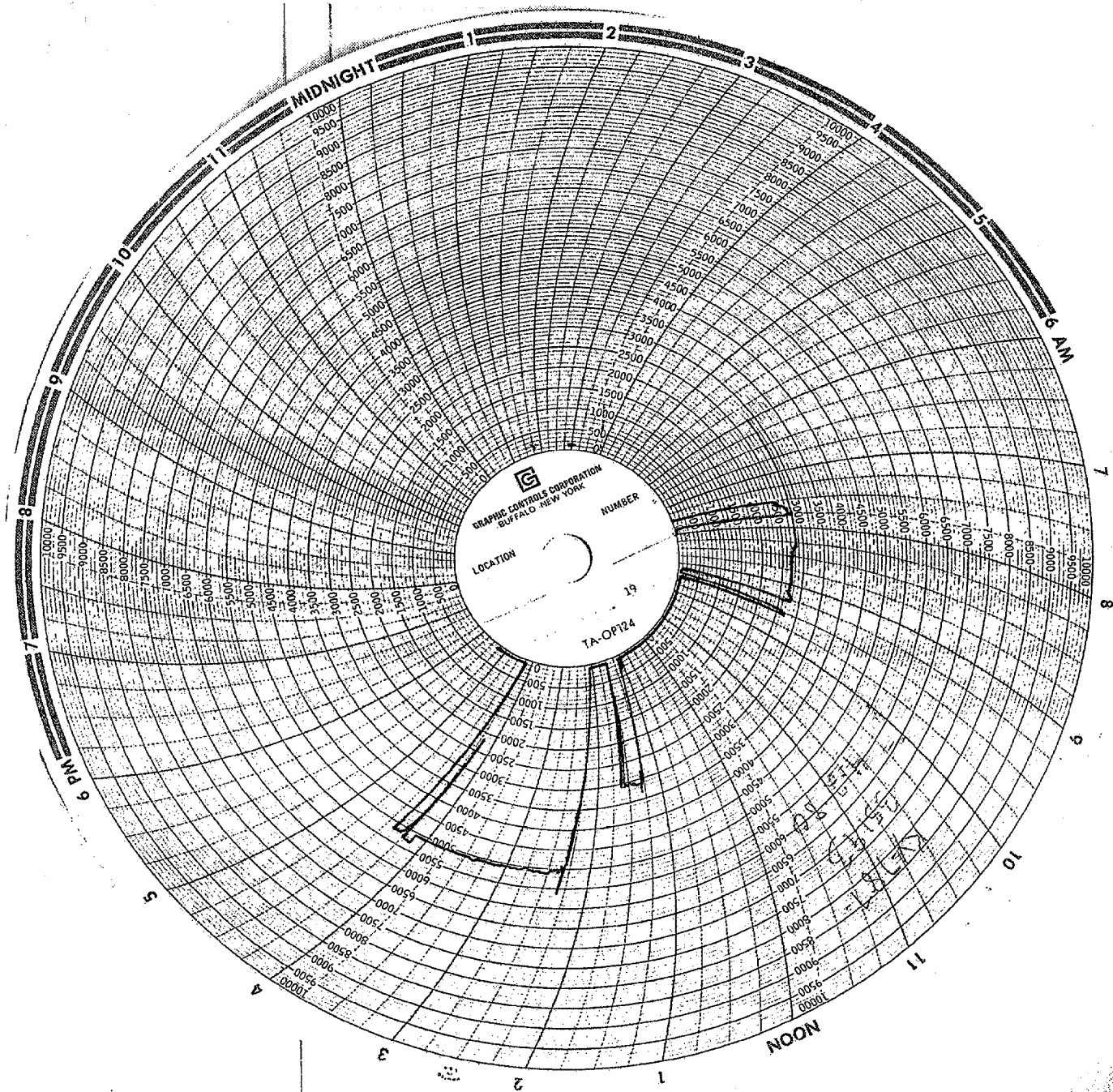
TOTAL WGT 3490#

NON-BLEEDING

IPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205 - 1	1. RUN 60" (992 G) WATER INTO V-203. SET AGITATOR ON HIGH SPEED.			
	2. WEIGH IN DRUM & POUR IN	320	32-D	320
	3. DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
	RECORD: START 4.45 AM 24770	2000		
	FIN 5.50 AM 24968	400		
	75" (1256)			
	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, WASH COLOR THRU HOMOG AT 1800-2000 PSI USING MINIMUM WATER			
	7. RECORD V-205 VOL 50 " & ADJ TO 60" (2100 G)			
	8. INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	9. DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205 & SV 2	10. RUN 10" (514 G) WATER INTO SV. START AGITATOR			
	11. PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-243			
	RECORD: TIME START 2.15 PM TOTAL MIN 120			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	12. WHEN V-205 MTY, RUN IN 5" (240 G) WATER AND PUMP THRU HOMOG AT 4800-5200 PSI			
SP & CP 3	13. SP STEP 01 - SET FORMULA SELECTOR TO POSITION #2 (V-243) OR #7 (V-244)			
	14. PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
	15. RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 42% - PRESET #1 80 GAL		15-A	160
	B. 13LG 53% - PRESET #6 135 GAL		20-A	135
	16. SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	A. 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM		27	275
	B. 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	C. 3FR10 (N-27-D/WATER RATIO) 0.64			
	D. 8FC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM		32-D	1840
	E. 8FC20 (N-32-D/WATER) IN MANUAL LOCAL 4.47 GPM			
	F. 8FC20 (N-32-D WATER) IN REMOTE			
	G. 8FR10 (N-32-D/WATER RATIO) 0.83			
SV SP & CP 4	17. OPERATOR STEP PB			
	18. RECORD LEVEL 2 LG 68%. IF BELOW 35% FOLLOW SOLUTION			
	19. MAKE-UP PROCEDURE FOR N-27-D			
	20. ADJ TO 48" (2470 G)			
	21. RECORD: PH 10.4			
	22. ADJ TO 11.1 - 11.3 USING N-7-D DILUTED TO 5% ASSUME 50% (10 PARTS WATER TO 1 PART N-7-D)	20	7-D	10
	23. SIPHON INTO SV. RECORD PH 11.2			
	24. OPERATOR STEP PB			

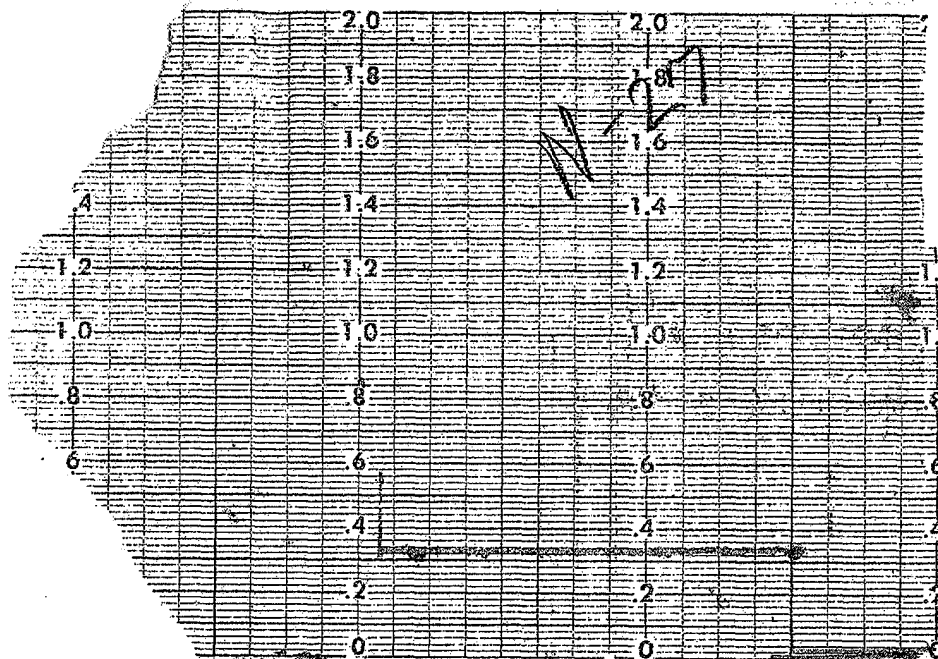
REV.

EQUIPMENT	PAGE 2 CG 03 CODE KY-787-D EST. WGT. 3490 LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22 SP STEP 06/39 - AFTER HEAT UP RECORD: pH 10.1 (9.5-10.0)			
SP	23 SWITCH 3FC20, 8FC10, 8FC20 TO AUTO			
&	24 OPERATOR STEP PB			
CP	25 SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS			
5	SWITCH 3FC10 TO AUTO OPERATOR STEP PB			
	26 SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH 3FC20 TO REMOTE			
	27 OPERATOR STEP PB (TAKE PH IN SV ASAP. RECORD: 10.1 ph)			
	28 DURING STRIKE, RECORD pH & TIME AS FOLLOWS:			
	SP STEP			
	V-243/V-244 pH() RANGE TIME			
	13/46 (30 MIN) 10.0 9.0-10.0 7:10			
	14/47 (60 MIN) 10.0 9.0-10.0 7:40			
	15/48 (2 HRS) 10.0 9.0-10.0 8:40			
	16/49 (2 HRS 25 MIN) 9.9 9.0-10.0 7:05			
	17/50 (3 HRS FINAL) 7.0 7.5-8.5 7:40 PM			
	NOTE: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG			
	IF FINAL pH IS ABOVE 8.5, ADJ pH TO 7.5-8.5 &			
	RECORD: pH ASSUME 77%		27-D	
339	29 WHILE STRIKING, RUN 30" (234 G) WATER INTO V-339			
6	30 ADD IN 7-8 MIN	350	530-A	350
	31 ADJ TO 49" (382 G) AT 80 - 100°F			
	32 STIR 5 MIN & RECORD pH 10.1 (9.5-10.5)			
	33 STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26			
	34 RECORD VOL 49 " & CALCULATE 49 "(VOL) X 0.78 = 38.2 G			
	35 SET PRESET #8 TO 38.2 G FROM S 34			
302	36 ADD 30" (360 G) WATER TO V-302			
7	37 ADD & STIR 2 MIN FOR S 41	ASSUME 50%	160	7-D 80
243	38 SP STEP 17/50 - AFTER CHECKING pH, OPERATOR STEP PB			
	39 SIFT IN 2 BAGS	100	128-A	100
SP	40 SP STEP 23/53 - RECORD pH 3.4 (3.7-4.2)			
&	41 RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN			
CP	42 RECORD: PH 9.3 (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5			
8	& RECORD: pH	ASSUME 77%	27-D	
	(DILUTE 10 PARTS WATER TO 1 PART N-7-D)	ASSUME 50%	7-D	
	SIPHON N-7 INTO SV			
	43 OPERATOR STEP PB			
	44 SP STEP 29/58 RECORD: pH 9.3 (9.0-10.0) TIME 11:30 PM			
	45 OPERATOR STEP PB			
	46 SP STEP 60 - BATCH COMPLETE			
	START FINISH			
	TIME SP STEP TIME SP STEP OPTR			
	7:00 AM 3:00 PM 322-201			
	3:00 PM 11:00 P 320-037			
	11:00 P 11:30 PM 225			



N32190.01

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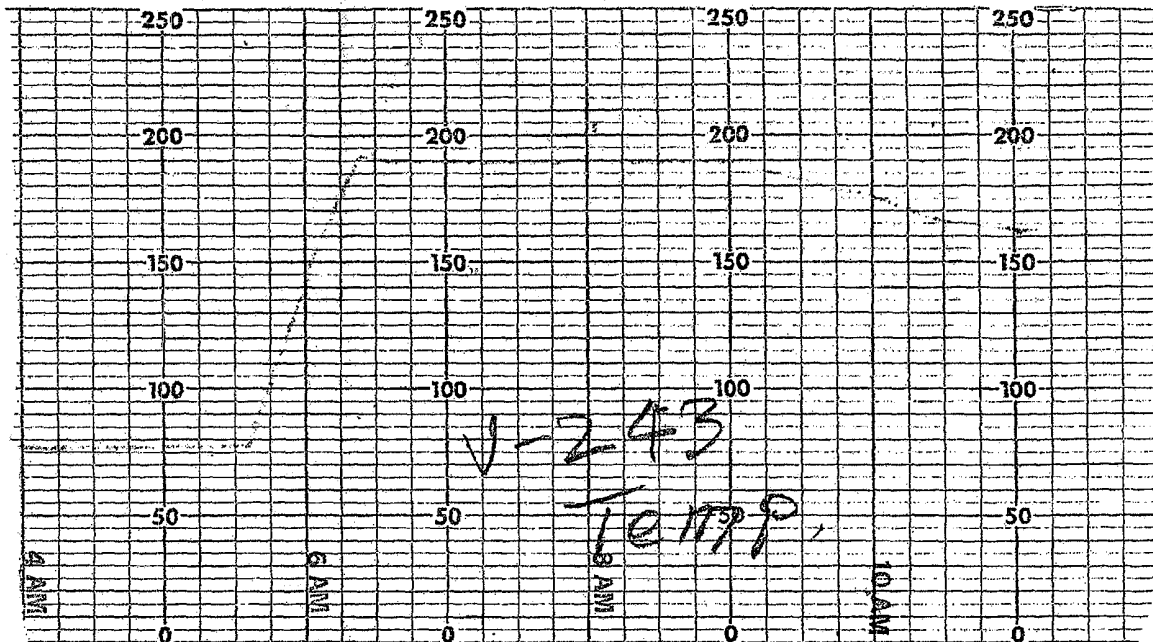


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GRAPHIC CONTROLS CORPORATION BUFFAL

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