CG 03 CODE KY-781-D PKG. _____

JAN 19 33895

EST. WGT. 1018 ~~818~~ LBS.

STD. HRS. _____ TIME 3P M

PROCESSES		APPROVED B
( ) KY-781-D	(N)	FWP 10-13-78
( )	( )	AMJ 10-13-78
( )	( )	FWP 06-26-79
( )	( )	
TYPED BY		
emw062879		

OK JKP

14 YC-3-B 93 4 Lot 24421, 300 #
14 YC-3-B 93 4 Lot 80365, 550 #
14 YC-3-B 93 4 Lot 23966, 2000 #
14 YC-3-B 93 4 Lot _____, _____ #

03 KY781D 98 4 28826 650#
Homog # 3 - 1ST Pass
" # 3 - 2ND "

Total Wgt ~~4268~~ 4468# (Req. _____)

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® YELLOW LIGHT		USE LBS.	N CODE	ACC LBS
203 & 205 1	1	~~Run~~ 60" (992 G) water in V-203 & add	Assume 50%	30	7-D	15
	2	~~Weigh~~ in drum & pour in		382	32-D	382
	3	Dump in & stir 5 min	Lot	57 x 50	YC-3-B	2850
		Record: Start 11:30 P/M	24421	300		
		Fin 1:20 A.M	80365	550		
		75" (1275G)	23966	2100		
	4	Adj to ~~80"~~ ~~(1360 G)~~ & Record: pH 10.6 (10.5-11.5)				
	5	Pump V-203 thru Homog # 3 at ~~1800-2200~~ psi into V-205				
	6	When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water				
	7	Record: V-205 Vol 43 " & adj to 45" (1662 G)				
	8	Inspect Homog strainer & clean if necessary				
205 & SV 2	9	~~Run~~ 12" (200 G) water into SV & start agitator				
	10	Pump V-205 thru Homog at 4800-5200 psi into V- 243				
		Record: Time Start 12:10 Total Min 150				
		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 & 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 (Tempterature is set at 190-194°F)				
	14	Record levels & set Raw Material Counter #1 as follows:				
		a) 11LG ~~40~~ % — preset #3	162 Gal		15-A	324
	15	Set strike flow controllers as follows:				
		a) 3FC10 (N-27-D Controller) in Manual	0.78 GPM		27-D	322
		b) 3FC20 (N-27-D Water) in Manual Local	5.44 GPM			
		c) 3FR10 (N-27-D / Water Ratio)	0.7			
		d) 8FC10 (N-32-D Controller) in Manual	1.04 GPM		32-D	2182
		e) 8FC20 (N-32-D Water) in Manual Local	4.66 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 8 %. If below 35% follow solution make-up procedure for N-27-D				
	18	Adj ~~MV~~ SV to 54" (2800 G)				
	19	Record: pH 10.0				
	20	Adj pH to 11.4-11.6 using	Assume 50%	44	7-D.	22
		(Dilute to 5% (10 parts water to 1 part N-7-D)) Siphon into SV. Record: pH 11.5				
	21	Operator Step PB				

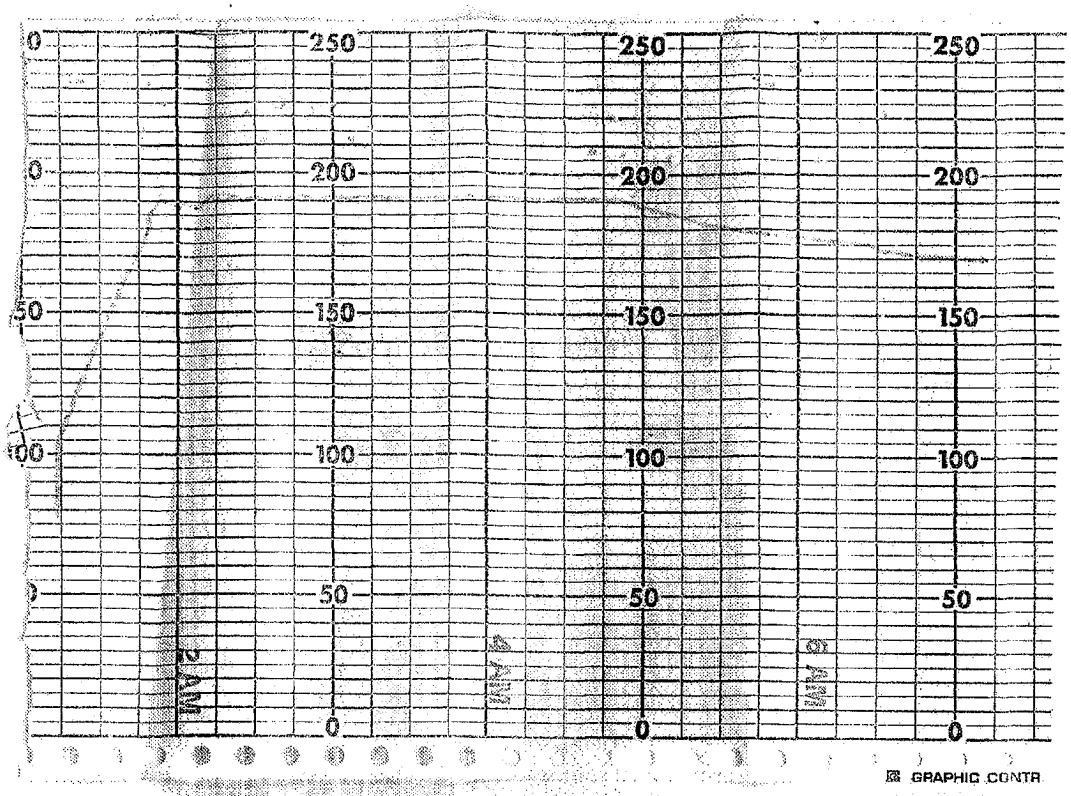
(3) REV.

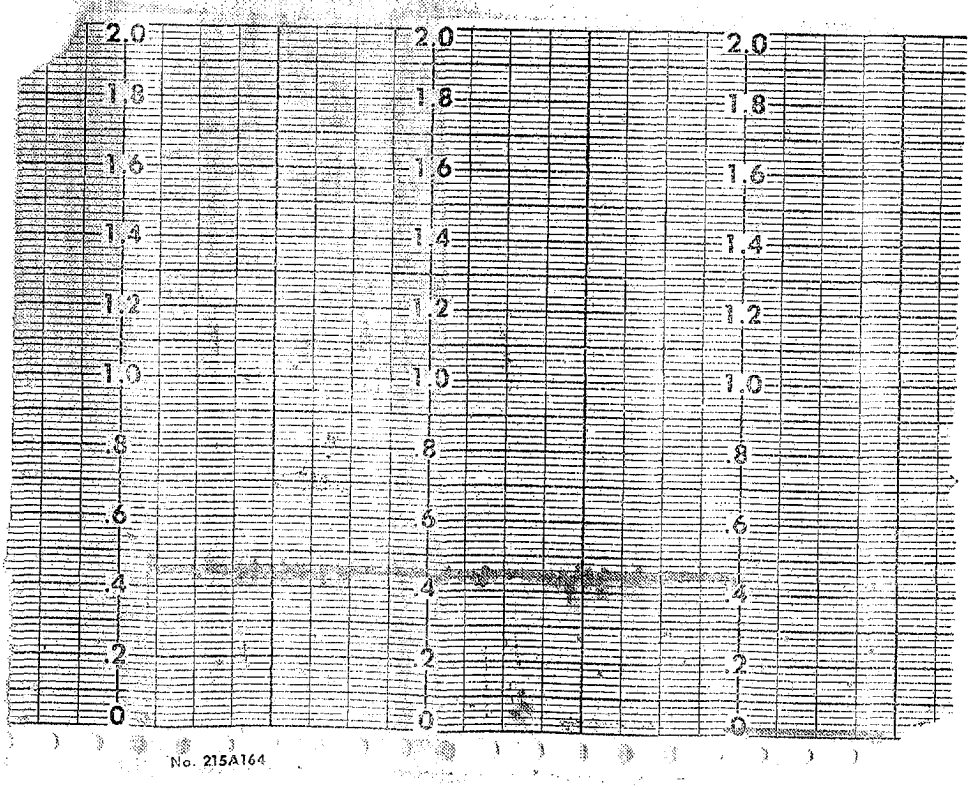
V-243

EQUIPMENT		PAGE 2 CG 03 CODE KY-781-D (N) EST. WGT. 4268 LBS.	USE LBS.	CODE	
SV	22	SP Step 06/39 — After heat-up Record: pH 9.8 (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. Opterator Step PB 4 30			
	27	During strike, Record pH & Time as follows:			
		SP Step pH Range Time			
		13/41 (30 min) 9.6 9.3-10.0 5			
		14/47 (60 min) 9.6 9.3-10.0 5 30			
		(2 hrs) 9.6 9.3-10.0 6 30			
		(3 hrs) 9.6 9.3-10.0 7 30			
		17/50 (Final) 7.3 7.5- 8.5 8 15			
		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	
	27A	Sift in	200	128A	300
ALM	28	During strike clean #2 ALM magnetic separator & pump strainer			
6	29	Install dust hood to #2 ALM & run in 2000# water			
	30	Dump in Lot 28326	600	KY-781-D	600
	31	Stir 60 min. Add water as necessary to fluidize			
	32	When strike (S 27A) complete, pump ALM thru box screen into			
		SV-			
	33	Rinse in ALM & lines			
	34	Clean magnetic separator & strainer			
302	35	Add 31" (379 G) water to V-302			
7	36	Add & stir 5 min Assume 50%	110	7-D	55
SV	37	SP Step 17/50 — After checking pH. Operator PB			
SP	38	SP Step 23/53 — Record: pH 3.5 (3.3-3.7)			
&	39	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			
8		Use ± 30 G of water to 50# N-15-A. Stir SV 5 min			
		after each addition			
	40	Run in N-7-D from S 36 & stir 5 min			
	41	Record: pH 4.1 (4.2-4.4)			
	42	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-D M , %		27-D	
		Assume 50%	12	7-D	6
		Siphon (if N-7-D) into SV. Record: pH 4.3			
	43	Operator Step PB			
	44	SP Step 24/54 — Add N-978-A & stir 15 min	17	978-A	17
	45	Operator Step PB			
	46	SP Step 60 — Batch complete			

START Time	START SP Step	FINISH Time	FINISH SP Step	OPTR
7:00 AM		3:00 PM		235
8:00 AM		11:15 AM		126-100

DUP050094259





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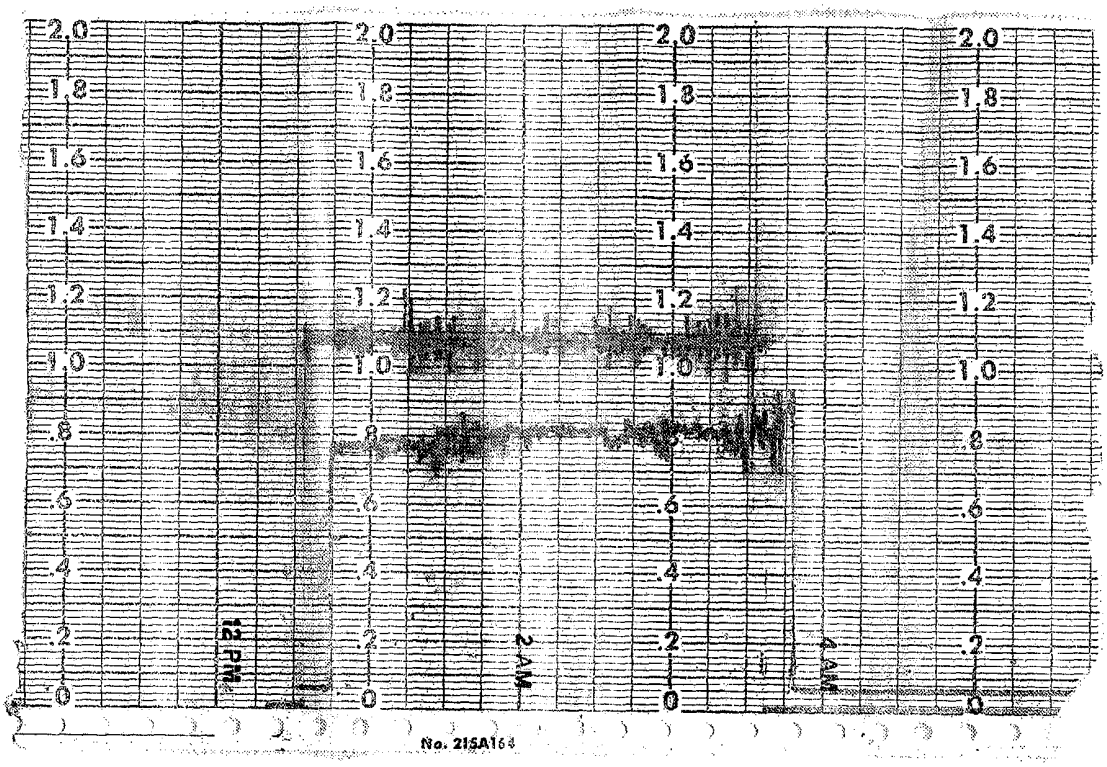

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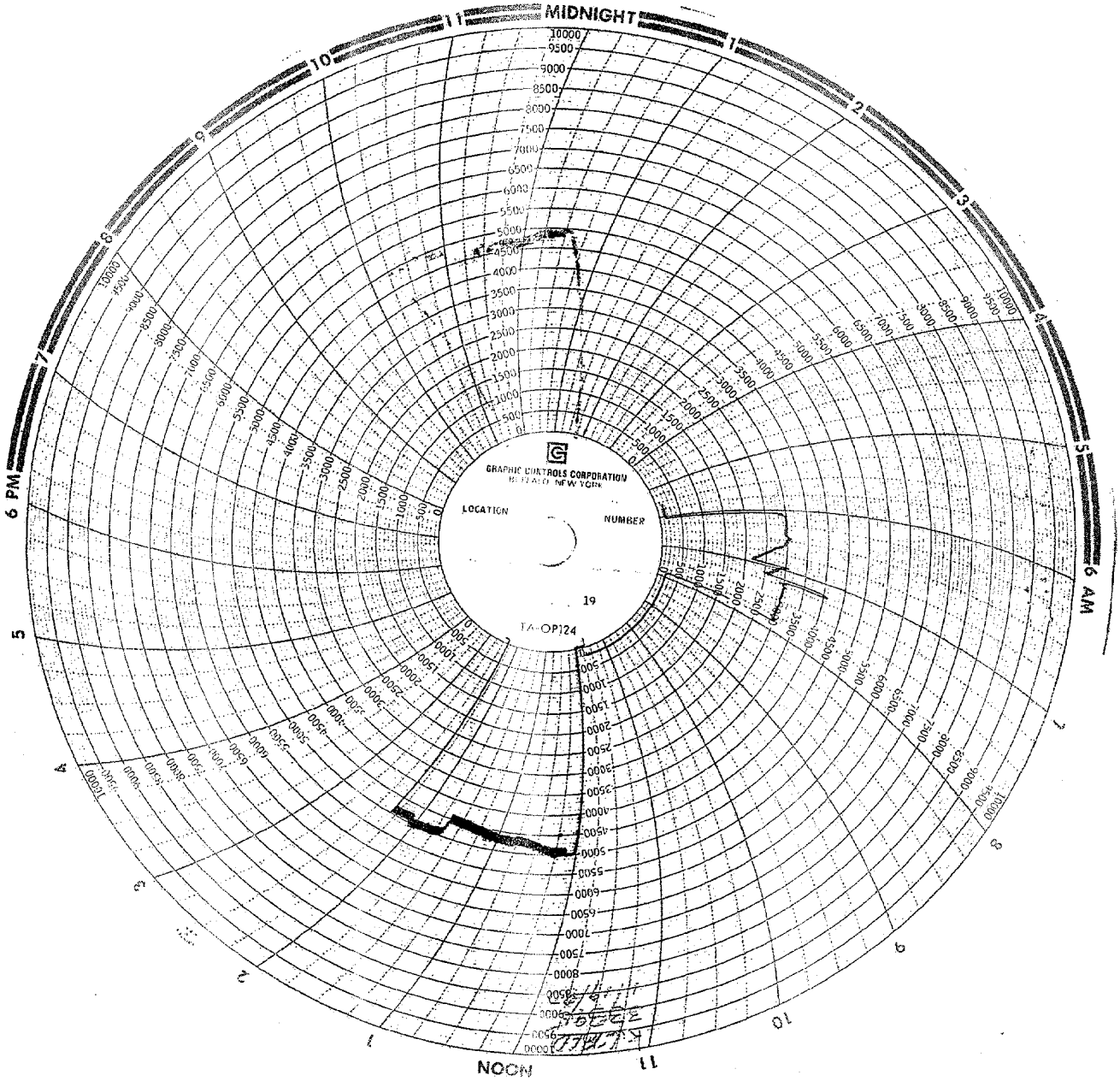

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243

V-243

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