

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

V 243,244 (AUTOMATED) CV APR 3 1980
 CG 03 CODE KY-787-D PKG _____
 → MARCO 35180
 EST WGT 1090 LBS
 STD HRS 8.9 TIME 11P M
 14 YC-2-B 93 4 LOT 24476, 2.000#
 LOT 24462, 4.00#
 LOT _____#

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

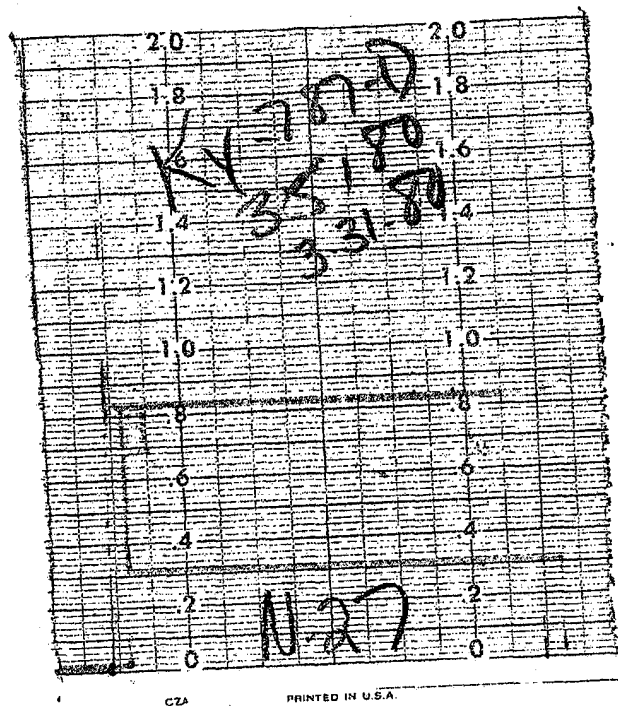
TOTAL WGT 3490#

NON-BLEEDING

INPIEMENT	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 SPEEDS			
	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 2:45 AM LOT 24476	2000		
	FIN 3:30-4M 24462	400		
	25" (12756)			
	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 HOMG AT 1800-2000 PSI USING MINIMUM WATER 263			
	7 RECORD V-205 VOL " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	9 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
	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 9:30 PM TOTAL MIN 150			
	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 #1 (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 35% - PRESET #1 80 GAL 15-A 160			
	B 12LG 45% - PRESET #6 135 GAL 20-A 135			
	16 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	A 3FC20 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM 27 275			
	B 3EC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	C 3ER10 (N-27-D/WATER RATIO) 0.64			
	D 3EC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM 32-D 1840			
	E 3EC20 (N-32-D/WATER) IN MANUAL LOCAL 4.47 GPM			
	F 3OF20 (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 42% IF BELOW 35% FOLLOW SOLUTION MAKE UP PROCEDURE FOR N-27-D			
	19 ADJ TO 48" (2470 G)			
	20 RECORD: pH 10.8			
	21 ADJ TO 11.1 - 11.3 USING N-7-D DILUTED TO 5% ASSUME 50% (10 PARTS WATER TO 1 PART N-7-D)	30	7-D	15
	22 STPHON INTO SV. RECORD pH 11.3			
	23 OPERATOR STEP PB			

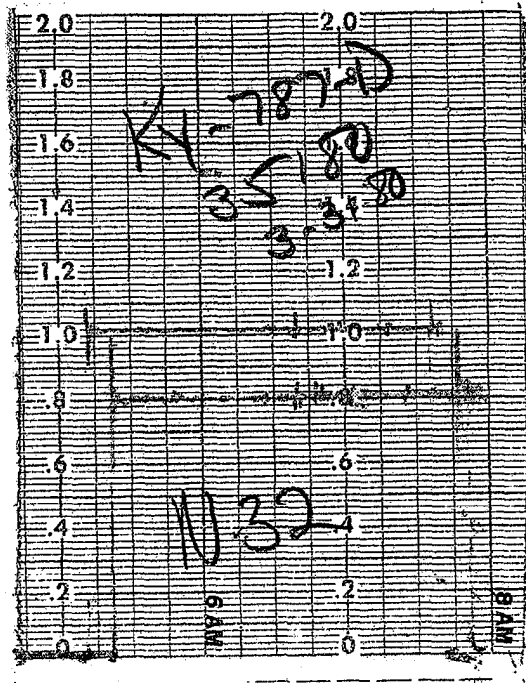
U 243

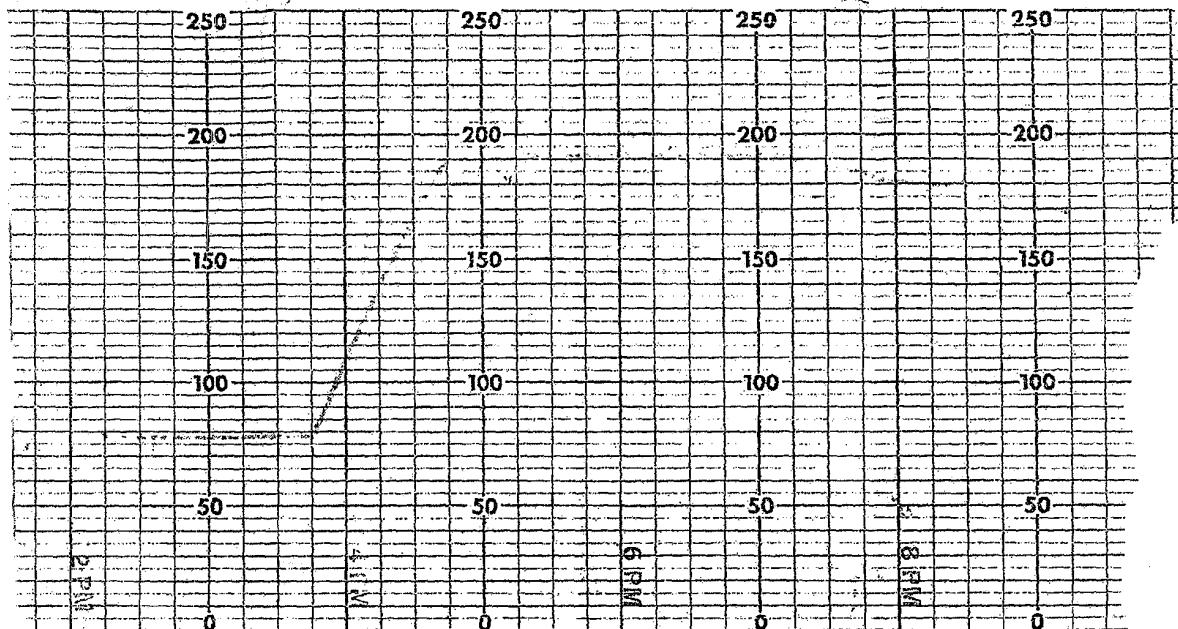
UIPMENT	PAGE 2	CG-03	CODE	KY-787-D	EST. WGT.	3490	LBS.	USE	N	ACCT.
								LBS.	CODE	LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH 10.0 (9.5-10.0)								
SP	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO								
&	24	OPERATOR STEP PB								
CP	25	SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS								
5	26	SWITCH 3FC10 TO AUTO OPERATOR STEP PB								
	27	SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH								
	28	3FC20 TO REMOTE								
	29	OPERATOR STEP PB								
	28	DURING STRIKE, RECORD pH & TIME AS FOLLOWS:								
		SP STEP								
		V-243/V-244	pH	RANGE	TIME	3:35A.M				
		13/46 (30 MIN)	9.9	9.0-10.0	4:05AM					
		14/47 (60 MIN)	9.9	9.0-10.0	4:35AM					
		15/48 (2 HRS)	9.9	9.0-10.0	5:35AM					
		16/49 (2 HRS 25 MIN)	9.9	9.0-10.0	6:05AM					
		17/50 (3 HRS FINAL)	8.4	7.5-8.5	6:35AM					
		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								
	31	ADJ TO 49" (382 G) AT 80 - 100°F								
	32	STIR 5 MIN & RECORD pH 10.3 (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 20" (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								
	40	SP STEP 23/53 - RECORD pH 4.2 (3.7-4.2)								
SP	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
&	42	RECORD: pH 10.1 (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5								
CP		& RECORD: pH 9.2								
3		(DILUTE 10 PARTS WATER TO 1 PART N-7-D)								
		ASSUME 77%								
		ASSUME 50%								
		12 27-D 8								
		7-D								
		SIPHON N-7 INTO SV								
	43	OPERATOR STEP PB								
	44	SP STEP 29/58 RECORD: pH 9.1 (9.0-10.0) TIME 8:15								
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE PUMPED TO V240								
		START		FINISH						
		TIME	SP STEP	TIME	SP STEP	OPTR				
		11:00AM		1:00PM		409				
		3:00PM		11:00PM		144-837				
		11:00PM		7:00AM		381-438				
		7AM		8:15A		120-27				



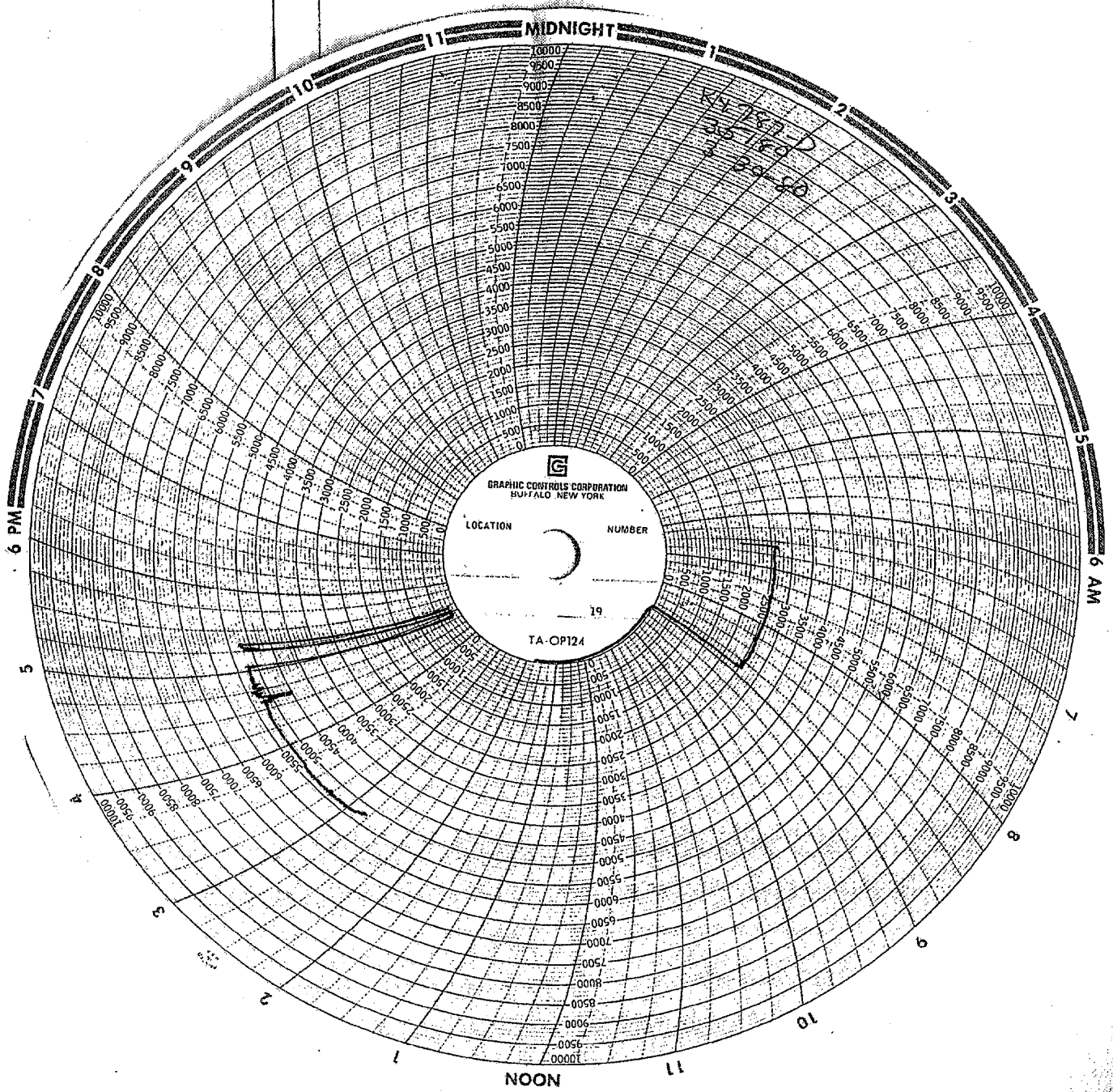
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