

244 (Automated) C.V. APR 1 1980

OS CODE KY-790-D PKG.

APR 15 35367

WGT. 3747 LBS.

HRS. TIME 7A M

PROCESSES		APPROVED BY	
()	KY-790-D	(C)	EWK 11-03-77
()		()	DCG 11-04-77
()		()	MTW 11-05-77
()		()	FWP 01-12-79
TYPED BY			
emw011279			

OK
EP
Homog #4 - 1st Pass

APR 15 1980

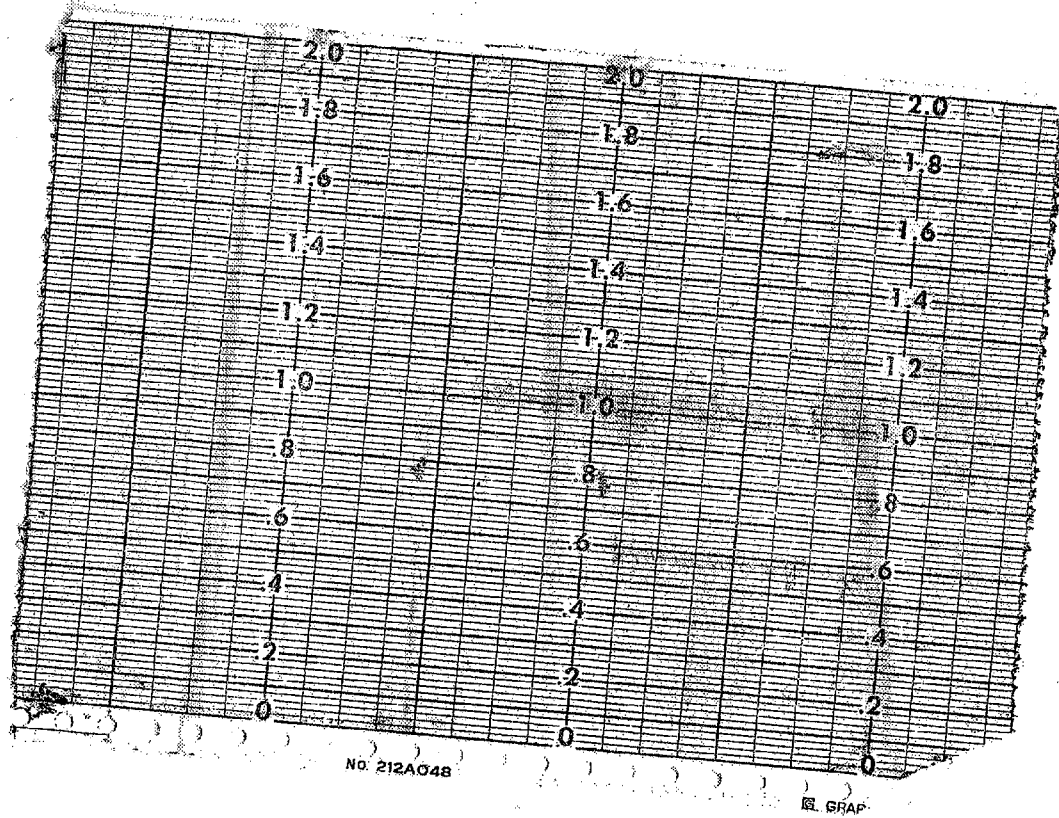
NON-BLEEDING

NAME	USE LBS.	N CODE	ACCT. LBS.
KROLOR® YELLOW PRIMROSE			
1 Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
2 Pour in	475	32-D	475
3 Dump in	59 x 50	104-B	2950
Record: Start 1:00 PM	Lot 9127	2000	
Fin 2:00 PM	9142	450	
75" (2756)	9146	500	
Adj to 80" (1360 G) & Record: pH 8.9 (7.0-9.0)			
4 Pump V-203 thru Homog at 2400-2600 psi into V-205			
5 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Proceed to S's 7, 8, 9, & 10 ASAP (Use Hot Water)			
Record: V-203 1" & adj to 55" (2016 G)			
6 Inspect Homog, strainer, & clean if necessary			
DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED.			
7 Run 12" (617 G) water into V-204 & start agitator			
8 Pump V-205 thru Homog at 4800-5200 psi into V-			
Record: Time Start 4:20 PM Total Min 170			
NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
9 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi. Rinse in using Hot Water			
10 SP Step 01 - Set Formula Selector to position #4 (V-243) or #9 (V-244)			
11 Press SV Cam Reset PB - set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
12 Record levels and set Raw Material Counter #1 as follows:			
11 LG 44 % - preset #3 59 Gal		15-A	112
13 Set strike flow controller as follows:			
a. 3FC10 (N-27-D Controller) in Manual 0.80 GPM		27-D	333
b. 3FC20 (N-27-D Water) in Manual Local 7.20 GPM			
c. 3ER10 (N-27-D / Water) Ratio 0.9			
d. 8FC10 (N-32-D Controller) in Manual 1.03 GPM		32-D	2175
e. 8EC20 (N-32-D Water) in Manual Local 5.67 GPM			
f. 8FC20 (N-32-D Water) in Remote			
g. 8FR10 (N-32-D / Water) Ratio 1.1			
14 Operator Step PB			
Record: level 2LG 46 %. If below 35%, follow solution make-up procedure for N-27-D			
15 Adj SV to 63" (3238 G) & Record: pH 8.1 (7.0-9.0)			
16 Operator Step PB			

N32309

V-244

EQUIPMENT	PAGE 2	CG 03 CODE KY-790-D (C) EST. WGT.	3747 LBS.	USE LBS.	CO.
SV	20	SP Step 06/39 - After heat up, Record: pH 7.5 (9.0-9.5)			
SP	21	Adj pH to 9.0-9.5 (UP ONLY) Assume 50%		20	7-D 10
&		Dilute to 5% (10 parts water to 1 part N-7-D)			
CP		Siphon into SV. Record: pH 7.05			
4	22	Switch 3FC20, 8FC10, 8FC20 to Auto			
(con'd)	23	Operator Step PB			
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flow in limits, switch 3FC10 to Auto. Operator Step PB			
	25	SP Step 11/44 - When 3FC10, 3FC20 flow in limits, switch 3FC20 to Remote. Operator Step PB			
	26	During strike, Record pH & time as follows: 11:00 P			
		SP Step			
		V-243 / V-244	pH	Range	Time
		13/46 (30 min)	8.9	9.0-9.8	11:30 P
		14/47 (60 min)	9.1	9.0-9.8	12:00 P
		15/48 (2 hrs)	9.3	9.0-9.8	1:00 PM
		16/49 (3 hrs)	9.35	9.0-9.8	2:00 PM
		17/50 (Final)	6.4	7.5-8.5	2:45 PM
		NOTE: If pH not as specified, notify Supervisor & note in lot. If final pH is above 8.5, adj to pH 7.5-8.5 & Record: pH			
	27	SP Step 17/50 - After checking pH, Operator PB Assume 78%			27-D
	29	SP Step 23/63 - Record: pH 3.4 (3.3-3.7)			
	30	If necessary, adj pH to 3.3-3.7 (DOWN ONLY) Record: pH			15-A
		NOTE: Dissolve extra N-15-A in water at 110-120°F in drum. Use ±30 gal of water to 50# N-15-A. Stir SV 5 min after each addition			
	31	Adj pH to 4.0-4.4 with dilute N-7-D (10 parts water to 1 part N-7-D)			
		Siphon N-7-D into SV & Record: pH 4.2 Assume 50%		18	7-D 9
	32	Operator Step PB			
	33	SP Step 60 - Batch Complete			
		START FINISH OPTR			
		TIME SP STEP TIME SP STEP			
		2:15 11 PM 3:00 P 3:10 A 2:35-144 12:00-201			



N32309.01

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