

243, 244 (Automated)

C.V.

D.V.

CG 03 CODE KY-787-D PKG.

MAL-5 34722

EST. WGT. 1090 790 LBS.

STD. HRS. 8.9 TIME

14 - YC-2-B 98 4 Lot 24068, 2000 #
Lot 24066, 400 #
Lot

PUNCHED & CHECKED

MAR - 5 1980

PROCESSES

APPROVED BY

() KY-787-D	()	EWK 9/22/76
()	()	DCG 9/27/76
()	()	MTW 9/30/76
()	()	
TYPED BY		
		2/12/77

1ST - #3 Homog

Total Wgt. - 3490#

NON-BLEEDING

SHIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	"KROLOR" - YELLOW MEDIUM			
203	1 Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED			
8	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start 12:15 PM 24068	2000		
	Fin 1:50 PM 24066	400		
	75" (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 Homog at 1800-2000 psi using minimum water			
	7 Record V-205 Vol 38 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205	9 Run 10" (514G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V- 743			
2	Record: Time start 3:30 PM Total Min 110			
	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 and pump thru Homog at 4800-5200 psi			
SP	12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
8	13 Press SV Cam Reset PB-set 22TC in Auto Remote			
CP	(Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 42 % - preset #1 80 Gal 15-A 160			
	b. 13LG 50 % - preset #6 135 Gal 20-A 135			
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.83 GPM 27-D 275			
	b. 3FC20 (N-27-D Water) in Manual Local 5.28 GPM			
	c. 3FR10 (N-27-D/Water Ratio) 0.64			
	d. 8EC10 (N-32-D Controller) in Manual 1.08 GPM 32-D 1840			
	e. 8EC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8EC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water Ratio) 0.83			
SV	16 Operator Step PB			
SP	17 Record Level 2 LG 46 %. If below 35% follow solution make-up procedure for N-27-D			
8	18 Adj to 48" (2470 G)			
CP	19 Record pH 10.6			
4	20 Adj to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% (10 parts water to 1 part N-7-D)	24	7-D	12
	Siphon into SV. Record pH 11.1			
	21 Operator Step PB			

V-243

JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACC LBS
SV	22	SP Step 06/39 - After heat up Record: pH 9.9 (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						
	28	During strike, record pH & time as follows:						
		SP STEP						
		V-243/V-244	pH	Range	Time 8:45 PM			
		13/46 (30 min)	9.8	9.0-10.0	9:15			
		14/47 (60 min)	9.8	9.0-10.0	9:45			
		15/48 (2 hrs)	9.8	9.0-10.0	10:45			
		16/49 (2 hrs 25 min)	9.8	9.0-10.0	11:10			
		17/50 (3 hrs Final)	8.2	7.5-8.5	11:45 PM			
		NOTE: If not as specified notify Supervisor & note in log						
		If final pH is Above 8.5, add 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 - 1000F						
	32	Stir 5 min & record pH 10.7 (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	8157 in 2 Bags				100	128-A	100
SP	40	SP Step 23/53 - Record: pH 4.0 (3.7-4.2)						
&	41	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
CP	42	Record: pH 9.2 (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-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH 9.2 (9.0-10.0) Time AM						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time	SP Step	Time	SP Step			
		2:15 PM		3:00 PM		126-201		
		3:00 PM		11:00 PM		320		
		11:00 PM		12:30 AM		381243		





