V. (243) 244 (Automated) C.V. MAR 15 1980 D.V.

CG 03 CODE KY-788-D PKG. _____

→ MAR 10 34978

EST. WGT. ~~960~~ 3460 LBS.

STD. HRS. 8.8 TIME 11 PM M

14 YC-3-B 98 4 Lot 24694 , 2400*

14 YC-3-B 98 4 Lot _____ , _____

14 YC-3-B 98 4 Lot _____ , _____

PROCESSES		APPROVED
( )KY-788-D	(J)	EWK 9/28/7
( )	( )	MTW 9/30/7
( )	( )	DCG 9/30/7
( )	( )	
TYPED BY		
NE 2-18-77		

OK KP FJM

Total Wgt. ~~3560#~~ 3460 MAR 21 1980 NON-BLEEDING

IPMENT		NAME "KROLOR" YELLOW - LIGHT	USE LBS.	N CODE	AC LB
		~~60" (2906 G)~~			
203	1	Run ~~23" (360 G)~~ water into V-203 SET AGITATOR ON HIGH SPEED			
&	2	Weigh in drum & pour in	345	32-D	34
205	3	Dump in & stir 5 min Lot 24694	52 x 50 2600	YC-3-B	260
1		Record: Start 11:15 AM			
		Fin 11:30 AM			
		~~75" (1275 G)~~			
	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 washcolor thru Homog at 1800-2200 psi using minimum water			
	7	Record: V-205 Vol 58 "& 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" (514 G) water into V- 205 & start agitator			
&	10	Pump V-205 thru Homog at 4800-5200 psi into V- 205			
SV		Record: Time Start 12:00 PM Total min 200			
2		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 #3 (V-243) or #8 (V-244)			
&	13	Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
CP	14	Record levels and set Raw Material Counter #1 as follows			
3		a. 11LG 14 % - preset #2 208 Gal		15-A	416
		b. 13LG 12 % - preset #6 135 Gal		20-A	135
	15	Set strike flow controllers as follows:			
		a. 3FC10 (N-27-D Controller) in Manual 0.54 GPM		27-D	180
		b. 3FC20 (N-27-D Water) in Manual Local 4.4 GPM			
		c. 3FR10 (N-27-D/Water) Ratio 0.8			
		d. 8FC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1215
		e. 8FC20 (N-32-D Water) in Manual Local 3.9 GPM			
		f. 8FC20 (N-32-D Water) in Remote			
		g. 8FR10 (N-32-D/Water) Ratio 1.1			
320	16	Operator Step PB			
243	17	Record Level 21G 64 %. If below 35% follow solution			
SP		make-up procedure for N-27-D			
&	18	Adj SV to 47" (2400 G)			
CP	19	Record pH 10.2 . Adj to 11.0-11.2 using N-7-D diluted to			
4		5% (10 parts water to 1 part N-7-D) Assume 50%	50	7-D	8
		Siphon into SV & Record: pH 11.2			
	20	Operator Step PB			

9 REV.

PAGE 2 CG 03 CODE KY-788-D EST. WGT. 3560 LBS.

VIPMENT			USE LBS.	N CODE	ACC LB
SV	21	SP Step 06/39 - After heat up Record: pH 9.8 (9.5-10.0)			
SP	22	Switch 3FC20, 8FC10, 8FC20 to Auto			
	23	Operator Step PB			
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits,			
5		Swich 3FC10 to Auto. Operator Step PB			
	25	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20			
		to Remote			
	26	Operator Step PB			
	27	During strike, record pH & time as follows: 12:00 P.M.			
		SP Step			
		V-243/V-244 pH Range Time			
		13/46 (30 min) 9.7 9.3-10.0 12:30 P.M.			
		14/47 (60 min) 9.7 9.3-10.0 1:00 P.M.			
		15/48 (2 hrs) 9.7 9.3-10.0 2:00 P.M.			
		16/49 (2 hrs 25 min) 9.7 9.3-10.0 2:25 P.M.			
		17/50 (Final 3 hrs) 7.8 7.5-8.5 3:00 P.M.			
		Note: If not as specified notify Supervisor & Note in log			
		If final pH is above 8.5, adj 7.5-8.5			
		& Record: pH _____ Assume 77%		27-D	
339	28	While striking run 30" (234 G) water into V-339			350
6	29	Add in 7-8 min	350	530-A	35
	30	Adj to 49" (382 G) at 80-100 °F			
	31	Stir 5 min & record pH 10.0 (9.5-10.5)			
	32	Stir 15 min or longer to dissolve for SP Step 26/56			
	33	Record Vol 45 " & Calculate 49 " (Vol X 0.78= 38.2 G)			
	34	Set preset #8 to 38.2G from S 33			
302	35	Run 40" (440 G) water into V-302			
7	36	Add & stir 2 min for S 40 Assume 50%	360	7-D	18 180
SV	37	SP Step 17/50 After checking pH. Operator Step PB			
SP	38	Sift in 2 bags	100	128 A	10
	39	SP Step 23/53 Record: pH 3.8 (3.7-4.2			
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min			
	41	Record: pH 9.4 (9.0-9.5) & if necessary adj to pH 9.0-9.5			
		& 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			
	42	Operator Step PB			
	43	SP Step 29 - Record: pH 9.2 (9.0-10.0) Time			
	44	Operator Step PB			
	45	SP Step 60 - Batch complete			

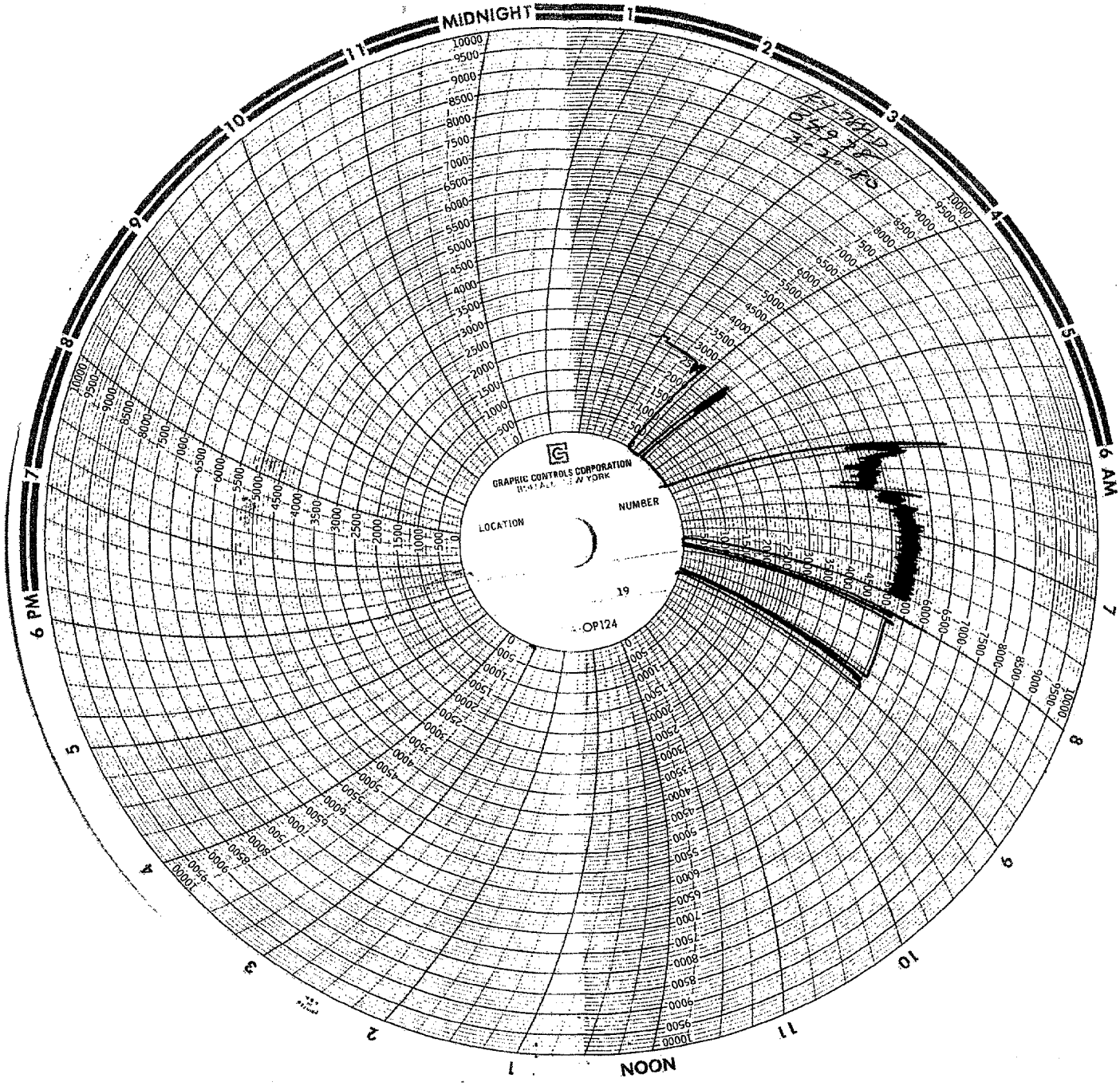
Pump To 240

Start Time	SP Step	Finish Time	SP Step	Optr
3:00 A		3:00 A		126
3:15 PM		5:30		223 289
4:30 PM		5:30		

DUP050094491

8 PM
10 PM
12 PM
2 AM
GRAPHIC CONTROLS CORPORATION BUFFALO, NEW

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