

APR 14 1980

MAKING INSTRUCTIONS: BATCH UNIT

SV-243 (Automated)

C.V.

D.V.

GS-03 CODE KY-907-D

PKG

APR 13 1980

PUNCHED & CHECKED

EST. WGT. 1080

LBS

STD. HRS.

TIME

APR 16 1980

M

PROCESSES	APPROVED BY
() KY-907-D	() EWK 12/12/77
()	() DCG 12/13/77
()	() MW 12/15/77
()	()
TYPED BY	
DJ 2/3/78	

14 YC-2-B 93 4 Lot 24773 2000
 14 YC-2-B 93 4 Lot 24773 4000
 14 YC-2-B 93 4 Lot

Homog #4-1st Pass

Total Weight 3480#

APR 14 1980

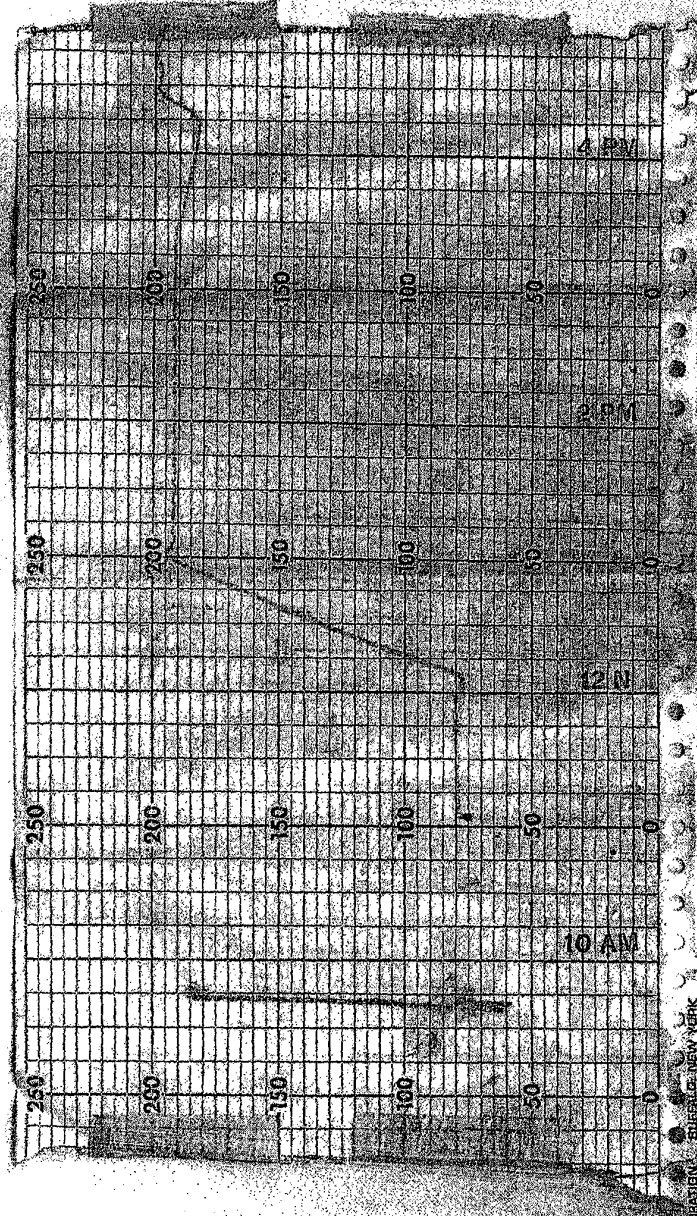
NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" KROLOKO YELLOW MEDIUM			
8	Run 3" (560 G) water into V-203. SET AGITATOR ON HIGH SPEED			
205	Pump in	320	32-D	320
1	Record: Start 10:30 AM Lot 24773 2000 Fin 11:45 AM 24773 4000	48 x 50	YC2-B	2400
	Adj to 30" (1200 G) 2400-2600			
	Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	Record V-205 Vol. 4" & adj to 60" (2100 G)			
	Inspect Homog strainer & clean if necessary			
205	Run 10" (514 G) water into SV & start agitator			
8	Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time Start 10:50 Total Min 720			
2	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
	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 190-194°F)			
3	14 Record levels and set Raw Materials Counter #1 as follows: 11G 22% - preset #1 80 Gal		15-A	160
	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. 8FR10 (N-27-D/Water Ratio) 0.64			
	d. 8FC10 (N-32-D Controller) in Manual 1.08 GPM		32-D	1840
	e. 8FC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8FC20 (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 50%. If below 35% follow solution			
8	18 make-up procedure for N-27-D			
CP	19 Adj to 48" (2470 G)			
4	20 Record pH 10.7			
	21 Adj to 11.1-11.3 using N-7-D diluted to 5% Assume 50% 22 7-0 11			
	(10 parts water to 1 part N-7-D)			
	Siphon into SV Record: pH 11.3			
	21 Operator Step PB			

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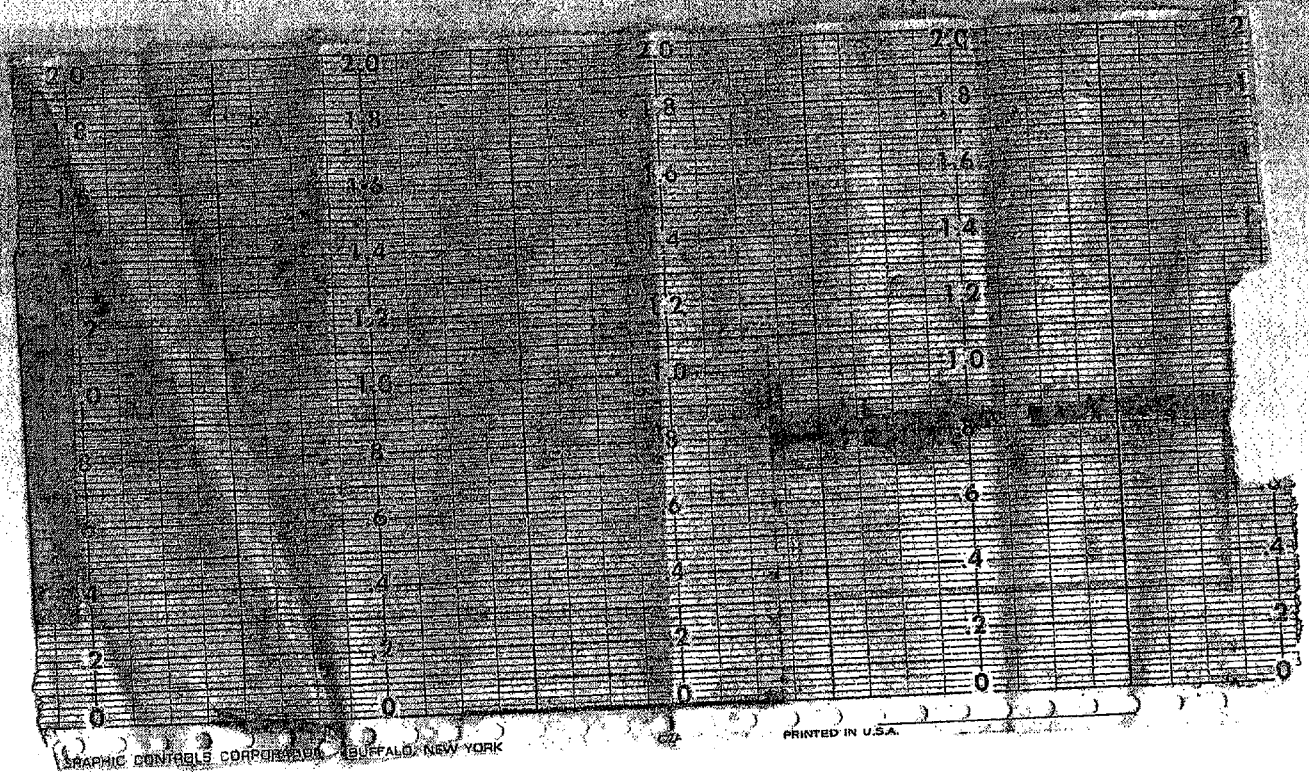
W-243

EQUIPMENT	PAGE	2	CG 03	CODE	KV-907-D (D)	EST. WGT.	3480	LBS.	USE LBS.	N CODE	ACCT LBS.
SV SP & CP 5	22	SP Step 06/39	- After heat up	Record:	pH 10.0 (9.5-10.0)						
	23	Switch 3FC20, 8FC10, 8FC20 to Auto									
	24	Operator Step PB									
	25	SP Step 10/43	- When 3FC20, 8FC10, 8FC20 water flows in limits								
	26	Switch 3FC10 to Auto	Operator Step PB								
	27	SP Step 11/44	- When 3FC10, 3FC20 flows in limits, switch								
	28	3FC20 to Remote									
	27	Operator Step PB									
	28	During strike, Record pH & time as follows:									
		SP Step									
		V-243/V-244		pH	Range	Time					
		13/46 (30 min)		10.0	9.0-10.0	10:30					
		14/47 (60 min)		10.0	9.0-10.0	11:00					
		15/48 (2 hrs)		10.0	9.0-10.0	11:00					
		16/49 (2 hrs 25 min)		10.0	9.0-10.0	12:25					
		17/50 (3 hrs Final)		8.5	7.5- 8.5	1:00 PM					
		NOTE: (1) If pH not as specified notify Supervisor & note in log (2) If final pH is above 8.5, adj pH to 7.5-8.5 &									
				Record: pH		Assume 78%					
	29	Sift in						50		27-D 128-A	50
302 6	30	Add 17" (208 G) water to V-302									
	31	Add & stir 2 min for S68				Assume 50%		100		7-D	50
PT 7	32	During strike pump into PT						318		169-A	318
	33	Pump in						36		155-A	36
	34	Pump in						36		160-A	36
	35	Stir 10 min with lightning mixer for S39									
356 8	36	During strike run 20" (244 G) water into V-356									
	37	Turn on steam									
	38	Adj to 26" (317 G) at 178-182°F 81-83°C									
	39	Pump PT mixture from S35 thru undersurface									
		Distributor AFAP									
	40	Rinse PT with hot water from hot water mixer & pump in									
	41	Shut off pump 81-83°C									
	42	Stir 30 min at 178-182°F for S49									
SV & SP 9	43	Do not shut off agitator									
	44	When S29 complete, heat SV to 198-200°F in 5-10 min									
	45	Close water line & discharge valves at stearate pump									
	46	Open V-356 Discharge valves to stearate pump inlet									
	47	Open water valve at stearate pump & run water thru									
		Homog at 2900-3100 psi to sewer									
	48	While Homog water at 2900-3100 psi, open Homog									
		Discharge valve to SV & close valve to sewer									
	49	Immediately open stearate pump discharge valve.									
		Turn on pump & Homog V-356 to SV at 2900-3100 psi									
		Maintain SV at 198-200°F									
	50	While Homog V-356 to SV, shut off water valve at									
		Stearate pump ASAP									
	51	When Homog complete, rinse in V-356 with hot water									
		From hot water mixer									

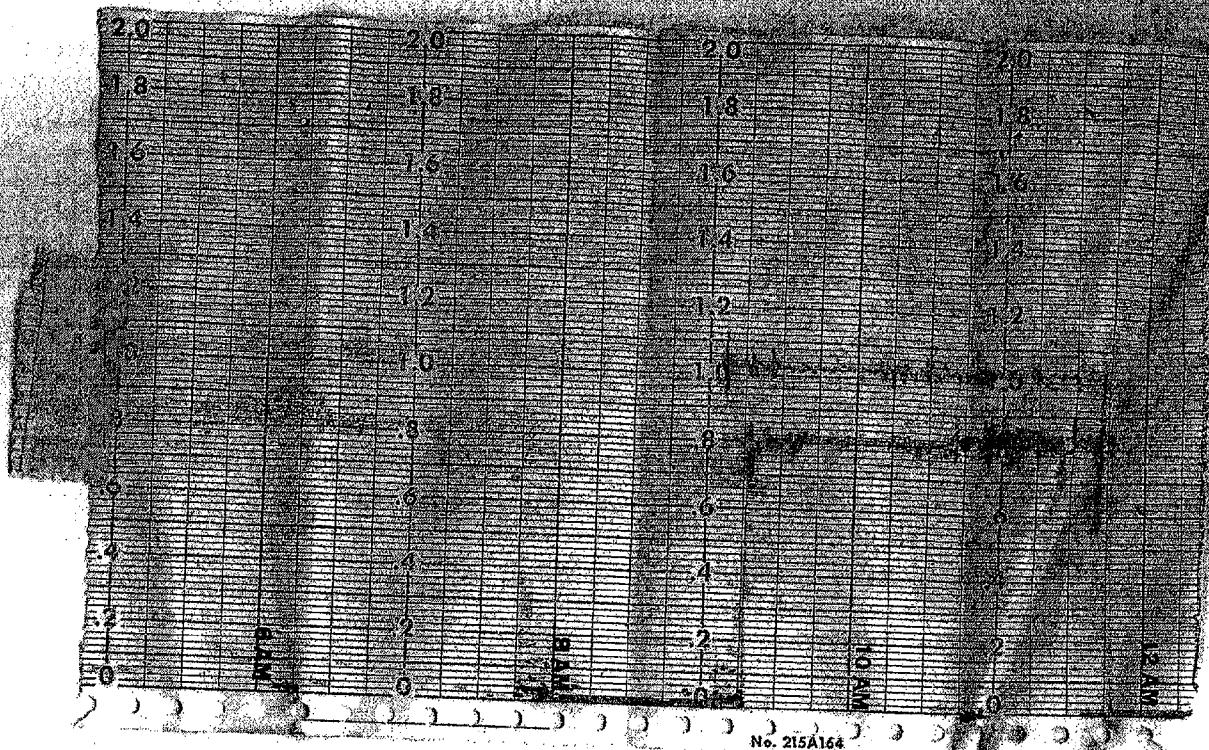


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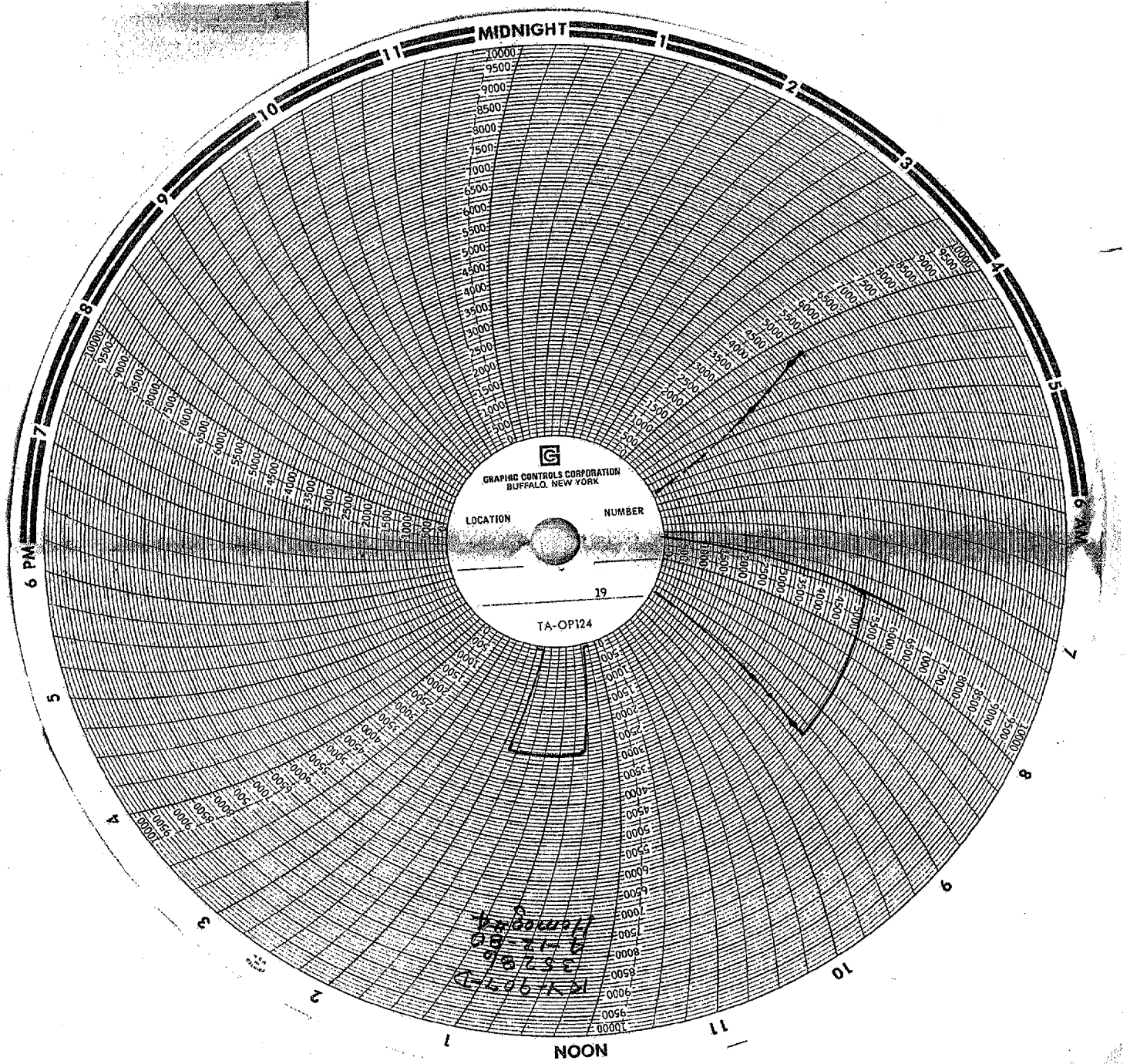
DUP050461341



DUP050461342



No. 215A164



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DUP050461344