

CG 03 CODE KY-781-D

PKG

PUNCHED & CHECKED

FEB 23 34501

OK
FP

EST. WGT. 1328 1128 LBS.

STD. HRS. TIME 111 M

14 YC-3-B 93 4 24417 3100 #

14 YC-3-B 93 4 #

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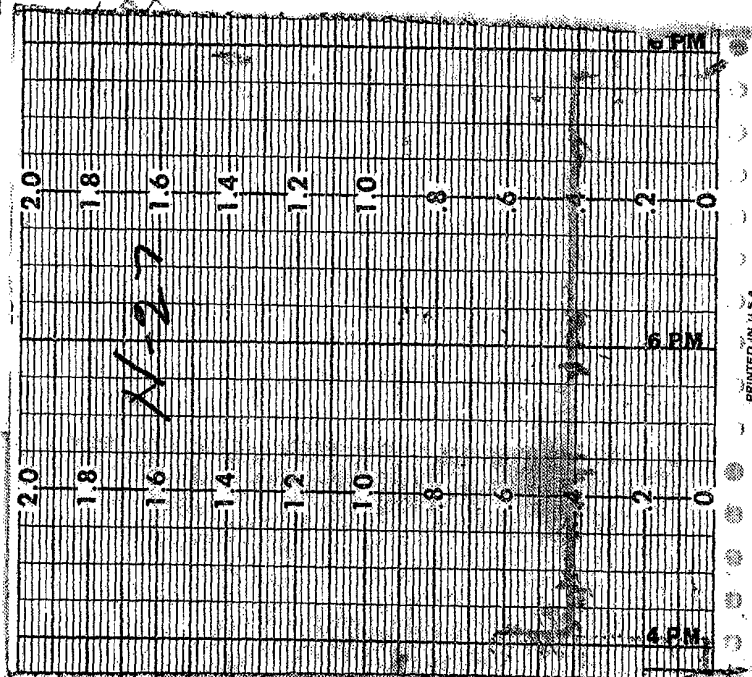
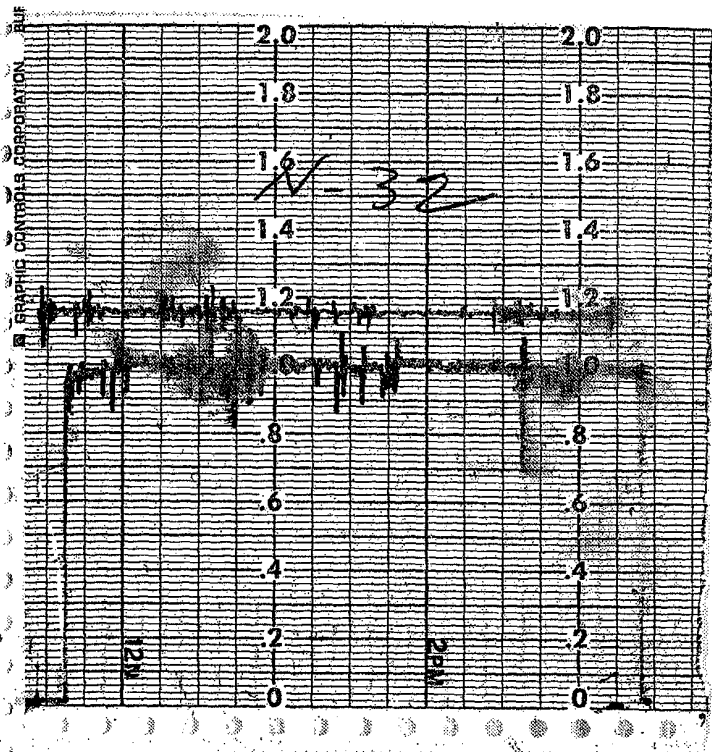
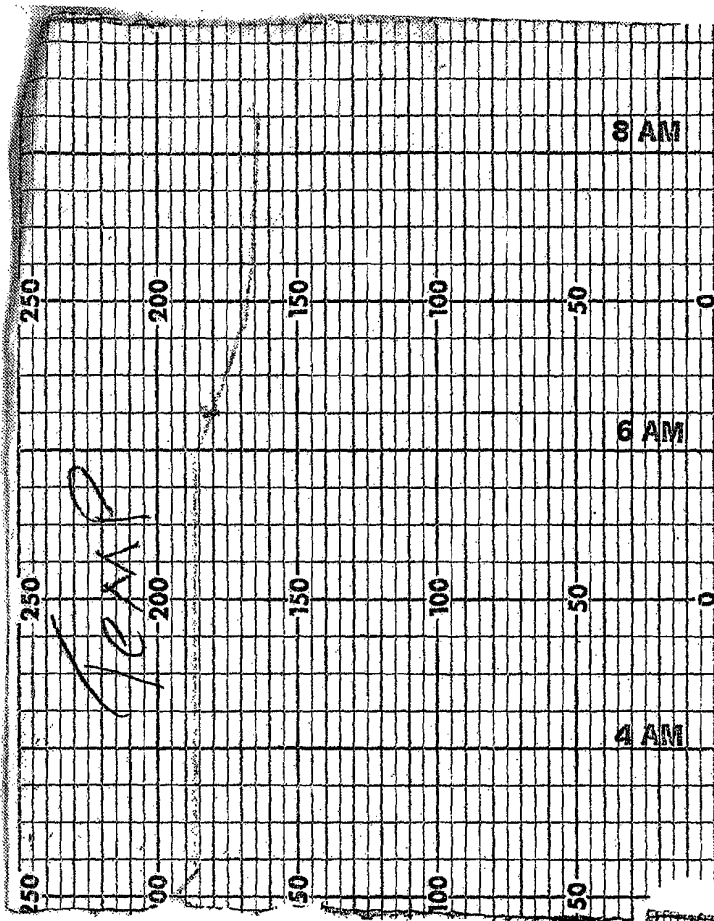
Total Wgt. 4428# (Req)

NON-BLEEDING

QUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	1 Run 60" (992 G) water in V-203 & add Assume 50%	36	7-D	18
	2 Weigh in drum & pour in	442	32-D	442
205	3 Dump in & stir 5 min with agitator on high speed. Lot 62	64 x 50	YC-3-B	3300
1	Record: Start 11:15 PM			3100
	Fin 12:30 AM	24417	3100	
	75" (12356)	2400-2600		
	4 Adj to 80" (1260 G) & Record: pH (10.5-11.5)			
	5 Pump V-203 thru Homog # at 1800-2200 psi into V-205			
	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-205 Vol 40" & adj to 45" (1662 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED.			
205	9 Run 12" (200 G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
2	Record: Time Start 12:15 PM Total Min			
	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 & CP	12 SP Step 01 - Set Formula Selector to position #1 (V-243) or #6 (V-244)			
3	13 Press SV Cam Reset PB-Set 22TC in Auto Remote (Temperature is set at 190-194°F)			
	14 Record levels and set Raw Material Counter #1 as follows:			
	a) 11LG 43% - preset #3 187 Gal		15-A	374
	15 Set strike flow controllers as follows:			
	a) 3FC10 (N-27-D Controller) in Manual 0.9 GPM		27-D	373
	b) 3FC20 (N-27-D Water) in Manual Local 6.3 GPM			
	c) 3FR10 (N-27-D / Water Ratio) 0.7			
	d) 8FC10 (N-32-D Controller) in Manual 1.20 GPM		32-D	2527
	e) 8FC20 (N-32-D Water) in Manual Local 5.4 GPM			
	f) 8FC20 (N-32-D Water) in Remote			
	g) 8FR10 (N-32-D / Water Ratio) 0.9			
SV	16 Operator Step PB			
SP	17 Record Level 2LG 38%. If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj SV to 54" (2800 G)			
4	19 Record: pH 10.3			
	20 Adj pH to 11.4-11.6 using Assume 50%	32	7-D	16
	(Dilute to 5% (10 parts water to 1 part N-7-D)			
	Siphon into SV. Record: pH 11.4			
	21 Operator Step PB			

PUMP TO 240VET

EQUIPMENT	PAGE	CG	03 CODE	KY-781-D	N	EST. WGT.	1128	LBS.	USE	N	ACCT
									LBS.	CODE	LBS.
SV	22	SP	Step 06/39.	After heat up Record:	pH	9.9	(9.6-10.2)				
SP	23		Switch 3FC20, 8FC10, 8FC20, to Auto								
&	24	Operator	Step PB								
CP	25	SP	Step 10.43 - When 3FC20, 8FC10, 8FC20 water flow in limits								
5			switch 3FC10 to Auto. Operator Step PB								
	26	SP	Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20								
			to Remote. Operator Step PB								
	27		During Strike, Record pH & Time as follows:								
		SP	Step	pH	Range	Time					
			13/41 (30 min)	9.9	9.3-10.0	4:00					
			14/47 (60 min)	9.8	9.3-10.0	4:30					
			(2 hrs)	9.8	9.3-10.0	5:30					
			(3 hrs)	9.8	9.3-10.0	6:30					
			17.50 (Final)	7.5	7.5-8.5	7:15					
			NOTE: If pH not as specified notify Supervisor & note in								
			log. If final pH is above (8.5) Adj to pH 7.5-8.5								
				M		%				27-D	
V-302	28		Add 31" (379 G) water to V-302								
6	29		Add & stir 5 min	DN		Assume 50%		124		7-D	62
SV	30	SP	Step 17/50 after checking pH. Operator PB								
SP	31		SP Step 23/53 Record: pH 3.7 (3.3-3.7)								
&	32		If necessary adj pH (DOWN ONLY) Record: pH							15-A	
CP			NOTE: Dissolve extra N-15-A in water at 110-120°F in drum								
7			Use ±30 Gal of water to 50# N-15-A. Stir SV 5 min								
			after each addition								
	33		Sift in					37-150		128-A	150
	34		Run in N-7-D from S 29 & stir 5 min								350
	35		Record: pH 4.2 (4.2-4.4)								
	36		If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts								
			H ₂ O to 1 part N-7-D) or N-27								
				M		%				27-D	
						Assume 50%				7-D	
			Siphon (if N-7-D) into SV. Record: pH								
	37		Operator Step PB								
	38		SP Step 24/54 - Add N-978-A & stir 15 min					20		978-A	20
	39		Operator Step PB								
	40		SP Step 60 - Batch Complete								
			START		FIN		OPTR				
			TIME	SP STEP	TIME	SP STEP					
			7:00 AM		7:00 AM		27				
			3:00 PM		3:00 PM		237-320				
							438-709				
			PUMP TO 240 VET								



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