

PUNCHED & CHECKED

MAY 15 1980

MAKING INSTRUCTIONS: BATCH UNIT

SV 243 244 (AUTOMATED)

CV

DV

CG 03 CODE KY-787-D

PKG

→ MAY 13 35739

EST WGT 1090 LBS

STD HRS 8.9 TIME 7A M

14 YC-2-B 93 4 LOT 24474, 400 #

LOT 24727, 2000 #

LOT , #

PROCESSES

APPROVED BY

() KY-787-D () EWK 9-22-76

() () DCG 9-27-76

() () MTW 9-30-76

() ()

RE TYPED BY

CJH 2-8-80

OK
HP
211. Homog 3-19.5 17.5
11 3-20.1

TOTAL WGT 3490#

NON-BLEEDING

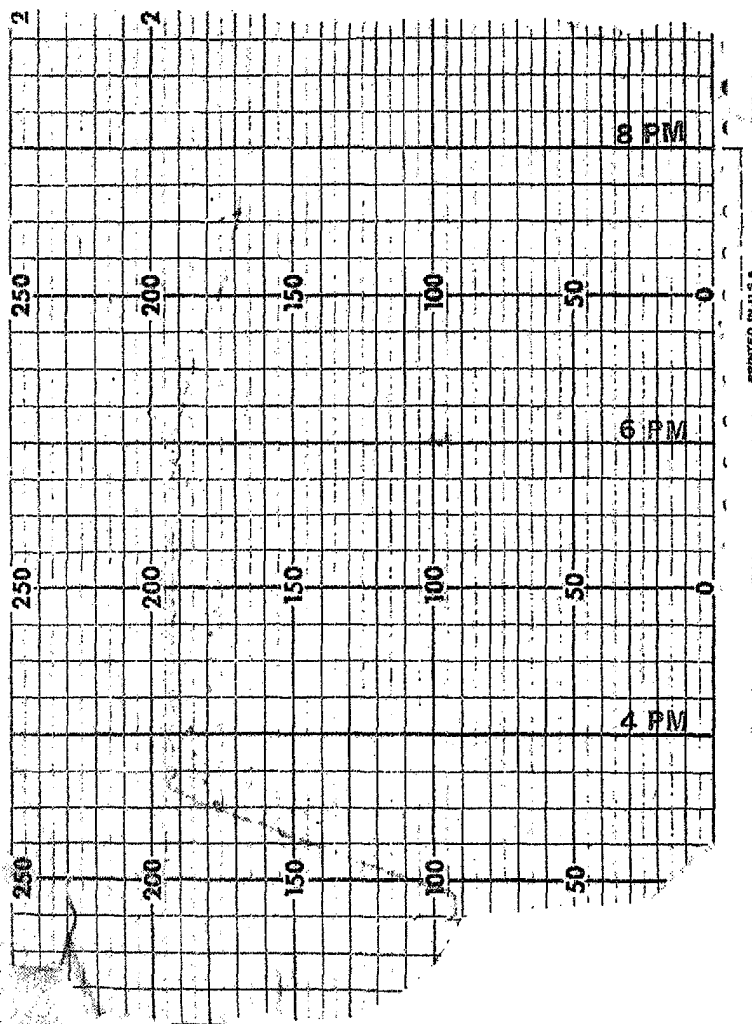
EQUIPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205 1	1 RUN 60" (992 G) WATER INTO V-203 RAW <u>AGITATOR ON HIGH SPEED</u>			
	2 WEIGH IN DRUM & POUR IN	320	32-D	320
	3 DUMP IN AND STIR 5 MIN	LOT 48 X 50	YC-2-B	2400
	RECORD: START 7:00 AM	24474		
	FIN 7:05 AM	24727		
	75" (1275 G)			
	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, WASH COLOR THRU HOMOG AT 1800-2000 PSI USING MINIMUM WATER			
	7 RECORD V-205 VOL 42" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	<u>DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED.</u>			
205 & SV 2	9 RUN TO" (514 G) WATER INTO SV START AGITATOR			
	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-243			
	RECORD: TIME START 5:25 TOTAL MIN 150			
	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 3	12 SP STEP 01 - SET FORMULA SELECTOR TO POSIT (ON #2 (V-243) OR #7 (V-244))			
	13 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
	14 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 71% - PRESET #1 80 GAL		15-A	160
	B. 13LG 83% - 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	275
	B. 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	C. 3FR10 (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 & CP 4	17 RECORD LEVEL 2 LG 29%. IF BELOW 35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
	18 ADJ TO 48" (2470 G)			
	19 RECORD: pH 10.5			
	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)	22	7-D	11
	SIPHON INTO SV. RECORD pH 11.1			
	21 OPERATOR STEP PB			

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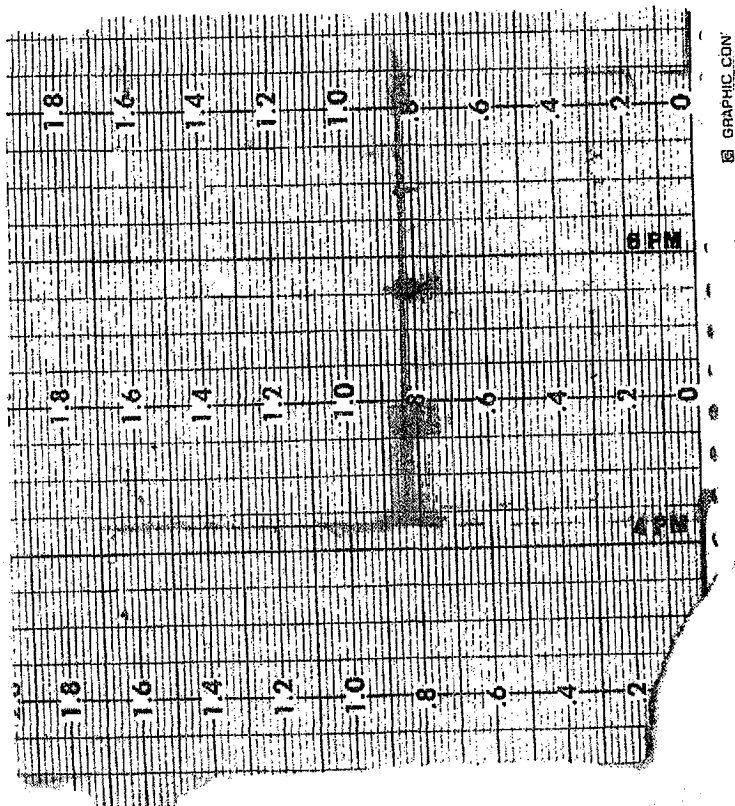
V-243

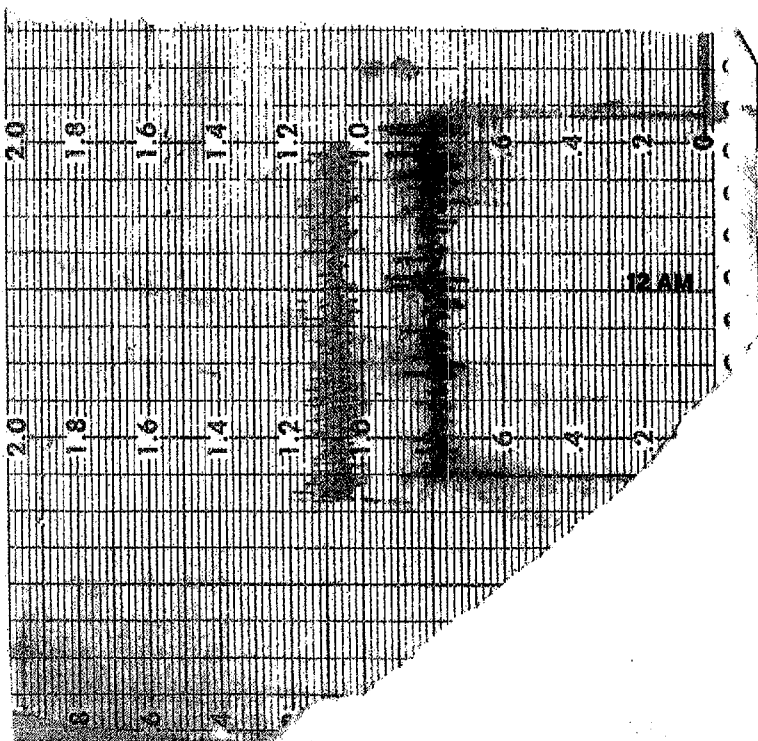
EQUIPMENT	PAGE 2	CG 03	CODE	KY-787-D	EST. WGT.	3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH <u>10.0</u> (9.5-10.0)								
SP	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO								
&	24	OPERATOR STEP PB								
CP	25	SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN 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					
		13/46 (30 MIN)	<u>7.85</u>	9.0-10.0	<u>10:55</u>					
		14/47 (60 MIN)	<u>7.85</u>	9.0-10.0	<u>11:25</u>					
		15/48 (2 HRS)	<u>7.75</u>	9.0-10.0	<u>12:25</u>					
		16/49 (2 HRS 25 MIN)	<u>7.85</u>	9.0-10.0	<u>12:50</u>					
		17/50 (3 HRS FINAL)	<u>7.1</u>	7.5-8.5	<u>1:25</u>					
		NOTE: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG								
		IF FINAL pH IS ABOVE 8.5, ADJ 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								
	31	ADJ TO 49" (382 G) AT 80 - 100°F								
	32	STIR 5 MIN & RECORD pH <u>10.1</u> (9.5-10.5)								
	33	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26								
	34	RECORD VOL <u>49</u> " & CALCULATE <u>49</u> " (VOL) X 0.78 = <u>38.2</u>								
	35	SET PRESET #8 TO <u>38.2</u> 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	SIFT IN 2 BAGS								
SP	40	SP STEP 23/53 - RECORD pH <u>3.6</u> (3.7-4.2)								
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
CP	42	RECORD: pH <u>9.1</u> (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5								
8		& RECORD: pH ASSUME 77%								
		(DILUTE 10 PARTS WATER TO 1 PART N-7-D)								
		ASSUME 50%								
		SIPHON N-7 INTO SV								
	43	OPERATOR STEP PB								
	44	SP STEP 29/58 RECORD: pH <u>9</u> (9.0-10.0) TIME <u>2:15 A</u>								
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE								
		START		FINISH						
		TIME	SP STEP	TIME	SP STEP	OPTR				
		<u>3:00 P</u>		<u>11:00 P</u>		<u>2:35</u>				
		<u>11:00</u>		<u>2:00</u>		<u>2:42</u>				



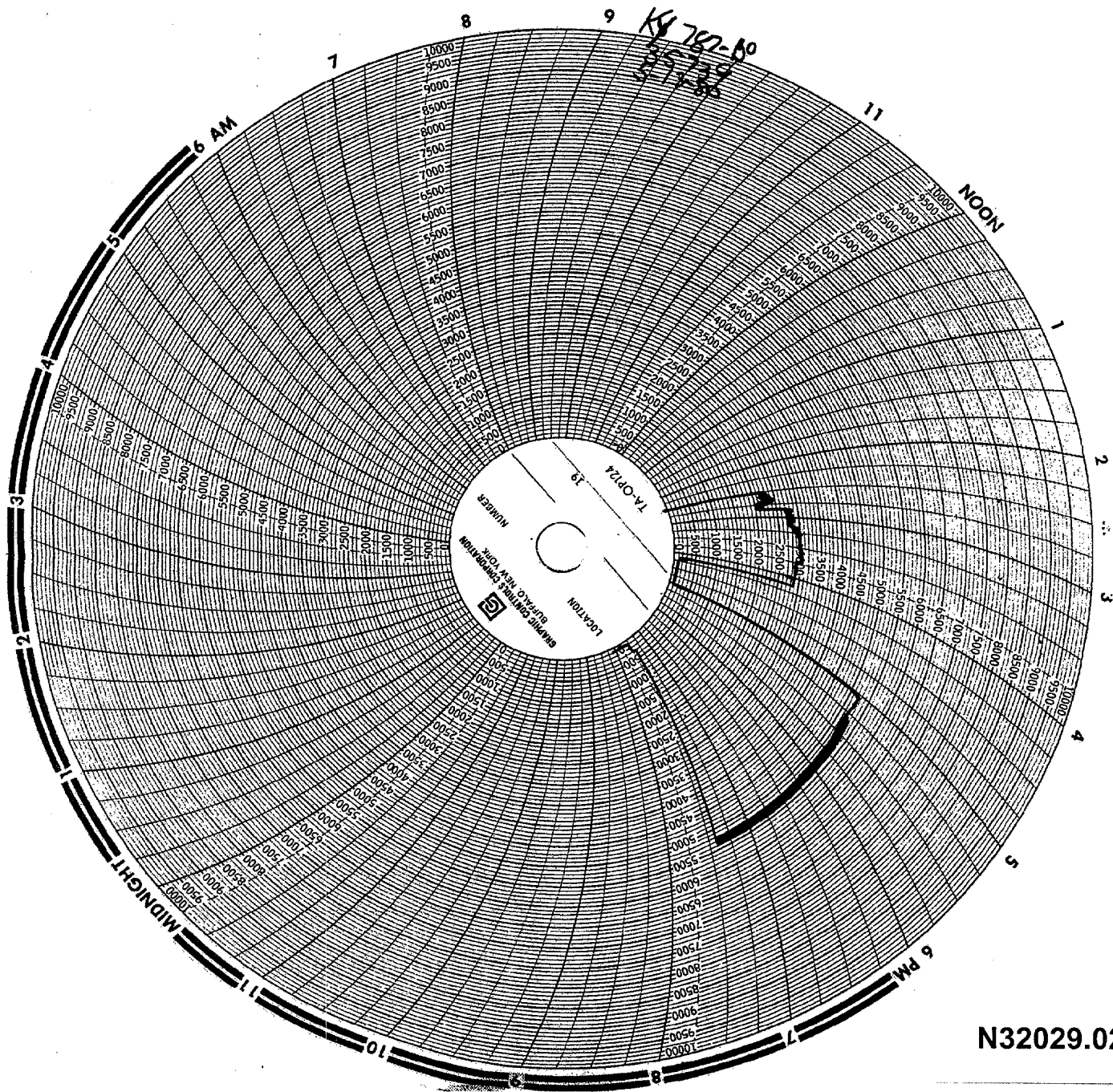
N32029.01

DUP050456297





DUP050456299



N32029.02

DUP050456300

V-243