MAKING INSTRUCTIONS: BATCH UNIT

243, 244 (Automated)

D.V.

| PROCESSES | APPROVED BY |
|---|---|
| ( ) KY-795-D (D) | EWK 10-05-76 |
| ( ) ( ) | DCG 10-07-76 |
| ( ) ( ) | MTW 10-11-76 |
| ( ) ( ) | FWP 12-22-78 |

TYPED BY emw122278

CG 03 CODE KY-795-D PKG. NAR 30 35141

1110 LBS

STD HRS 8.2 TIME 11 PM

14 YC-2-B 93 4 Lot _____, _____#

14 YC-2-B 93 4 Lot _____, _____#

14 YC-2-B 93 4 Lot _____, _____#

Total Wgt. 4612#

NON-BLEEDING

| SPMEN | | NAME: KROLOR® YELLOW MEDIUM | | USE LBS. | N CODE | ACCT LBS. |
|---|---|---|---|---|---|---|
| 203 | 1 | Run 60" (992 G) water into V-203, SET AGITATOR ON HIGH SPEED | | | | 355 |
| & | 2 | Weigh in drum & pour in | | 355 ~~475~~ | 32-D | ~~475~~ |
| ~~205~~ | 3 | Dump in & stir 5 min 3:40 P.M. | Lot, | 70 x 50 | YC-2-B | 3500 |
| | 1 | Record: Start 3:10 P.M. | 24774 | 2000 | | |
| V-263 | | Fin | 24778 | 400 | | |
| | | ~~75"~~ (1275G) | 24773 | 900 | | |
| | 4 | ~~Adj to 78" (1328 G)~~ | | | | |
| | 5 | Pump V-203 thru Homog at 2400-2600 psi into ~~V-205~~ V-263 | | | | |
| | 6 | When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water | | | | |
| | 7 | Record: V-205 Vol " & adj to 51" (1874 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-243 & start agitator~~ | | | | |
| & | 10 | ~~Pump V-205 thru Homog at 4800-5200 psi into V-~~ | | | | |
| SV | | Record: Time Start 5:30 AM Total Min 150 | | | | |
| | 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. Rinse in using Hot Water | | | | |
| SP | 12 | SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (V-244) | | | | |
| & | 13 | Press SV Cam Reset PB set 22 TC in Auto Remote | | | | |
| CP | 3 | (Temperature is set at 190-194oF) | | | | |
| | 14 | Record levels and set Raw Material Counter #1 as follows: | | | | |
| | | a. 11 LG 45 % - preset #1 | 104 Gal | | 15-A | 208 |
| | 15 | Set strike flow controllers as follows: | | | | ~~295~~ |
| | | a. 3FC10 (N-27-D Controller) in Manual 0.71 | ~~0.95~~ GPM | | 27-D | ~~394~~ |
| | | b. 3FC20 (N-27-D Water) in Manual Local 5.76 | ~~7.7~~ GPM | | | |
| | | c. 3FR10 (N-27-D / Water Ratio) | 0.8 | | | |
| | | d. 8FC10 (N-32-D Controller) in Manual 0.95 | ~~1.27~~ GPM | | 32-D | ~~2675~~ |
| | | e. 8FC20 (N-32-D Water) in Manual Local 4.6 | ~~6.2~~ GPM | | | 2001 |
| | | f. 8FC20 (N-32-D Water) in Remote | | | | |
| | | g. 8FR10 (N-32-D / Water) Ratio | 1.0 | | | |
| SV | 16 | Operator Step PB | | | | |
| SP | 17 | Record Level 2LG 85 % if below 35% follow solution make- | | | | |
| & | | up procedure for N-27-D | | | | |
| CP | 18 | Adj SV to 68" (3495 G) | | | | |
| 4 | 19 | Record: pH 10.5 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D) | Assume 50% | 18 | 7-D | 9 |
| | | Siphon N-7-D into SV & Record: pH 11.1 | | | | |
| | 20 | Operator Step PB | | | | |

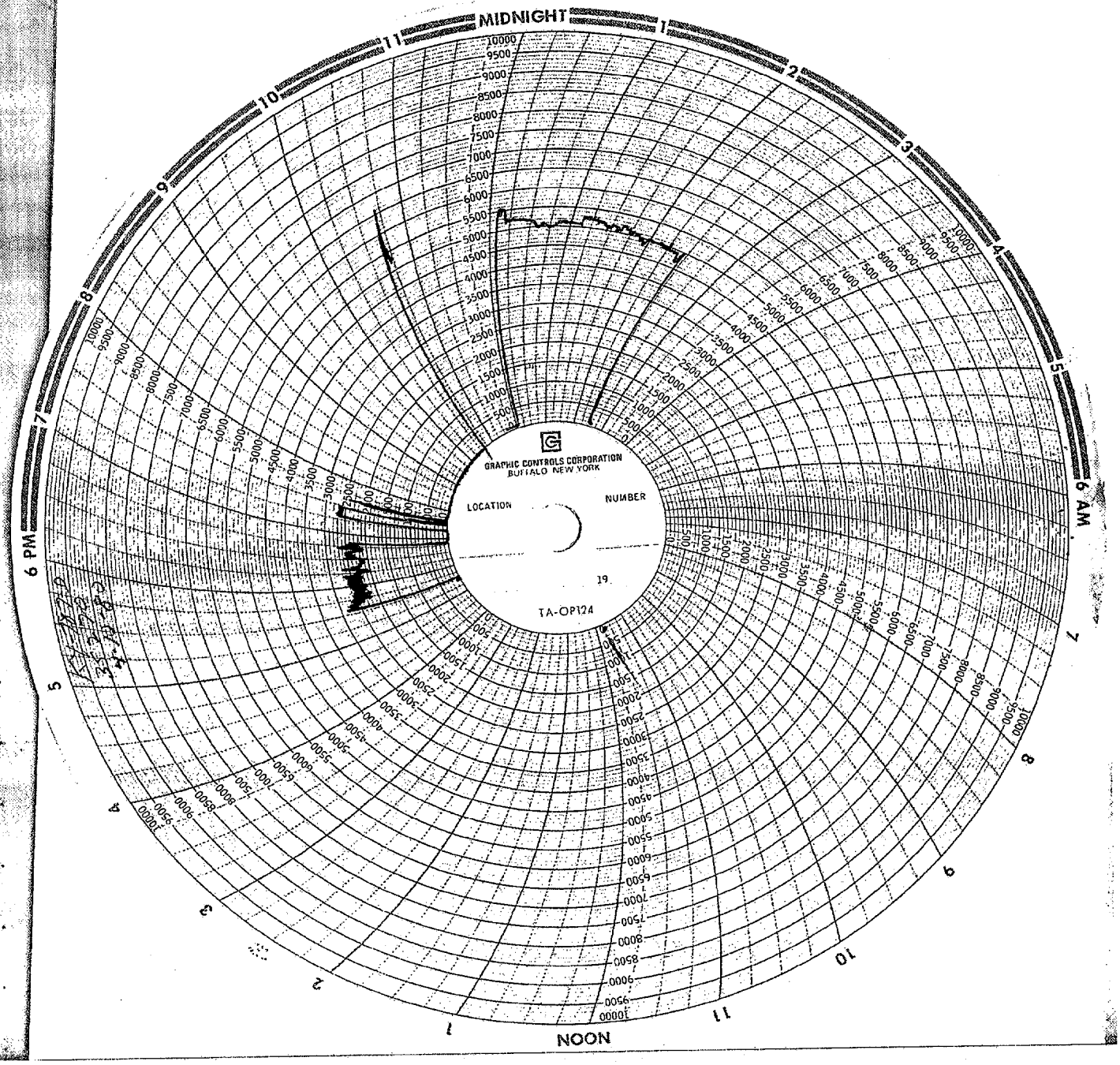
# V-243

| UIPMENT | | PAGE 2 CG 03 CODE KY-795-D (H) EST. WGT. 4612 LBS. | USE LBS. | N CODE | ACC LB |
|---|---|---|---|---|---|
| SV | 21 | SP Step 06/39 - After heat up Record: pH 9.7 (9.5-10.0) | | | |
| SP | 22 | Switch 3FC20, 8FC10, 8FC20, to Auto | | | |
| & | 23 | Operator Step PB | | | |
| CP | 24 | SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits | | | |
| 5 | | switch 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 NOTE: RECORD ph 9.65 | | | |
| | 27 | During Strike, Record pH & Time as follows: | | | |
| | | SP Step | 10 | 45 AM | |
| | | V-243/V-244 pH Range Time | | | |
| | | 13/46 (30 min) 9.5 9.0-10.0 11:15 | | | |
| | | 14/47 (60 min) 9.5 9.0-10.0 11:45 | | | |
| | | 15/48 ( 2 hrs) 9.7 9.0-10.0 12:45 | | | |
| | | 16/49 ( 3 hrs) 9.75 9.0-10.0 1:45 | | | |
| | | 17/50 (Final) 7.7 7.5- 8.5 2:30 | | | |
| | | NOTE: If not as specified notify Supervisor & note in log | | | |
| | | If final pH above 8.5 adj to 7.5-8.5 | | | |
| | | & Record: pH Assume 77% | | 27-D | |
| Drum | 28 | Weigh into 55 Gal Drum Assume 50% | 56 | 7-D | 28 |
| 7 | 29 | Fill with water & stir 2 min | | | |
| SV | 30 | SP Step 17/50 - After checking pH, Operator Step PB | | | |
| SP | 31 | Step 23/53 - Record: pH 3.5 (3.3-3.7) | | | |
| & | 32 | If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH / | | 15-A | |
| CP | ~~33~~ | ~~Sift in 2 bags~~ | ~~150~~ | ~~28-A~~ | ~~150~~ |
| 8 | 34 | Siphon in N-7-D from S 29 in 10-12 min & stir 5 min | | | |
| | 35 | Record: pH 3.9 (4.0-4.2) & if necessary adj to pH 4.0-4.2 | | | |
| | | & Record: pH 4.0 Assume 77% | | 27-D | |
| | | (Dilute 10 parts water to 1 part N-7-D) Assume 50% | 12 | 7-D | 6 |
| | | Siphon N-7-D into SV | | | |
| | 36 | Operator Step PB (RECORD INCHES IN VAT ON 2 SAMPLE TICKETS) | | | |
| | 37 | SP Step 24/54 - Pour in & stir 15 min | 22 | 978-A | 22 |
| | 38 | Operator Step PB | | | |
| | 39 | SP Step 60 - Batch complete | | | |
| | ~~40~~ | PUMP TO V-240 | | | |

2 SAMPLE

TAKE VAT CONTENTS

| START TIME | SP STEP | FINISH TIME | SP STEP | OPTR |
|---|---|---|---|---|
| ~~5:30P~~ | | 11:00P | | 120 |
| 7:00A | | 3:00PM | | 235-323 |
| 3P | | 3:30P | | 120 |

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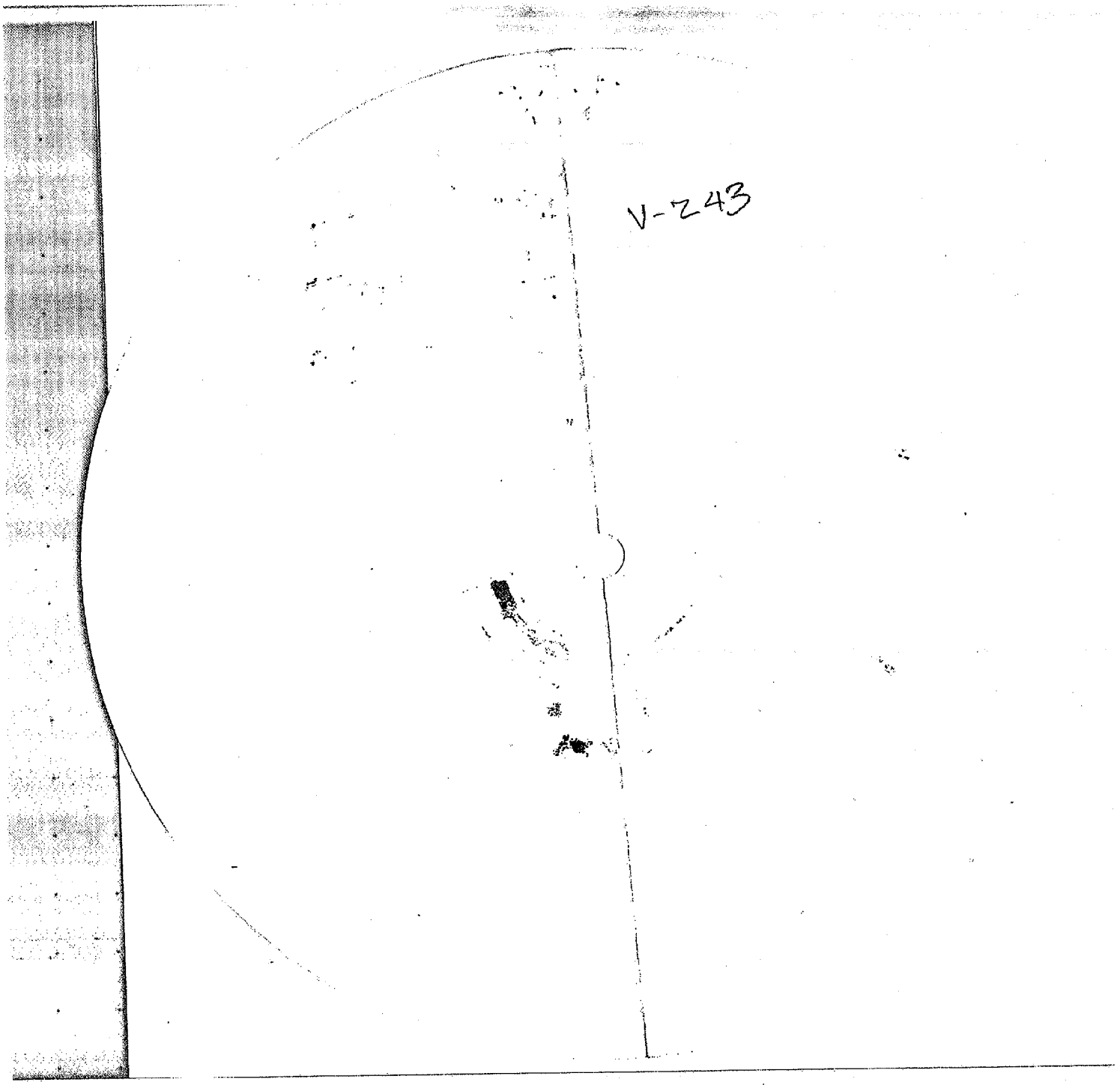


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