

CG 03 CODE KY-788-D PKG.

→ MAR. 18 34856

EST. WGT. 360 LBS.

PUNCHED & CHECKED

MAR 20 1980

PROCESSES	APPROVED BY
() KY-788-D	(J) EWK 9/28/76
()	() MTW 9/30/76
()	() DCG 9/30/76
()	()
TYPED BY	
NE 2-18-77	

STD. HRS. 8.8 TIME M
 14 YC-3-B 98 4 Lot 24699, 2600*
 14 YC-3-B 98 4 Lot
 14 YC-3-B 98 4 Lot

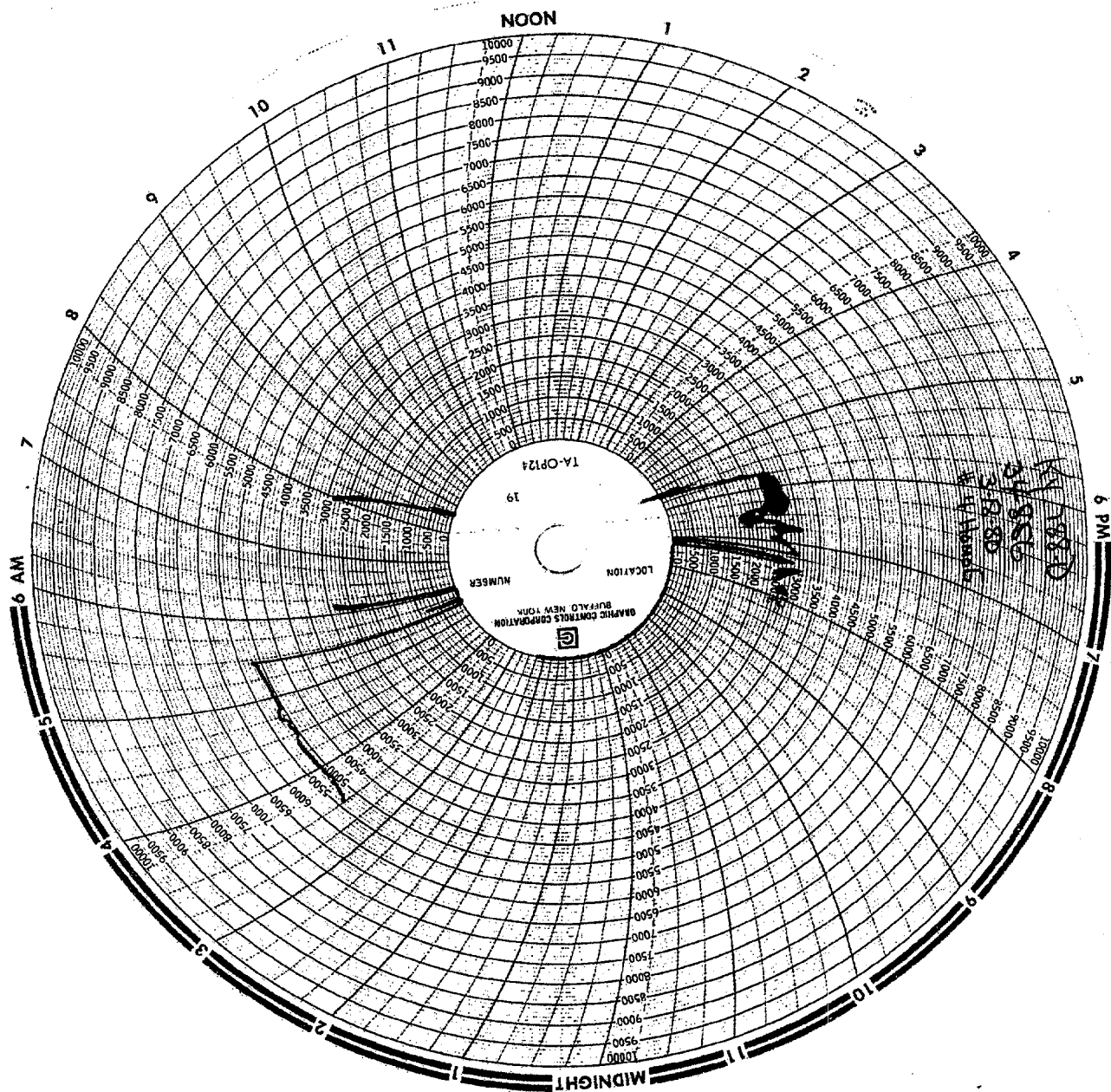
Total Wgt. 3460
 3600

NON-BLEEDING

MENT	NAME:	USE LBS.	N CODE	ACC LBS.
203	1 Run 23" (360 G) water into V-203 SET AGITATOR ON HIGH SPEED			
&	2 Weigh in drum & pour in	345	32-D	345
205	3 Dump in & stir 5 min Lot 52 x 50		YC-3-B	2600
1	Record: Start 4:15 PM 24699 2600			
	Fin 5:30 PM			
	75" 12756			
	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. 40 " & adj to 60" (1200 G)			
	8 Inspect homog. strainer & clean if necessary			
	9 DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED			
205	9 Run 10" (514 G) water into V- 247 & start agitator			
8	10 Pump V-205 thru Homog at 4800-5200 psi into V- 247			
	Record: Time Start 2:30 AM total min 150			
	Note: If Homog pressure falls below 4800 ps., 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			
	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)			
	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 60% - preset #2 208 Gal		15-A	416
	b. 13LG 68% - 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. 8FR10 (N-32-D/Water Ratio) 1.1			
	16 Operator Step PB			
	17 Record Level 21G 7.1 %. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.2. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.2	30	7-D	15
	20 Operator Step PB			

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MENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS.
SV	21	SP Step 06/39 - After heat up Record: pH <u>9.7</u> (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.						
		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: <u>6:35 AM</u>						
		SP Step						
		V-243/V-244 pH Range Time						
		13/46 (30 min) <u>9.6</u> 9.3-10.0 <u>7:05 AM</u>						
		14/47 (60 min) <u>9.6</u> 9.3-10.0 <u>7:35</u>						
		15/48 (2 hrs) <u>9.6</u> 9.3-10.0 <u>8:35</u>						
		16/49 (2 hrs 25 min) <u>9.6</u> 9.3-10.0 <u>9:00</u>						
		17/50 (Final 3 hrs) <u>7.75</u> 5-8.5 <u>9:35 AM</u>						
		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						
	28	While striking run 30" (234 G) water into V-339						
	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 <u>10.2</u> (9.5-10.5)						
	32	Stir 15 min or longer to dissolve for SP Step 26/56						
	33	Record Vol <u>49</u> " & Calculate <u>49</u> " (Vol X 0.78= <u>38.2 G</u>)						
	34	Set preset #8 to <u>38.2 G</u> from S 33						
92	35	Run 40" (440 G) water into V-302						
	36	Add & stir 2 min for S 40 Assume 50% 360 7-D 18						
V	37	SP Step 17/50 After checking pH. Operator Step PB						
	38	Sift in 2 bags <u>3.35</u> <u>3.7-4.2</u> 100 100-A 10						
	39	SP Step 23/53 Record: pH						
	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min						
	41	Record: pH <u>9.5</u> (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 <u>9.4</u> (9.0-10.0) Time <u>11:00 AM</u>						
	44	Operator Step PB						
	45	SP Step 60 - Batch complete						
		Start Finish Optr						
		Time SP Step Time SP Step						
		<u>5:30 PM</u> <u>7:00 PM</u> <u>381</u>						
		<u>11:00 PM</u> <u>7:00 AM</u> <u>237</u>						
		<u>7:00 AM</u> <u>11:00 AM</u> <u>235</u>						



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