

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

s.v. 243, 244 Automated

c.v.

APR 25 1980

D.V.

CG 03 CODE KY-781-D PKG.

APR 23 35490
EST. WGT. 1128 LBS.

STD. HRS. TIME 77 M

14 YC-3-B 93 4 24419 3300 #
14 YC-3-B 93 4 #
14 YC-3-B 93 4 #

Total Wgt. 4428# (Req)

APR 23 1980

NON-BLEEDING

PROCESSES		APPROVED BY	
()	KY-781-D (M)	()	FWP 101378
()	()	()	AMJ 101378
()	()	()	
()	()	()	
TYPED BY			
EMW101378			

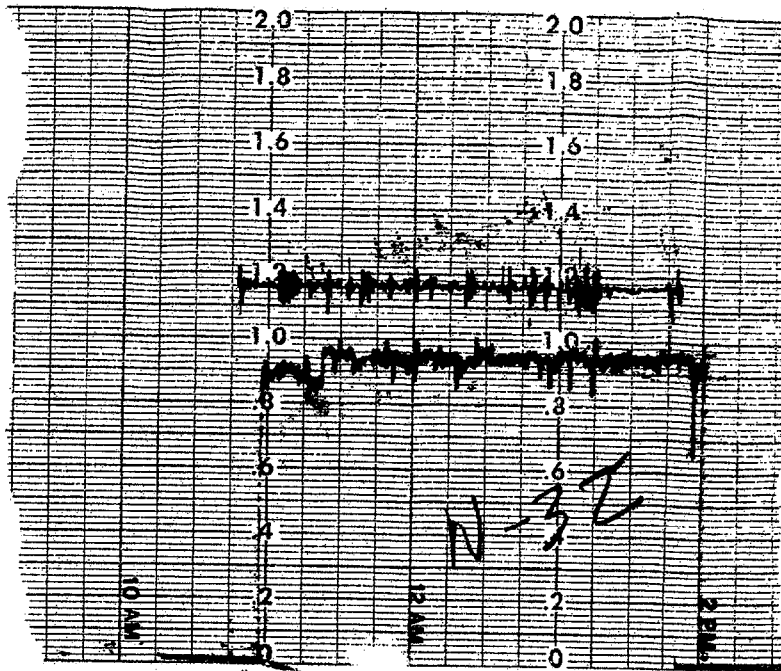
EQUIPMENT	NAME:	USE LBS.	N CODE	ACGT. LBS.
203	KROLOR® YELLOW LIGHT			
203 & 205	Run 60" (992 G) water in V-203 & add	Assume 50%	36	7-D 18
205	Weigh in drum & pour in		442	32-D 442
1	Dump in & stir 5 min	Lot	66 x 50	YC-3-B 3300
	Record: Start 4:30 AM	24419	3300	
	Fin 6:15 AM			
	75" (12756)			
	Adj to 80" (1360 G) & Record: pH 10.6 (10.5-11.5)			
	Pump V-203 thru Homog # 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 " & adj to 45" (1662 G)			
	Inspect Homog strainer & clean if necessary			
	During Homog, Run V-203 AGITATOR ON LOW SPEED			
205 & SV	Run 12" (200 G) water into SV & start agitator			
205	Pump V-205 thru Homog at 4800-5200 psi into V-203			
2	Record: Time Start 7:40 AM Total Min 120			
	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 & 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:			
	11KG 1 X - preset #3 187 Gal		15-A	374
	15 Set strike flow controllers as follows:			
	27 AFC10 (N-27-D Controller) in Manual 0.9 GPM		27-D	373
	27 AFC20 (N-27-D Water) in Manual Local 0.3 GPM			
	27 AFC10 (N-27-D / Water Ratio) 0.7			
	32 AFC10 (N-32-D Controller) in Manual 1.20 GPM		32-D	2527
	32 AFC20 (N-32-D Water) in Manual Local 5.4 GPM			
	32 AFC20 (N-32-D Water) in Remote 0.9			
	32 AFC10 (N-32-D / Water Ratio)			
SV & CP	16 Operator Step PB			
4	17 Record Level 21G 4. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 54" (2800 G)			
	19 Record: pH 10.4			
	20 Adj pH to 11.4-11.6 using Assume 50%		7-D	75
	21 Dilute to 5% (10 parts water to 1 part N-7-B)			
	Siphon into SV. Record: pH 11.6			
	21 Operator Step PB			

K 12020 REV.

N32242

✓ 243

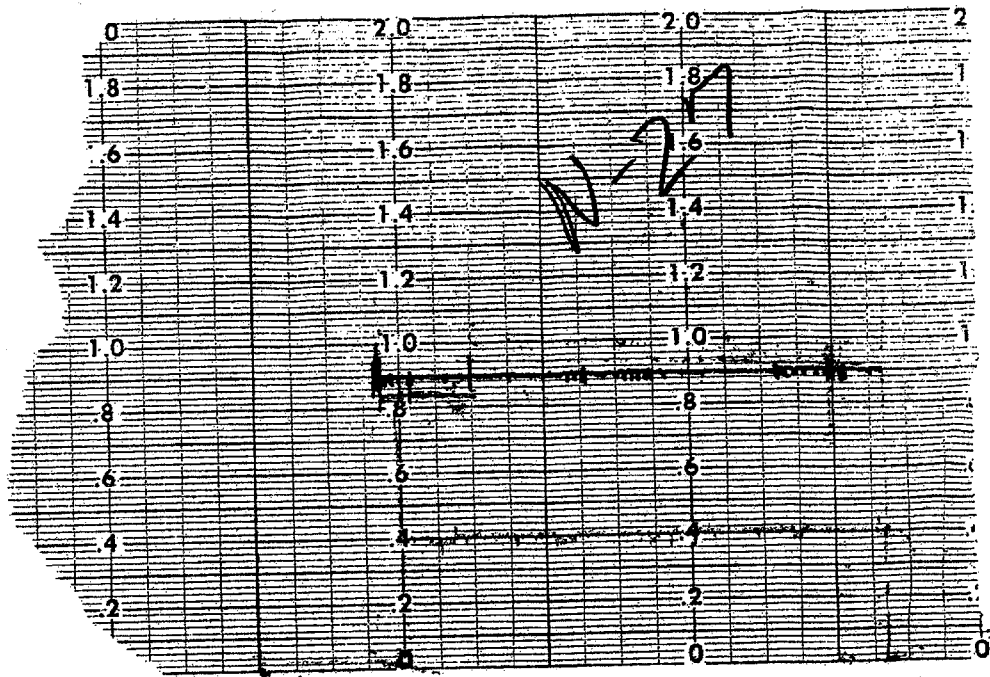
EQUIPMENT	PAGE 2	CG 03 CODE	KY-781-D	N EST. WGT.	1128 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV SP & CP 5	22	SP Step 06/39. After heat up Record: pH 10.05(9.6-10.2)						
	23	Switch 3FC20, 8FC10, 8FC20, to Auto						
	24	Operator Step PB						
	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flow in limits						
		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)	9.8	9.3-10.0	12:10			
V-302 6	28	Add 31" (379 G) water to V-302						
	29	Add & stir 5 min				Assume 50%	124	7-D 62
	30	SP Step 17/50 after checking pH. Operator PB						
	31	SP Step 23/53 Record: pH 3.6(3.3-3.7)						
	32	If necessary adj pH (DOWN ONLY) Record: pH					15-A	
		NOTE: Dissolve extra N-15-A in water at 110-120°F in drum						
		Use ±30 Gal of water to 50# N-15-A. Stir SV 5 min						
		after each addition						
	33	Sift in				✓ 150	128-A	150
	34	Run in N-7-D from S 29 & stir 5 min						
SV SP & CP 7	35	Record: pH 3.8(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%	40	7-D	20
		Siphon (if N-7-D) into SV. Record: pH 4.2						
	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			
		6 AM		7 AM		282-381		
		7:00 PM		3 PM		120 - 126		
		3:00 PM		4:40 PM		235 - 237		



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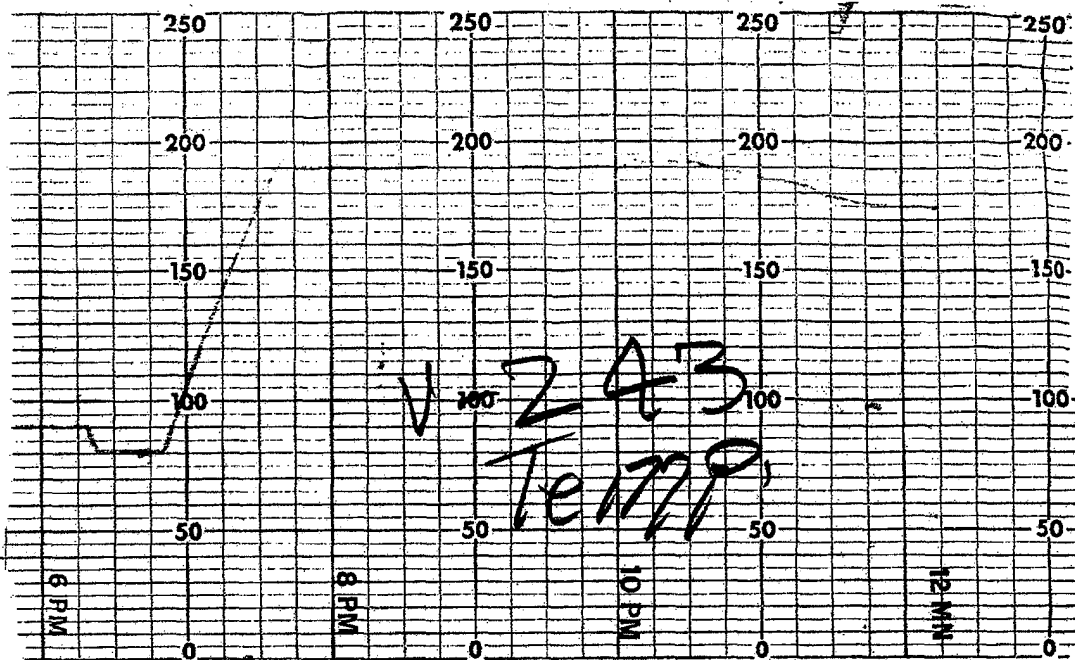
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