SV 243, 244 Automated C.V. D.V.

CG 03 CODE KY-781-D PKG. YC-3-B OK

JAN 16 33855

EST. WGT. 818 LBS.

STD. HRS. TIME

PROCESSES		APPROVED B
( ) KY-781-D	(N)	FWP 10-13-78
( )	( )	AMJ 10-13-78
( )	( )	FWP 06-26-79
( )	( )	
TYPED BY emw062879		

14 YC-3-B 93 4 Lot 23868, 1600# (TJW)
14 YC-3-B 93 4 Lot 24408, 1250#
14 YC-3-B 93 4 Lot _____, _____#
14 YC-3-B 93 4 Lot _____, _____# 03 KY-781-D 98 LOT 28326, 600#

Scrub #2 Alm Homog #4 - 1ST Pass
" #3 - 2ND "

Total Wgt 4268# (Req. _____)

NON-BLEEDING

EQUIPMENT	#	NAME: KROLOR® YELLOW LIGHT	USE LBS.	N CODE	ACC LBS
203 & 205 1	1	Run 60" (992 G) water in V-203 & add Assume 50%	30	7-D	15
	2	Weigh in drum & pour in	382	32-D	382
	3	Dump in & stir 5 min Lot	57 x 50	YC-3-B	2850
		Record: Start 900 PM 23868	1600		
		Fin 1000 PM 24408	1250		
		75" (1275G)			
	4	Adj to ~~80" (1360 G)~~ & Record: pH (10.5-11.5)			
	5	Pump V-203 thru Homog # at 1800-2200 psi into V-~~205~~ 263			
	6	When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water 263			
	7	Record: V-205 Vol 38 " & adj to 45" (1662 G)			
	8	Inspect Homog strainer & clean if necessary			
205 & SV 2	9	Run 12" (200 G) water into SV & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into V-244			
		Record: Time Start 10:25 AM Total Min 120			
		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 & pump thru Homog at 4800-5200 psi			
SP & CP 3	12	SP Step 01 Set Formula Selector to position #1 (V-243) or #6 (V-244)			
	13	Press SV Cam Reset PB-Set 22TC in Auto Remote (Tempterature is set at 190-194°F)			
	14	Record levels & set Raw Material Counter #1 as follows:			
		a) 11LG 59 % — preset #3 162 Gal		15-A	324
	15	Set strike flow controllers as follows:			
		a) 8FC10 (N-27-D Controller) in Manual 0.78 GPM		27-D	322
		b) 8FC20 (N-27-D Water) in Manual Local 5.44 GPM			
		c) 8FR10 (N-27-D / Water Ratio) 0.7			
		d) 8FC10 (N-32-D Controller) in Manual 1.04 GPM		32-D	2182
		e) 8FC20 (N-32-D Water) in Manual Local 4.66 GPM			
		f) 8FC20 (N-32-D Water) in Remote			
		g) 8FR10 (N-32-D / Water Ratio) 0.9			
SV SP & CP 4	16	Operator Step PB			
	17	Record Level 2LG 40 %. If below 35% follow solution make-up procedure for N-27-D			
	18	Adj SV to 54" (2800 G)			
	19	Record: pH 10.2			
	20	Adj pH to 11.4-11.6 using Assume 50%	30	7-D	15
		(Dilute to 5% (10 parts water to 1 part N-7-D))			
		Siphon into SV. Record: pH 11.5			
	21	Operator Step PB			

(TJW)

REV.

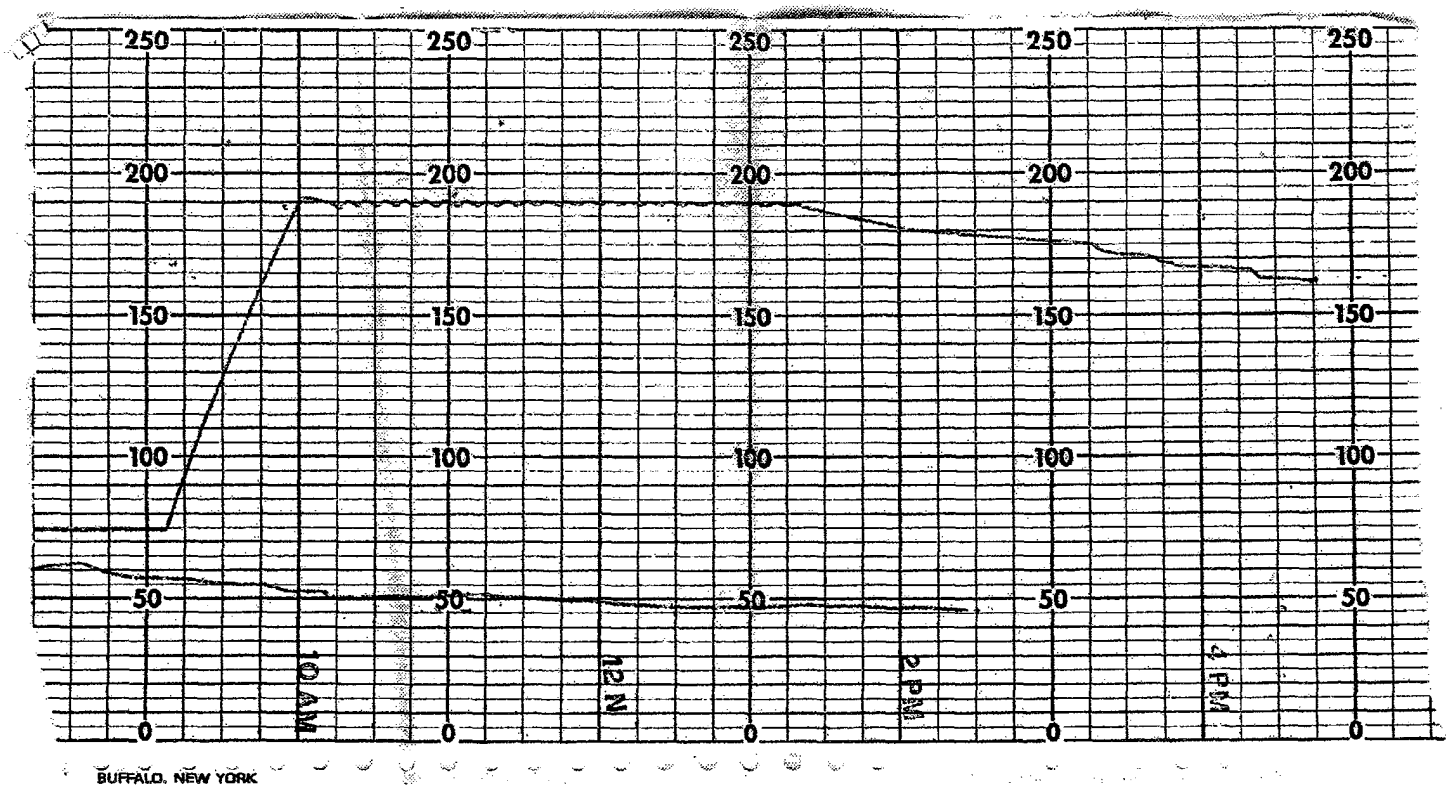
N 26

V-244

EQUIPMENT		PAGE 2 CG 03 CODE KY-781-D (N) EST. WGT. 4268 LBS.	USE LBS.	N CODE	AC LI
SV	22	SP Step 06/39 — After heat-up Record: pH 9.5 (9.6-10.2)			
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto 3:35 PM			
&	24	Operator Step PB			
CP	25	SP Step 10/43 — When 3FC20, 8FC10, 8FC20 water flow in limits switch 3FC10 to Auto. Operator Step PB			
5	26	SP Step 11/44 — When 3FC10, 3FC20 flow in limits, switch 3FC20 to Remote. Opterator Step PB			
	27	During strike, Record pH & Time as follows:			
		SP Step — pH — Range — Time			
		13/41 (30 min) — 9.6 — 9.3-10.0 — 4:05			
		14/47 (60 min) — 9.6 — 9.3-10.0 — 4:35			
		(2 hrs) — 9.6 — 9.3-10.0 — 5:35			
		(3 hrs) — 9.6 — 9.3-10.0 — 6:35			
		17/50 (Final) — 8.0 — 7.5- 8.5 — 5:20			
		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	
ALM	28	During strike clean #2 ALM magnetic separator & pump strainer			
6	29	Install dust hood to #2 ALM & run in 2000# water			
	30	Dump in Lot 28326	600	KY-781-D	600
	31	Stir 60 min. Add water as necessary to fluidize			
	32	When strike (S 27) complete, pump ALM thru box screen into SV 200			
	33	Rinse in ALM & lines			
	34	Clean magnetic separator & strainer			
302	35	Add 31" (379 G) water to V-302			
7	36	Add & stir 5 min Assume 50%	110	7-D	55
SV	37	SP Step 17/50 — After checking pH. Operator PB			
SP	38	SP Step 23/53 — Record: pH 3.4 (3.3-3.7)			
&	39	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			
8		Use ± 30 G of water to 50# N-15-A. Stir SV 5 min after each addition			
	40	Run in N-7-D from S 36 & stir 5 min			
	41	Record: pH 4.2 (4.2-4.4)			
	42	If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts H_2O to 1 part N-7-D) or N-27-D M , %		27-D	
		Assume 50%		7-D	
		Siphon (if N-7-D) into SV. Record: pH			
	43	Operator Step PB			
	44	SP Step 24/54 — Add N-978-A & stir 15 min	17	978-A	17
	45	Operator Step PB			
	46	SP Step 60 — Batch complete			

START Time	START SP Step	FINISH Time	FINISH SP Step	OPTR
11:00P		7:00A		235-259
7:00AM		3:00PM		381-86
3:00P		10:15P		126-201

DUP050094196



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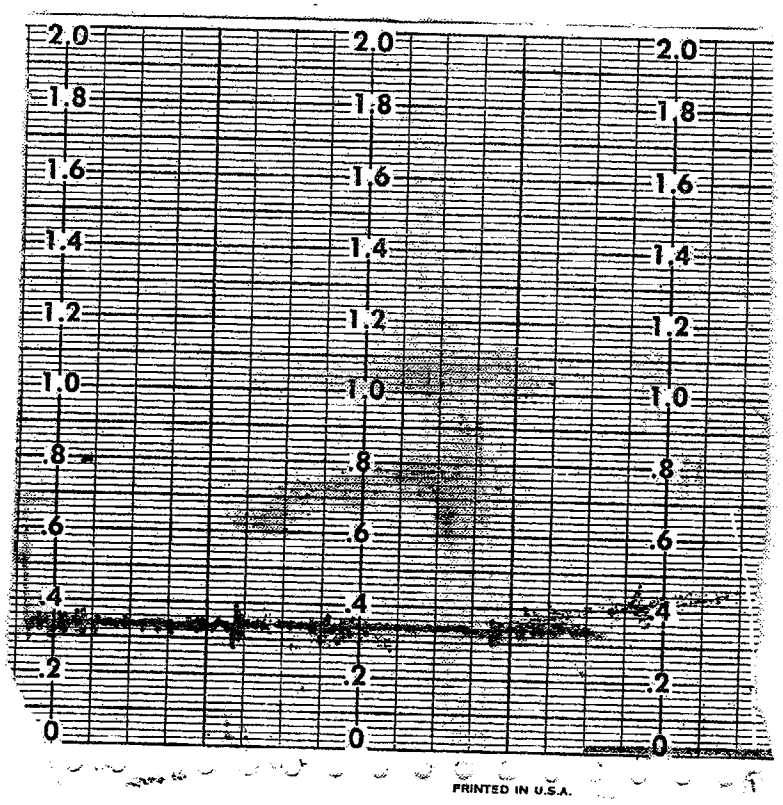

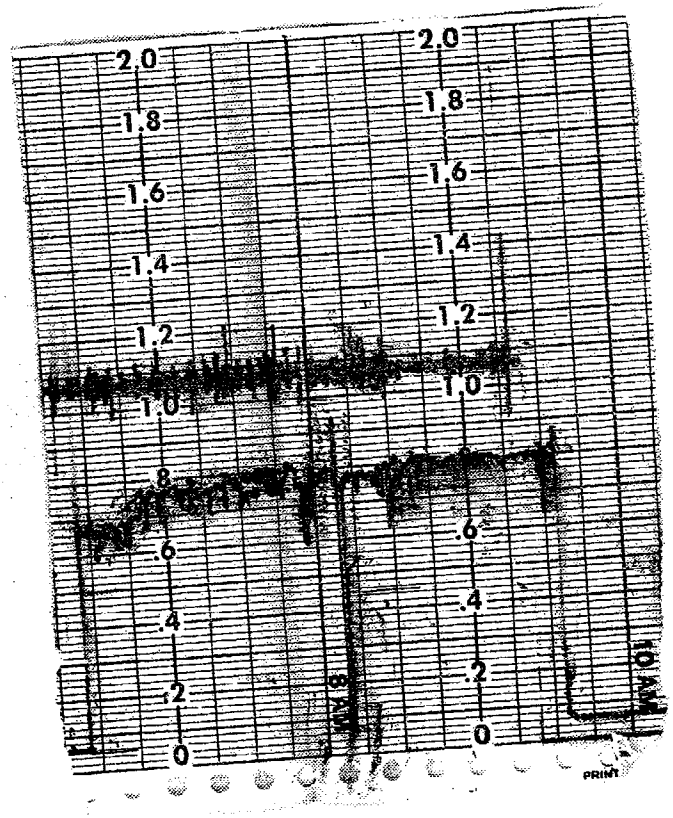

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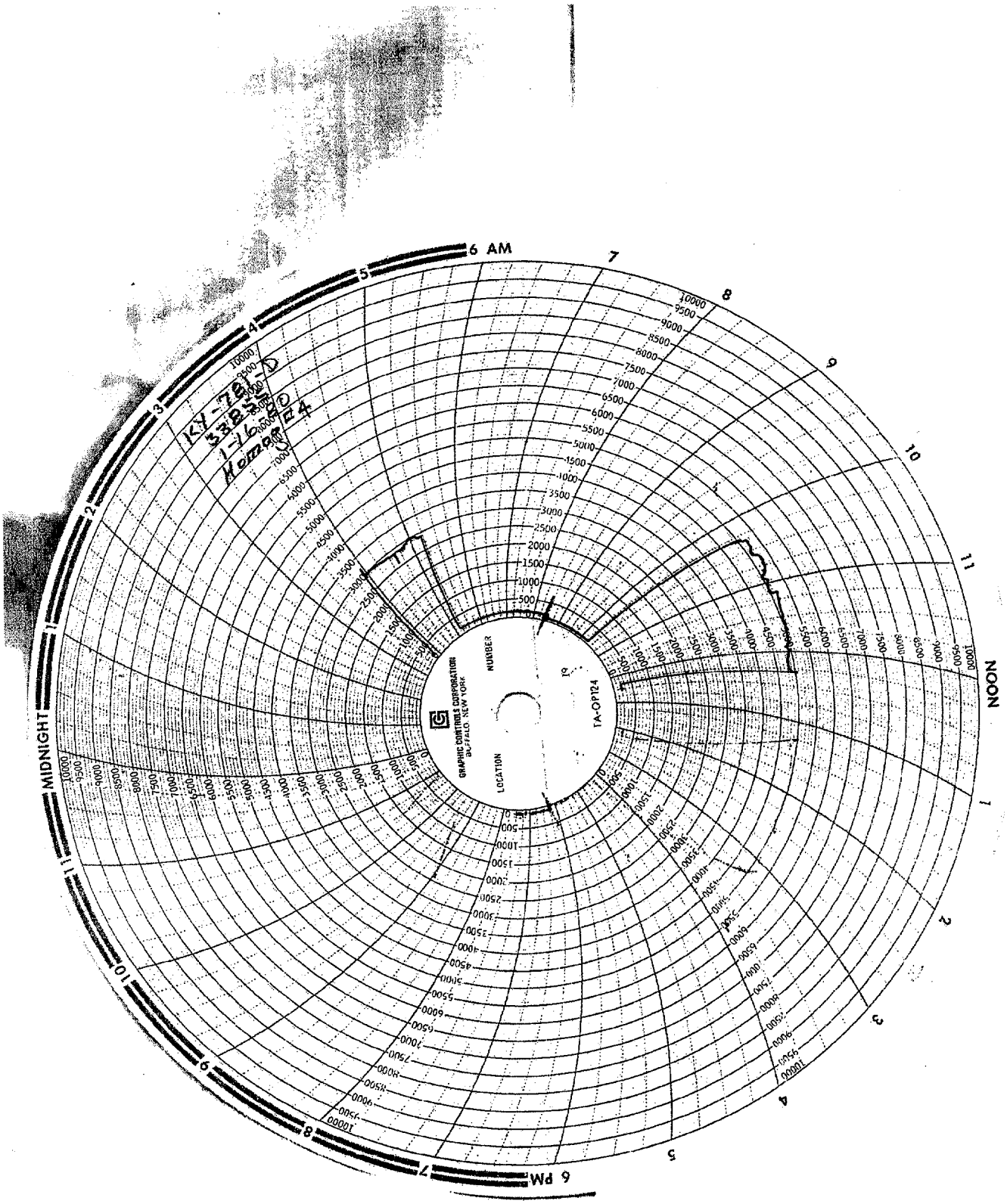

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