

S.V. 243, 244 (Automated)

C.V.

D.V.

CC 03 CODE KY-907-D PKG.

FEE-49 34233

Feb 9.

EST. WGT. 1080 LBS.

STD. HRS. TIME

14 YC-2-B 93 4 Lot 24467, 400#
14 YC-2-B 93 4 Lot 24470, 2000#
14 YC-2-B 93 4 Lot

PROCESSES		APPROVED BY	
()	KY-907-D	(D)	EWK 12/12/77
()		()	DCG 12/13/77
()		()	MW 12/15/77
()		()	
TYPED BY			
rj 2/3/78			

WATER & COLOR ONLY

ND-N-32-D

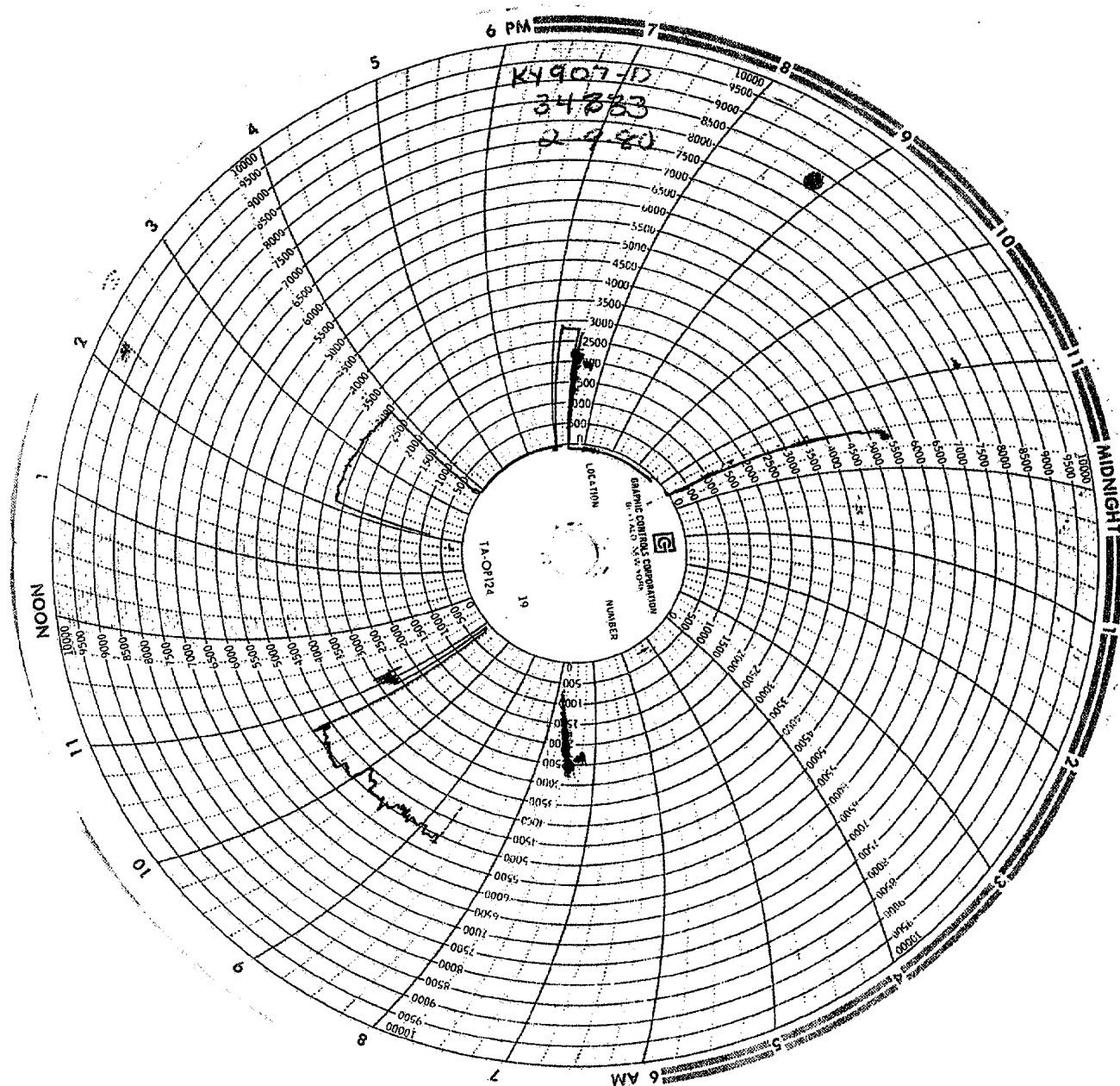
Total Weight - 3480#

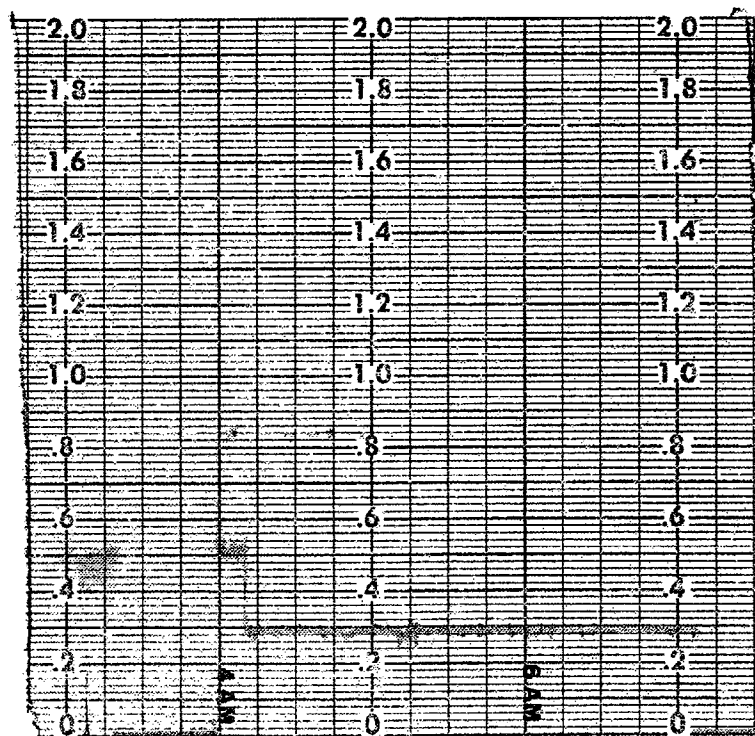
NON-BLEEDING

EQUIPMENT	NAME: (9909) KROLOR® - YELLOW MEDIUM	USE LBS.	N CODE	ACCT, LBS.
203	1 Run 33" (560 G) water into V-203			
&	2 Pour in	320	32-D	320
205	3 Dump in	48 x 50	YC-2-B	2400
1	Record: Start	24467		
	Fin	24470		
	4 Adj to 70" (1200 G)	2400-2600		
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205	V-2163		
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record V-205 Vol. 54 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514 G) water into SV & start agitator			
1	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
	Record: Time Start 8:35 AM Total Min 1:40			
	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
	12 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 #2 (V-243) or #7 (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 Materials Counter #1 as follows:			
	11LG 64 % - preset #1 80 Gal		15-A	160
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.83 GPM		27-D	275
	b. 3FC20 (N-27-D Water) in Manual Local 5.28 GPM			
	c. 3FC20 (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 SP & CP	16 Operator Step PB			
4	17 Record Level 2 LG 93 %. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj to 48" (2470 G)			
	19 Record: pH 10.4			
	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)		7-D	20
	Siphon into SV Record: pH 11.3			
	21 Operator Step PB			

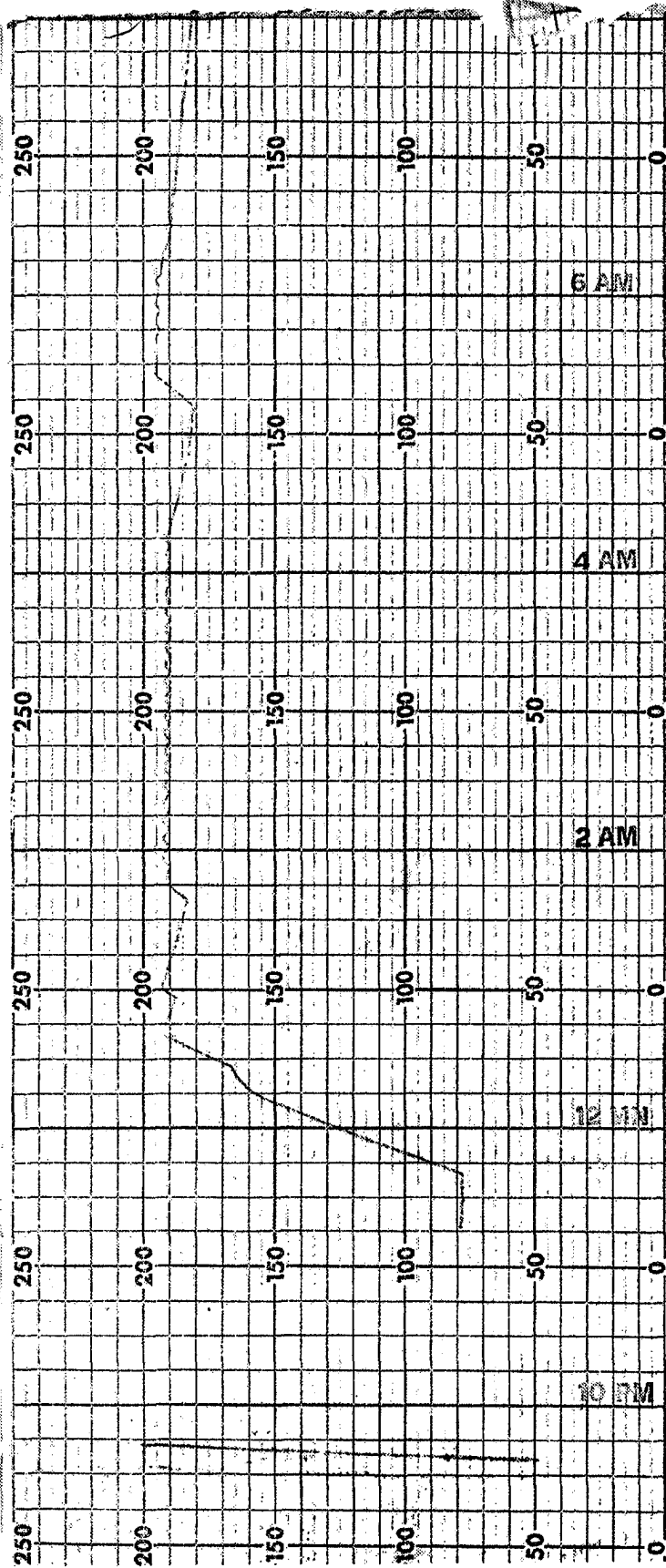
V-244

EQUIPMENT	PAGE	CG	03	CODE	KY-907-D (D)	EST. WGT.	3480	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV SP & CP 5	22	SP Step 06/39 - After heat up Record: pH <u>10.0</u> (9.5-10.0)									
	23	Switch 3FC20, 8FC10, 8FC20 to Auto									
	24	Operator Step PB									
	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits									
	26	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)	10.0	9.0-10.0	3:05				
				14/47 (60 min)	10.0	9.0-10.0	3:36				
				15/48 (2 hrs)	10.0	9.0-10.0	4:23				
				16/49 (2 hrs 25 min)	10.0	9.0-10.0	5:00				
				17/50 (3 hrs Final)	9.3	7.5-8.5	5:39				
		NOTE: (1) If pH not as specified notify Supervisor & note									
		in log (2) If final pH is above 8.5, adj pH to 7.5-8.5 &									
				Record: pH			Assume 78%				
	29	Sift in									
								50		27-D	50
	302	30	Add 17" (208 G) water to V-302								
	6	31	Add & stir 2 min for S58								
							Assume 50%	100.80		7-D	40 90
PT 7	32	During strike pump into PT									
	33	Pump in									
	34	Pump in									
	35	Stir 10 min with lightning mixer for S39									
356 8	36	During strike run 20" (244 G) water into V.356									
	37	Turn on steam									
	38	Adj to 26% (317 G) at 178-182°F 81-82°C									
	39	Pump PT mixture from S35 thru undersurface									
		Distributor AFAP									
	40	Rinse PT with hot water from hot water mixer & pump in									
	41	Shut off pump 81-82°C									
	42	Stir 30 min at 178-182°F for S49									
	43	Do not shut off agitator									
SV & SP 9	44	When S29 complete, heat SV to 198-200°F in 5-10 min									
	45	Close water line & discharge valves at stearate pump									
	46	Open V-356 Discharge valves to stearate pump inlet									
	47	Open water valve at stearate pump & run water thru									
		Homog at 2900-3100 psi to sewer									
	48	While Homog water at 2900-3100 psi, open Homog									
		Discharge valve to SV & close valve to sewer									
	49	Immediately open stearate pump discharge valve.									
		Turn on pump & Homog V-356 to SV at 2900-3100 psi									
		Maintain SV at 198-200°F									
	50	While Homog V-356 to SV, shut off water valve at									
		Stearate pump ASAP									
	51	When Homog complete, rinse in V-356 with hot water									
		From hot water mixer									



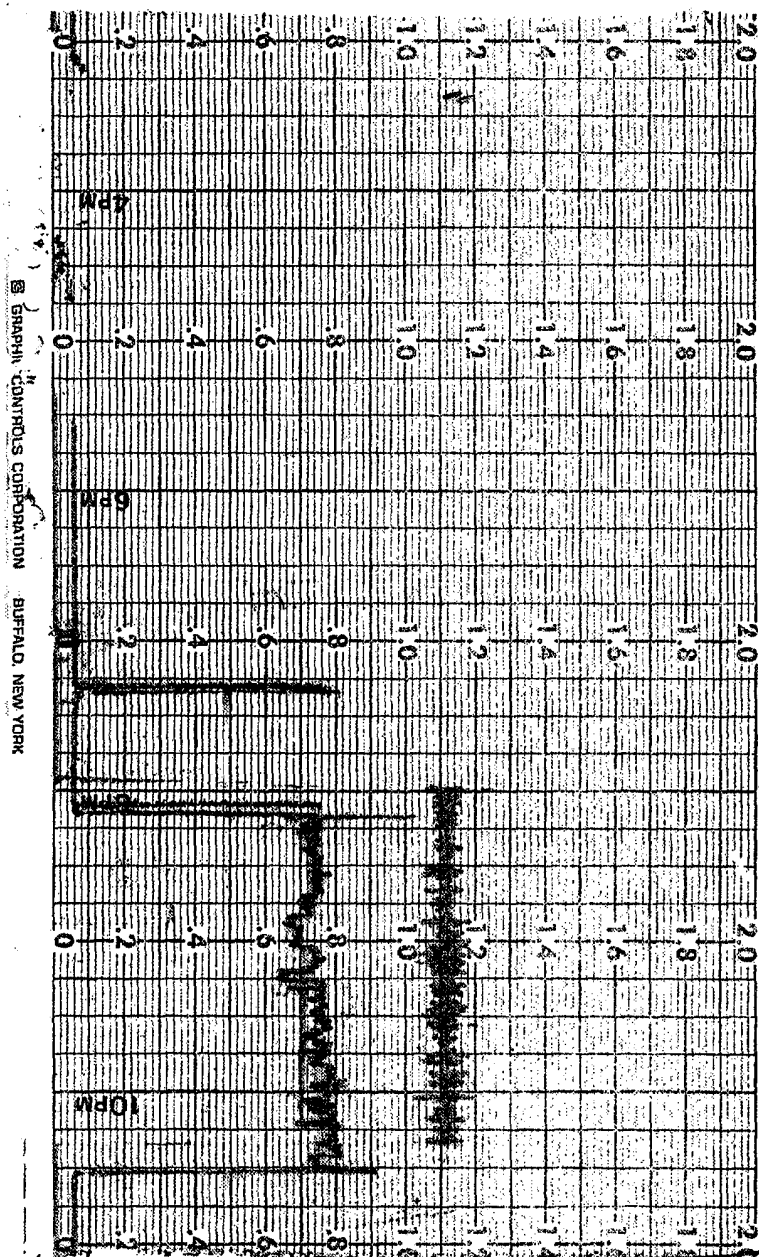


BUFFALO, NEW YORK



GRAPHIC CONTROLS CORP.

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