MAKING INSTRUCTIONS: BATCH UNIT

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

CG 03 CODE KY-907-D PKG.

→ Jan 12 33776

EST. WGT. 1080 LBS.

STD. HRS. TIME 7 PM

O/C
KP

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		

14 YC-2-B 93 4 Lot 24068, 1.900#
14 YC-2-B 93 4 Lot 24171, 500#
14 YC-2-B 93 4 Lot _____, _____#

V-244 'M'T' 1:35 AM

Homog #3 - 2nd Pass

Total Weight - 3480#

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® YELLOW MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	60 (992G)	1 Run ~~33" (560 G)~~ water into V-203			
		2 Pour in	320	32-D	320
		3 Dump in Lot	48 x 50	YC-2-B	2400
		Record: Start 10.35 AM 24068	1.900		
		Fin 11.40 AM 24171	500		
		4 Adj to 70" (1200 G) 2400-2600			
		5 Pump V-203 thru Homog #3 at ~~1800-2200~~ psi into V-205			
265		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~~ & SV 2		9 Run 10" (514 G) water into SV & start agitator			
		10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
		Record: Time Start 1:40 AM Total Min 125			
263		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			
SP & CP 3		12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
		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 29 % - 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. 3FR10 (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 4		16 Operator Step PB			
		17 Record Level 2 LG 45 %. If below 35% follow solution make-up procedure for N-27-D			
		18 Adj to 48" (2470 G)			
		19 Record: pH 10.5			
		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)	30	7-D	15
		Siphon into SV Record: pH 11.1			
		21 Operator Step PB			

13829 REV.

V-244

EQUIPMENT		PAGE 2 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP Step 06/39 - After heat up Record: pH 9.85 (9.5-10.0)			
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto			
&	24	Operator Step PB			
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits			
5		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:	5	50/AW1	
		SP Step			
		V-243/V-244 pH Range Time			
		13/46 (30 min) 9.7 9.0-10.0 6:20			
		14/47 (60 min) 9.7 9.0-10.0 6:50			
		15/48 (2 hrs) 9.7 9.0-10.0 7:50			
		16/49 (2 hrs 25 min) 9.7 9.0-10.0 8:15			
		17/50 (3 hrs Final) 7.8 7.5- 8.5 8:50			
		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%		27-D	
	29	Sift in	50	128-A	50
302	30	Add 17" (208 G) water to V-302	50		
6	31	Add & stir 2 min for S58 Assume 50%	100	72.1-D	50
PT	32	During strike pump into PT	318	169-A	318
7	33	Pump in	36	155-A	36
	34	Pump in	36	160-A	36
	35	Stir 10 min with lightning mixer for S39			
356	36	During strike run 14" (244 G) water into V-356			
8	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			
	42	Stir 30 min at 178-182°F for S40 81-82°C			
	43	Do not shut off agitator			
SV	44	When S29 complete, heat SV to 198-200°F in 5-10 min			
&	45	Close water line & discharge valves at stearate pump			
SP	46	Open V-356 Discharge valves to stearate pump inlet			
9	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			

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EQUIPMENT		PAGE 3 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV & SP 9 Con'T	52	When 851 complete turn off Homog & stearate pump			
	53	Stir 5 min at 198-200°F			
	54	Shut off steam			
	55	When 854 complete, Operator PB			
	56	SP Step 23/53 Record pH 4.0 (3.3-3.7)			
	57	If necessary adj pH to (3.3-3.7) (DOWN ONLY) Record: pH 3.7	110	15-A	110
		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			
	58	Run in N-7-D from S31 in 10-12 min & stir 5 min			
	59	Record: pH 4.1 (4.2-4.4) & if necessary adj pH 4.2-4.4			
		& Record: pH 4.2 Assume 50%		7-D	1
		(Dilute 10 parts water to 1 part N-7-D) Assume 78%	30	27-D	21
		Siphon N-7-D into SV			
	60	Operator Step PB			
	61	Operator Step PB			
	62	SP Step 60 - Batch complete			

START		FINISH		OPTR
Time	SP Step	Time	SP Step	
11AM		3PM		282-381
11:00PM		7:00A		235-54
7:00A.M		10:45A.M		381.438

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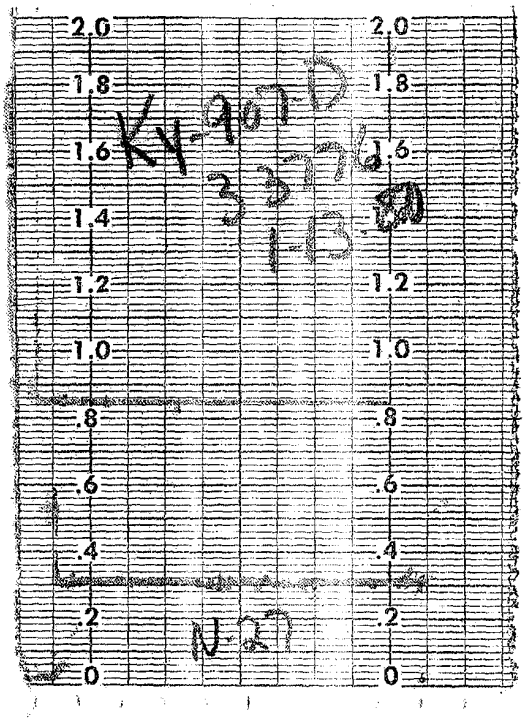

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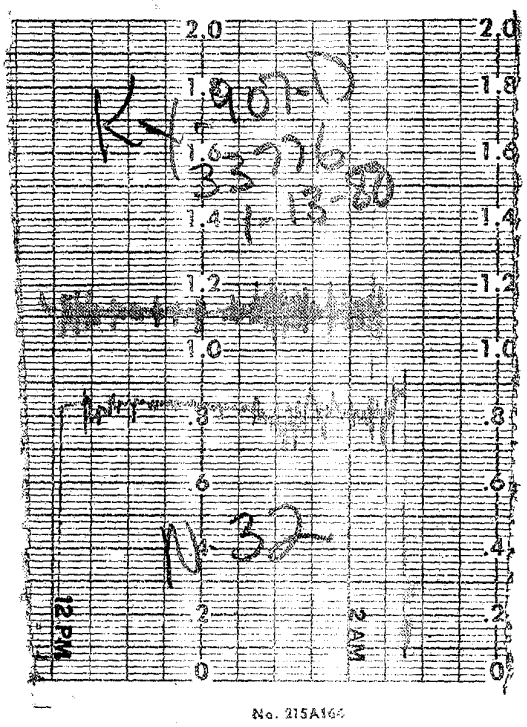

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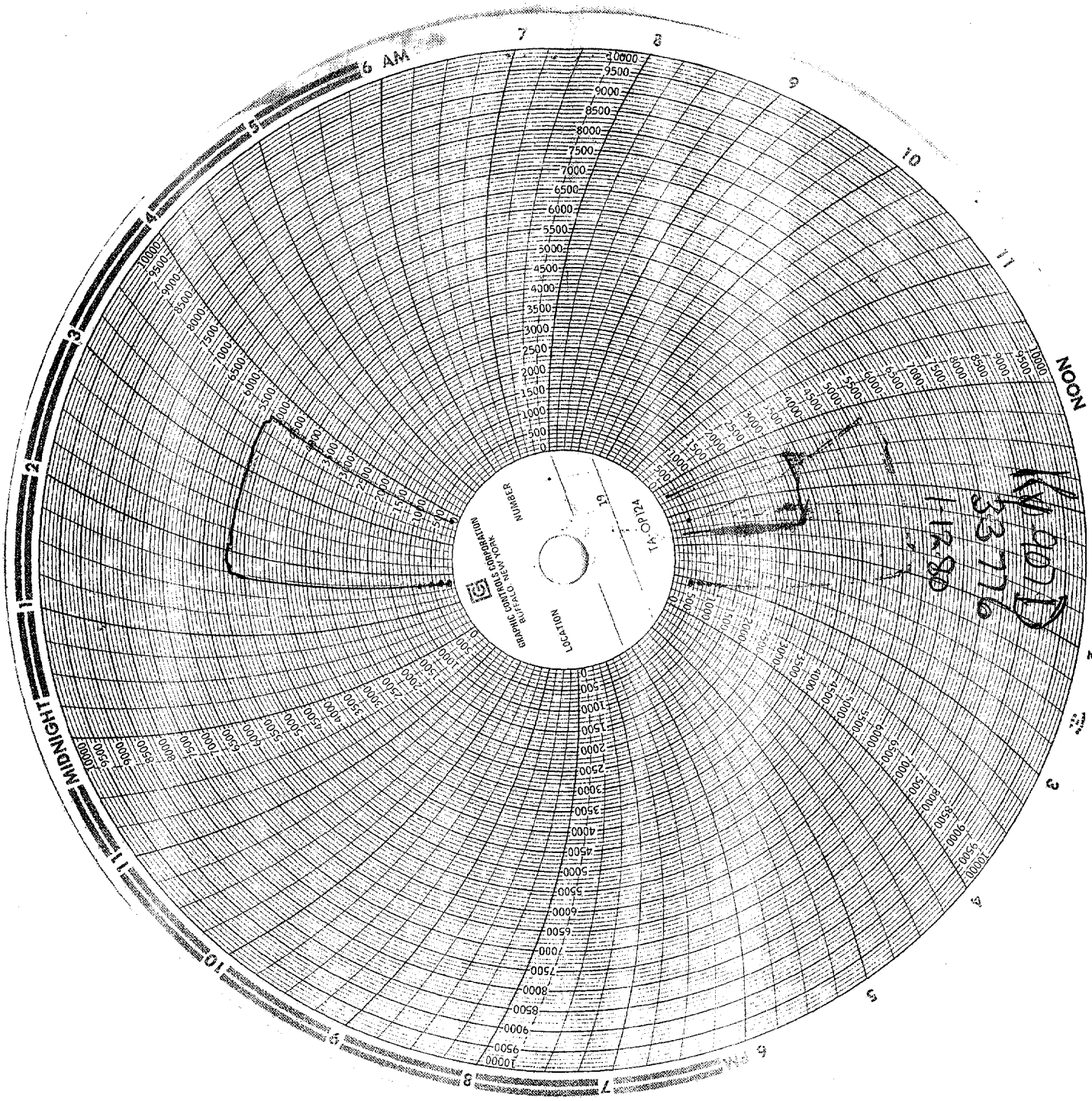

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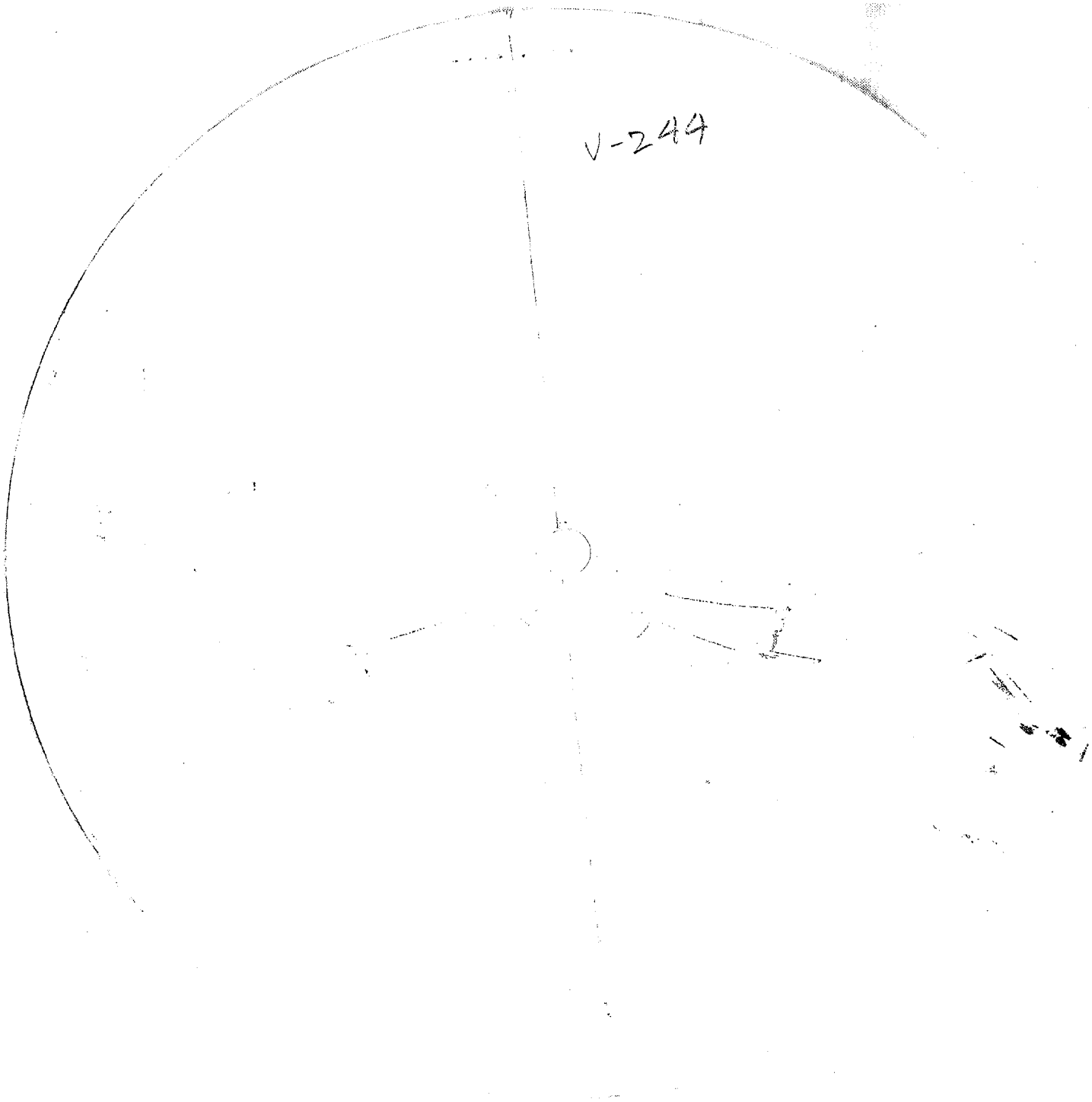
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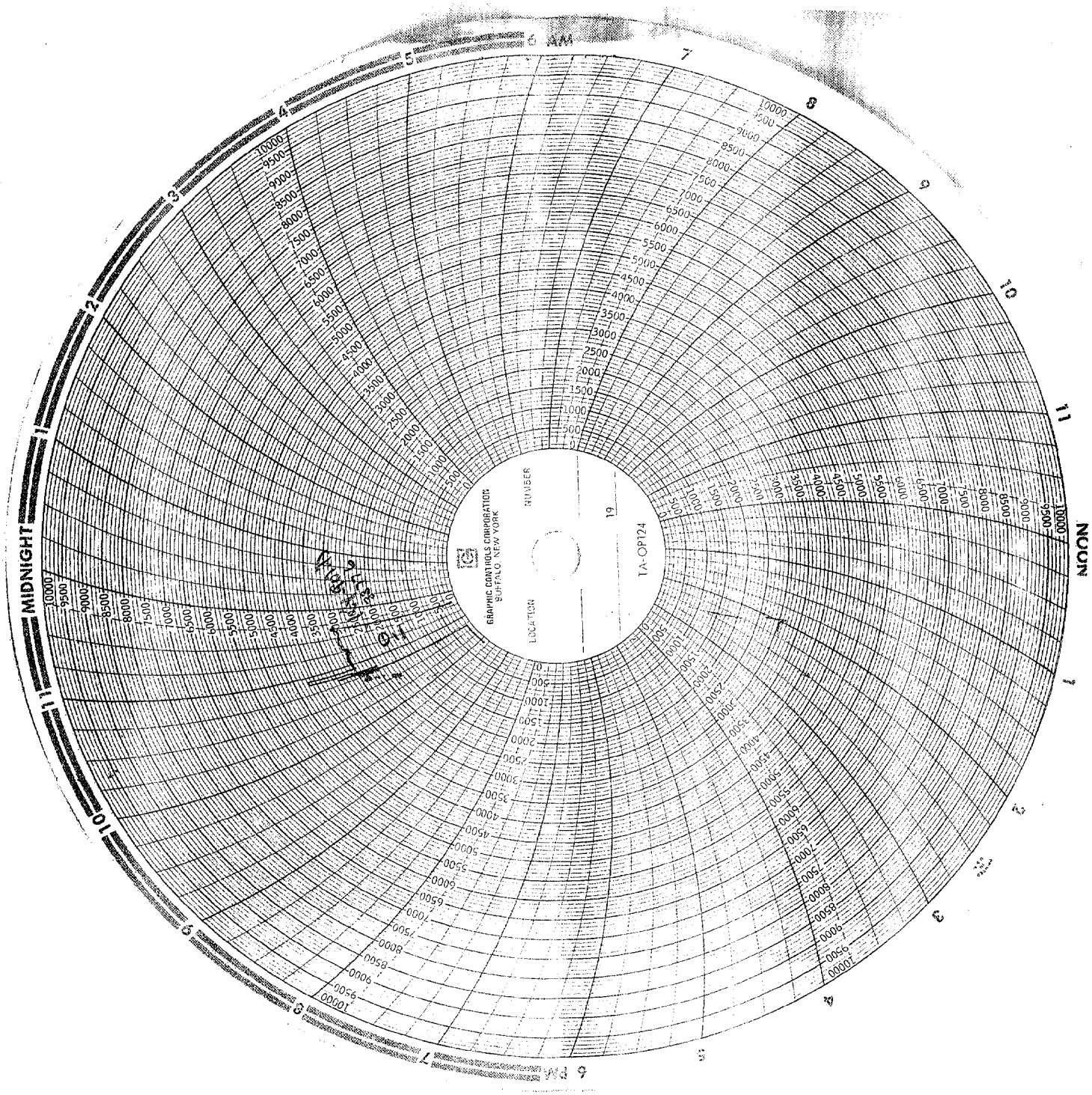

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