

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

✓ 23(24) (AUTOMATED) CV APK 1 1980
 CG 03 CODE KY-787-D PKG _____

PROCESSES		APPROVED BY
() KY-787-D	Q	EWK 9-22-76
()	()	DCG 9-27-76
()	()	MTW 9-30-76
()	()	
RE TYPED BY		
CJH 2-8-80		

→ MAL 20 35179
 EST WGT 1090 LBS

STD HRS 8.9 TIME 3 P M

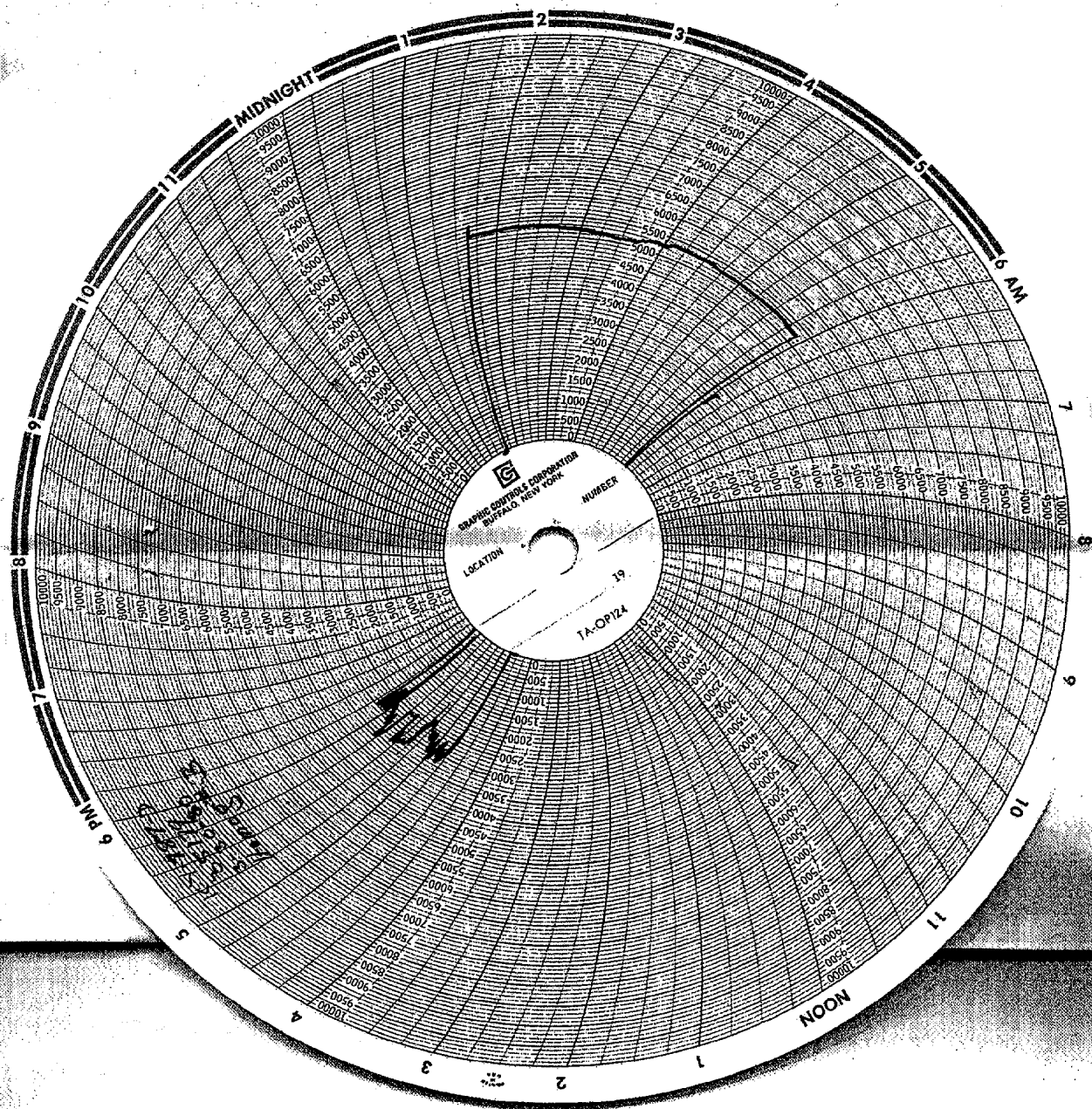
14 YC-2-B 93 4 LOT 24474, 1800#
 LOT 24462, 600#
 LOT _____ #

#3 1ST PASS

TOTAL WGT <u>3490#</u>		NON-BLEEDING		
ITEM	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205 1	1. RUN 60" (992 G) WATER INTO V-203. <u>SET AGITATOR ON HIGH SPEED</u> 2. WEIGH IN DRUM & POUR IN 3. DUMP IN AND STIR 5 MIN RECORD: START <u>6:41 PM</u> <u>24474</u> FIN <u>7:33 PM</u> <u>24462</u> <u>25" (2256)</u> 4. ADJ TO 70" (1200 G) <u>2400-2600</u> 5. PUMP V-203 THRU HOMOG #3 AT 1800-2200 PSI INTO V-205 6. WHEN V-203 MTY, WASH COLOR THRU HOMG AT 1800-2000 PSI USING MINIMUM WATER 7. RECORD V-205 VOL <u>41</u> " & ADJ TO 60" (2100 G) 8. INSPECT HOMOG STRAINER & CLEAN IF NECESSARY <u>DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED</u> 9. RUN 10" (514 G) WATER INTO SV/START AGITATOR 10. PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V- <u>244</u> RECORD: TIME START <u>2:00</u> TOTAL MIN <u>2:55</u> 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	320 48 X 50 1800 600	32-D YC-2-B	320 2400
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 190-194F) 14. RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS: A. 11LG <u>42%</u> - PRESET #1 80 GAL B. 13LG <u>55%</u> - PRESET #6 135 GAL 15. SET STRIKE FLOW CONTROLLERS AS FOLLOWS: A. 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM 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 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		15-A 20-A 27 32-D	160 135 275 1840
SV SP & CP 4	16. OPERATOR STEP PB 17. RECORD LEVEL 2 LG <u>64%</u> IF BELOW 35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D 18. ADJ TO 48" (2470 G) 19. RECORD: pH <u>10.5</u> 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) SIPHON INTO SV. RECORD pH <u>11.3</u> 21. OPERATOR STEP PB		<u>20</u> <u>7-D</u>	<u>70</u>

V-244

UIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH 9.9 (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:						
		SP STEP						
		V-243/V-244	pH	RANGE	TIME			
		13/46 (30 MIN)	9.7	9.0-10.0	8:20pm			
		14/47 (60 MIN)	9.7	9.0-10.0	8:50pm			
		15/48 (2 HRS)	9.7	9.0-10.0	9:50pm			
		16/49 (2 HRS 25 MIN)	9.7	9.0-10.0	10:15pm			
		17/50 (3 HRS FINAL)	9.0	7.5-8.5	10:50pm			
		NOTE: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG						
		IF FINAL pH IS ABOVE 8.5, ADJ pH TO 7.5-8.5 &						
		RECORD: pH			ASSUME 77%		27-D	
339	29	WHILE STRIKING, RUN 30" (234 G) WATER INTO V-339						
6	30	ADD IN 7-8 MIN				350	530-A	350
	31	ADJ TO 49" (382 G) AT 80 - 100°F						
	32	STIR 5 MIN & RECORD pH (9.5-10.5)						
	33	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26						
	34	RECORD VOL 49" & CALCULATE 49" (VOL) X 0.78 = 38.2 G						
	35	SET PRESET #8 TO 38.2 G FROM S 34						
302	36	ADD 30" (360 G) WATER TO V-302						
7	37	ADD & STIR 2 MIN FOR S 41			ASSUME 50%	160	7-D	80
243	38	SP STEP 17/50 - AFTER CHECKING pH, OPERATOR STEP PB						
	39	SIFT IN 2 BAGS				100	128-A	100
SP	40	SP STEP 23/53 - RECORD pH 3.5 (3.7-4.2)						
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN						
CP	42	RECORD: pH 9.1 (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5						
8		& RECORD: pH			ASSUME 77%		27-D	
		(DILUTE 10 PARTS WATER TO 1 PART N-7-D)			ASSUME 50%		7-D	
		SIPHON N-7 INTO SV						
	43	OPERATOR STEP PB						
	44	SP STEP 29/58 RECORD: pH 9.3 (9.0-10.0) TIME 12:00pm						
	45	OPERATOR STEP PB						
	46	SP STEP 60 - BATCH COMPLETE						
		START	FINISH					
		TIME	SP STEP	TIME	SP STEP	OPTR		
		11:00pm		7:00am		409		
		2:00pm		3:00pm		126		
		3:00pm		11:00pm		144.23		
		11:00pm				391.538		



N32153.01

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