

CG 03 CODE KY-788-D PKG.

→ MAR 13 34864
EST. WGT. 960 - 860 LBS.

STD. HRS.	8.8	TIME	3P	M	2.000
14 YC-3-B	98	4	Lot 24405		
14 YC-3-B	98	4	Lot 24407		600
14 YC-3-B	98	4	Lot		

PROCESSES		APPROVED B
() KY-788-D	(J)	EWK 9/28/76
()	()	MTW 9/30/76
()	()	DCG 9/30/76
TYPED BY		
NE 2-18-77		

PUNCHED & CHECKED 1ST PASS

MAR 17 1980 # 3 2ND PASS

Total Wgt. 3560# 3460

NON-BLEEDING

PMENT	NAME	USE LBS.	N CODE	ACCT LBS.
203 & 205 1	60" (9706) "KROLOR" YELLOW - LIGHT			
	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
	2 Weigh in drum & pour in	345	32-D	345
	3 Dump in & stir 5 min	Lot 52 x 50	YC-3-B	2600
	Record: Start 7.30	24.405		
	Fin 8.30	24407		
	75" (1256)	2600		
	4 Add to 70" (1200 G)	2400-2600		
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-205 Vol 40 " & adi to 60" (2100 G)			
	8 Inspect homog. strainer & clean if necessary			
	DURING HOMOG. RUN V-203 AGITATOR ON LOW SPEED.			
205 & SV 2	9 Run 10" (514 G) water into V- 242 & start agitator			
	10 Pump V-205 thru Homog at 4800-5200 psi into V- 242			
	Record: Time Start 1:45 PM 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 and pump thru Homog at 4800-5200 psi			
SP & CP 3	12 SP Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
	13 Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 30% - preset #2	208 Gal	15-A	416
	b. 13LG 60% - preset #6	135 Gal	20-A	135
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual	0.54 GPM	27-D	180
	b. 3FC20 (N-27-D Water) in Manual Local	4.4 GPM		
	c. 3FR10 (N-27-D/Water Ratio)	0.8		
	d. 8FC10 (N-32-D Controller) in Manual	0.72 GPM	32-D	1215
	e. 8FC20 (N-32-D Water) in Manual Local	3.9 GPM		
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water Ratio)	1.1		
20 & 43 SP	16 Operator Step PB			
	17 Record level 2LG 64%. If below 35% follow solution make-up procedure for N-27-D			
	18 Adi SV to 47" (2400 G)			
	19 Record pH 10.1. Adi to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.1	10	7-D	10
	20 Operator Step PB			

V-243

ENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS
21	SP Step 06/39	- After heat up	Record: pH 9.5 (9.5-10.0)					
22	Switch 3FC20	8FC10, 8FC20 to Auto	7:35 P					
23	Operator Step PB							
24	SP Step 10/43	- When 3FC20, 8FC10, 8FC20 water flows is limits.						
		Switch 3FC10 to Auto.	Operator Step PB					
25	SP Step 11/44	- When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote						
26	Operator Step PB							
27	During strike, record pH & time as follows:							
	SP Step							
	V-243/V-244	pH	Range	Time				
	13/46 (30 min)	9.0	9.3-10.0	8:05		N-27	Stopped	
	14/47 (60 min)	9.4	9.3-10.0	8:35		File	± 18 min	
	15/48 (2 hrs)	9.4	9.3-10.0	9:35				
	16/49 (2 hrs 25 min)	9.0	9.3-10.0	10:00				
	17/50 (Final 3 hrs)	6.8	7.5-8.5	10:35				
	Note:	If not as specified notify Supervisor & Note in log						
		If final pH is above 8.5, adj 7.5-8.5						
		& Record: pH Assume 77%						27-D
28	While striking run 30" (234 G) water into V-339							
29	Add in 7-8 min				350	530-A	350	
30	Add to 49" (382 G) at 80-100 °F							
31	Stir 5 min & record pH 9.8 (9.5-10.5)							
32	Stir 15 min or longer to dissolve for SP Step 26/56							
33	Record Vol 52" & Calculate 52" (Vol X 0.78 = 40.6 G)							
34	Set preset #8 to 40.6 G from S 33							
35	Run 40" (440 G) water into V-302							
36	Add & stir 2 min for S 40		Assume 50%		360	7-D	180	
37	SP Step 17/50 After checking pH. Operator Step PB							
38	Sift in 2 bags				400	128-A	100	
39	SP Step 23/53 Record: pH 3.0 (3.7-4.2)							
40	Run in N-7-D from S 36 in 10-12 min & stir 5 min							
41	Record: pH 9.0 (9.0-9.5) & if necessary adj to pH 9.0-9.5							
	& Record: pH		Assume 77%				27-D	
	(Dilute 10 parts water to 1 part N-7-D)		Assume 50%				7-D	
	Siphon N-7-D into SV							
42	Operator Step PB							
43	SP Step 29 - Record: pH 9.0 (9.0-10.0) Time 12:00 AM							
44	Operator Step PB							
45	SP Step 60 - Batch complete							
	PUMP TO V-240							
	Time	Start	SP Step	Time	Finish	SP Step	Optr	
	1:00 AM			3:00 PM			409	
	2:00 PM						126	
	11:00 PM			12:15 AM			237	



