

243 244 (Automated)

CG 03 CODE KY-788-D PKG.

APR 11 35288

EST. WGT. 960 LBS.

STD. HRS. 8.8 TIME

14 YC-3-B 98 4 Lot 24696, APR 15 1980
 14 YC-3-B 98 4 Lot 24699, 600
 14 YC-3-B 98 4 Lot

PUNCHED & CHECKED

Note Step 27i-

APR 14 1980

D.V.

PROCESSES		APPROVED BY	
() KY-788-D	(J)	EWK	9/28/76
()	()	MTW	9/30/76
()	()	DCG	9/30/76
()	()		
TYPED BY			
NE 2-13-77			

Total Wgt. 3560#

NON-BLEEDING

IPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	60" (9906) "KROLOR" YELLOW - LIGHT			
&	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
205	2 Weigh in drum & pour in	345	32-D	345
1	3 Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
	Record: Start 12:05 - A.M. 24696			
	Fin 12:40 - A.M. 24699			
	75" (2756)			
	4 Adj to 76" (1200 G) 2400-3600			
	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-203 Vol 43 " adj to 60" (2100 G)			
	8 Inspect homog. strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
205	9 Run 10" (514 G) water into V- 243 & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-			
SV	Record: Time Start 8:15 AM tai min 1:35			
2	Note: If Homog pressure falls below 4800 ps., 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	12 SP Step 81 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
&	13 Press SV Cam Reset PB- set 22 TC in Auto Remote			
CP	(Temperature is set at 190-194 F)			
3	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG 32% - preset #2 208 Gal		15-A	416
	b. 13LG 26% - 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			
320	16 Operator Step PB			
243	17 Record Level 2LG 73 %. If below 35% follow solution make-up procedure for N-27-D			
SP	18 Adj SV to 47" (2400 G)			
&	19 Record pH 10.3. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	20
CP	Siphon into SV & Record: pH 11.1			
4	20 Operator Step PB			

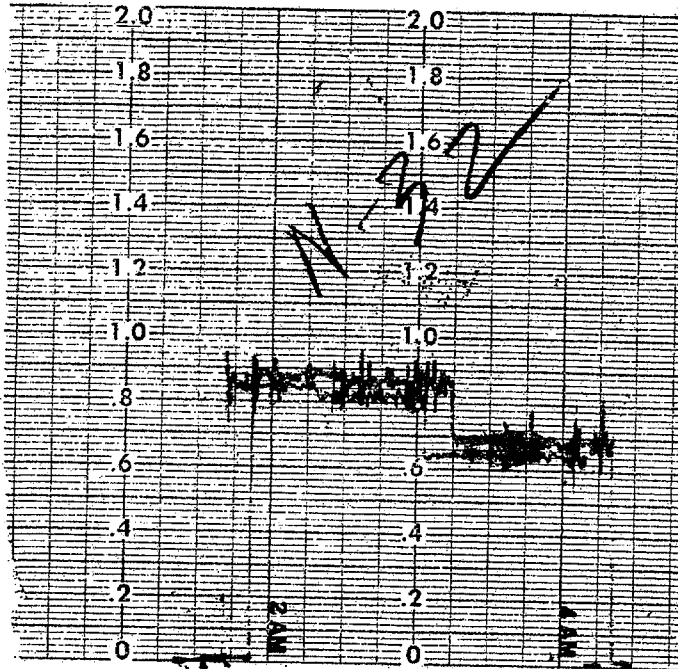
20 REV.

N32255

V-243

UIPMENT	PAGE 2 CG 03 CODE KY-788-D	EST. WGT 3500	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	21	SP Step 06/39 - After heat up Record: pH <u>9.8</u> (9.5-10.0)				
SP	22	Switch 3FC20 8FC10, 3FC20 to Auto.				
	23	Operator Step PB				
5	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:				
	28	SP Step				
	29	V-42/V-244 pH Range Time				
	30	13/48 (30 min) 9.85 9.3-10.0 12:20				
	31	14/47 (60 min) 9.95 9.3-10.0 12:50				
	32	15/48 (2 hrs) 10.0 9.3-10.0 1:50				
	33	16/49 (2 hrs 25 min) 10.0 9.3-10.0 2:15				
	34	17/50 (Final 3 hrs) 9.0 7.5-8.5 2:50				
		Note: If not as specified notify Supervisor & Note in log				
		If final pH is above 8.5, adj 7.5-8.5				
		& Record: pH <u>8.2</u> Assume 77%				
				14	27-D	10
339	28	While striking run 30" (234 G) water into V-339				
6	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 <u>10.0</u> (9.5-10.5)				
	32	Stir 15 min or longer to dissolve for SP Step 26/56				
	33	Record Vol <u>4.9</u> & Calculate <u>4.9</u> (Vol X 0.78 = <u>3.82 G</u>)				
	34	Set preset #8 to <u>38.2</u> from S 33				
302	35	Run 40" (440 G) water into V-302				
7	36	Add & stir 2 min for S 40 Assume 50%		360	7-D	180
SV	37	SP Step 17/50 After checking pH. Operator Step PB				
SP	38	Sift in 2 bags		100	128-A	100
	39	SP Step 23/53 Record: pH <u>3.1</u> (3.7-4.2)				
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min				
	41	Record: pH <u>9.4</u> (8.0-9.5) & 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 <u>9.4</u> (9.0-10.0) Time <u>4:45 PM</u>				
	44	Operator Step PB				
	45	SP Step 60 - Batch complete				
		Start Finish Optr				
		Time SP Step Time SP Step				
		11:00 PM 244-909				
		7:00 AM 233-301				
		3:00 PM 322-121				
		4:45 PM				
		STEP 27: -				
		START P.H. Settings Normal				
		11:50 PM 9.8				
		12:20 9.85				
		12:50 9.95				
		1:05 10.0				
		1:20 10.0				
		1:35 10.0				
		2:15 10.0				
		Charged N-32 0.65				
		0.65				
		0.65				
		0.65				

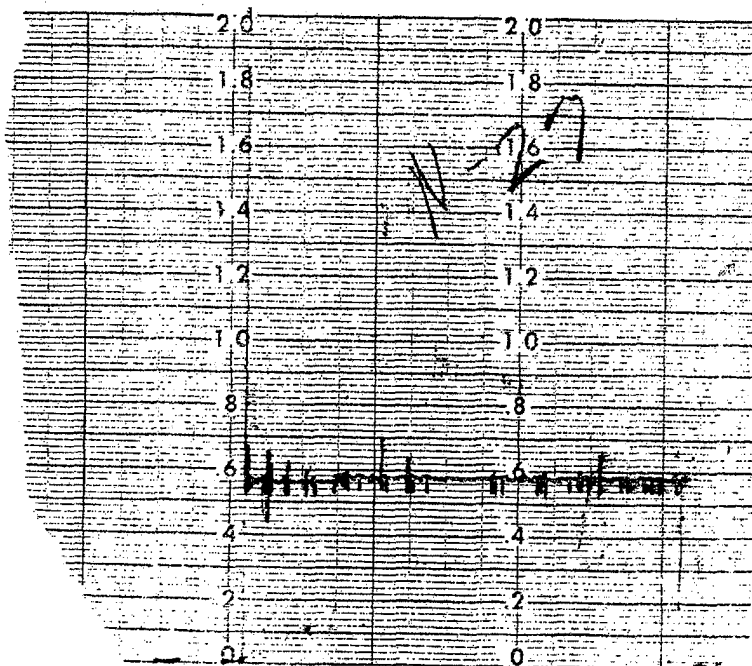
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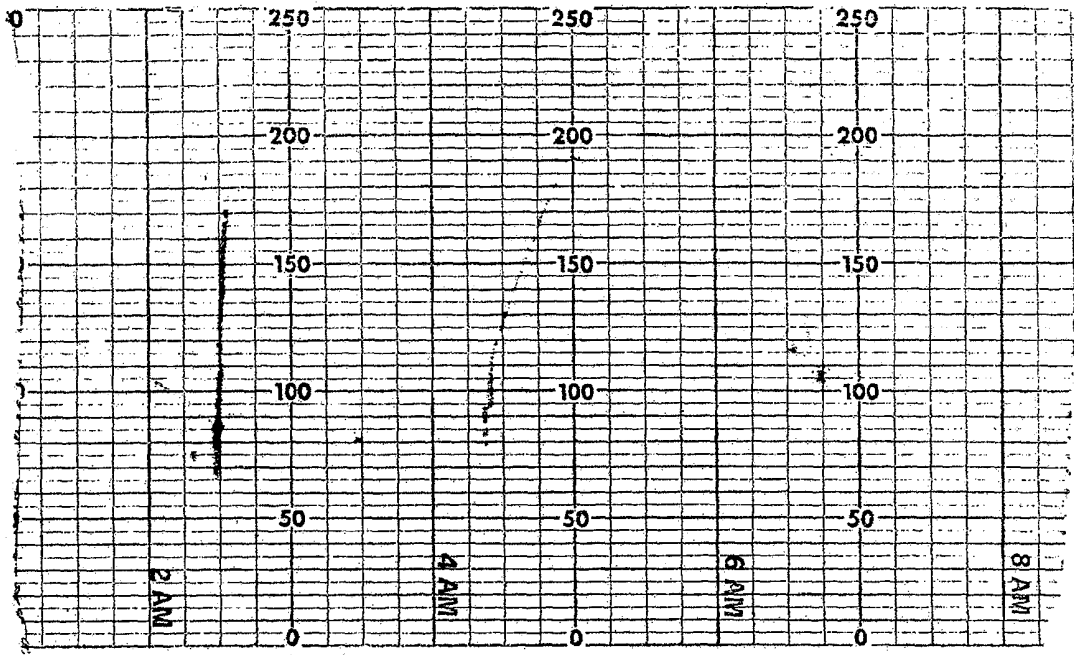
GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

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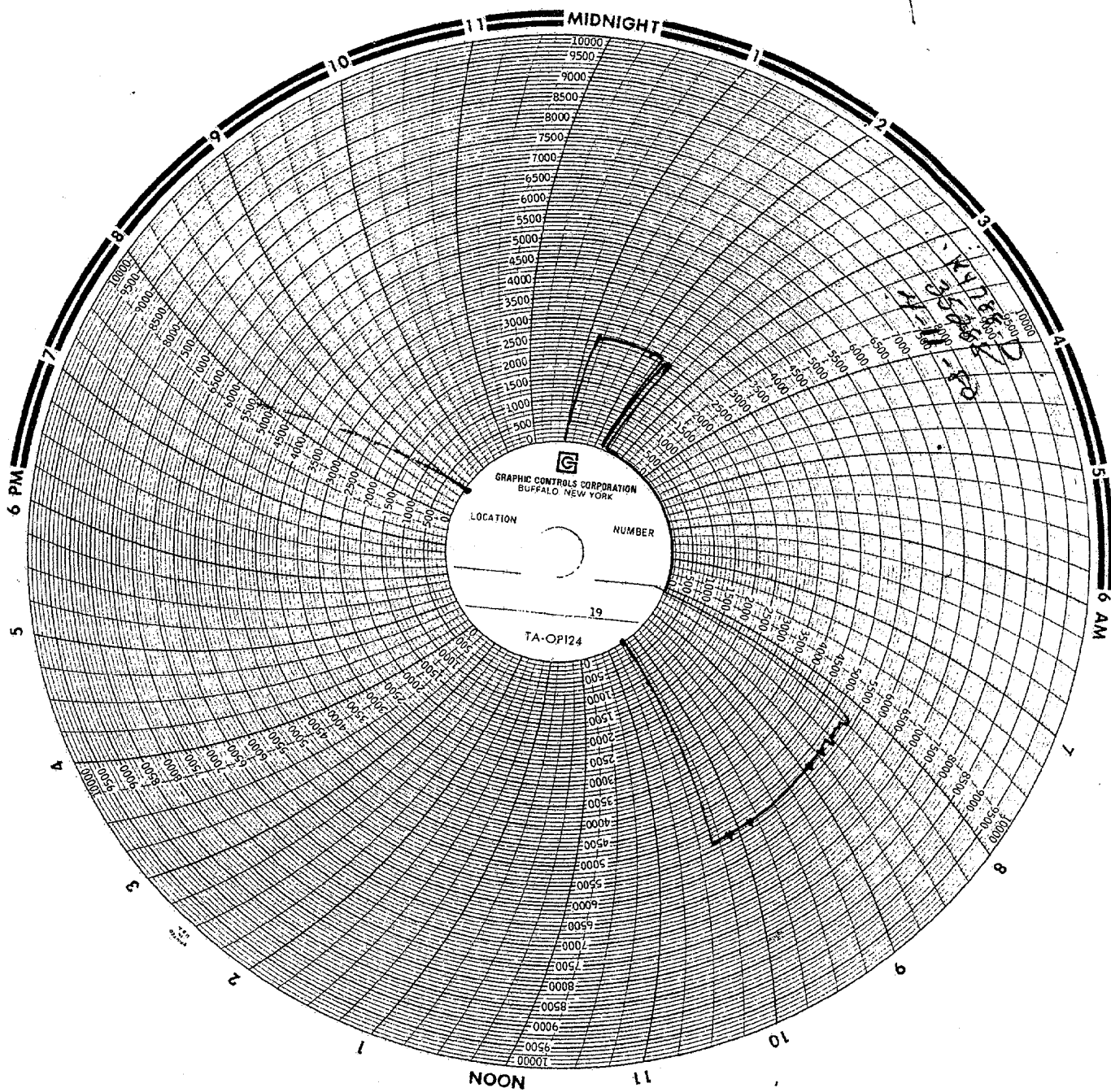
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