

243 (Automated)

FEB 25 1980
C.V.

03 CODE KY-787-D PKG.

FEB 27 34595

EST. WGT. 1090 990 LBS.

STD. HRS. 8.9 TIME 7 AM

14 - YC-2-B 98 4 Lot 24481, 2000 #
Lot 24464, 402 #
Lot

PUNCHED & CHECKED

Note Step 18

FEB 29 1980

OR

RP

PROCESSES	APPROVED BY
() KY-787-D	() FWK 9/22/76
()	() DCG 9/27/76
()	() MTW 9/30/76
()	()
TYPED BY	
N.E. 2/12/77	

Homog #3 - 1ST Pass
" #4 - 2ND "

Total Wgt. 3490# 33% V-243 M/T 5:15 PM

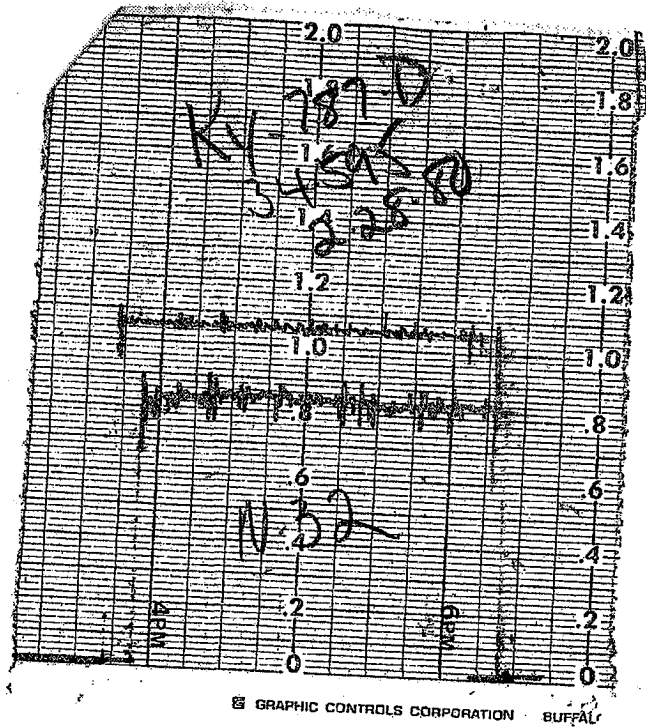
NON-BLEEDING

UIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205	"KROLOR" - YELLOW MEDIUM			
1	1 Run 60" (992 G) water into V-203. Set agitator on high speed	320	32-D	320
2	2 Weigh in drum & pour in	48 x 50	YC-2-B	2400
3	3 Dump in and stir 5 min	400		
4	4 Record: Start	24464		
5	5 Fin	24481		
6	6 25" (1275 G)	2600		
7	7 Adj to 70" (1200 G) 2400-2600			
8	8 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 203			
9	9 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water 263			
10	10 Record V-205 Vol " & adj to 60" (2100 G)			
11	11 Inspect Homog strainer & clean if necessary			
12	12 DURING HOMOGS, RUN V-203 AGITATOR AT LOW SPEED			
13	13 Run 10" (514 G) Water into SV & start agitator			
14	14 Pump V-205 thru Homog at 4800-5200 psi into V-243			
15	15 Record: Time start 5:20 P Total Min 115			
16	16 NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
17	17 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
18	18 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
19	19 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
20	20 Record levels and set Raw Materials Counter #1 as follows:			
21	21 a. 11LG 5% - preset #1 80 Gal 15-A 160			
22	22 b. 13LG 3.3% - preset #6 135 Gal 20-A 135			
23	23 Set strike flow controllers as follows:			
24	24 a. 3FC10 (N-27-D Controller) in Manual 0.83 GPM 27-D 275			
25	25 b. 3FC20 (N-27-D Water) in Manual Local 5.28 GPM			
26	26 c. 3FR10 (N-27-D/Water Ratio) 0.64			
27	27 d. 8FC10 (N-32-D Controller) in Manual 1.08 GPM 32-D 1840			
28	28 e. 8FC20 (N-32-D Water) in Manual Local 4.47 GPM			
29	29 f. 8FC20 (N-32-D Water) in Remote			
30	30 g. 8FR10 (N-32-D/Water Ratio) 0.83			
31	31 Operator Step PB			
32	32 Record Level 2 LG 46 %. If below 35% follow solution make-up procedure for N-27-D			
33	33 Adj to 48" (2470 G)			
34	34 Record pH 10.1			
35	35 Adj to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% (10 parts water to 1 part N-7-D)			
36	36 Siphon into SV. Record pH 11.1			
37	37 Operator Step PB			

N32472

V-243

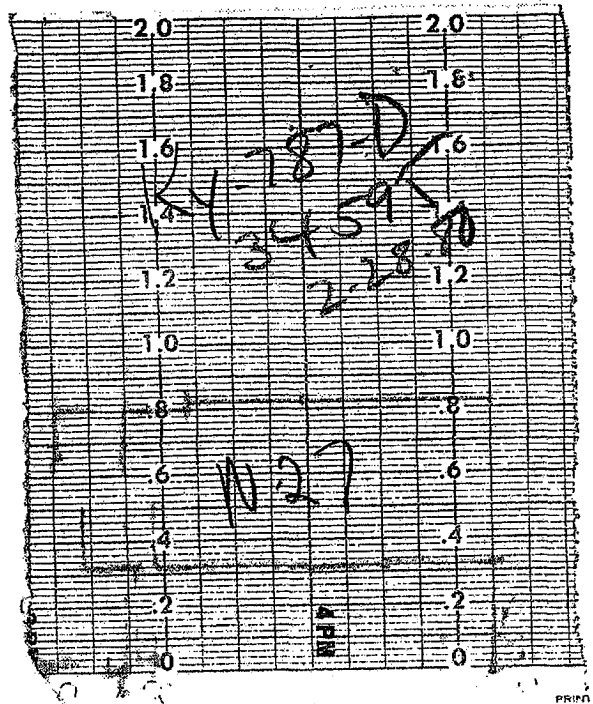
JIPMENT	PAGE 2	CG 03	Code KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22	SP Step 06/39 - After heat up Record: pH <u>9.65</u> (9.5-10.0)						
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
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)	<u>9.5</u>	9.0-10.0	<u>9:00</u>			
		14/47 (60 min)	<u>9.5</u>	9.0-10.0	<u>9:30</u>			
		15/48 (2 hrs)	<u>9.5</u>	9.0-10.0	<u>10:30</u>			
		16/49 (2 hrs 25 min)	<u>9.5</u>	9.0-10.0	<u>10:55</u>			
		17/50 (3 hrs Final)	<u>8.0</u>	7.5-8.5	<u>11:30</u>			
		NOTE: If not as specified, notify Supervisor & note in log						
		If final pH is above 8.5, add pH to 7.5-8.5 &						
		Record: pH <u>7.6</u> 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 <u>10.1</u> (9.5-10.5)						
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol <u>49</u> " & calculate <u>49</u> " (Vol) x 0.78 = <u>38.2 G</u>						
	35	Set preset #8 to <u>38.2</u> 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	Stir in 2 Bags				100	128-A	100
SP	40	SP Step 23/53 - Record: pH <u>3.8</u> (3.7-4.2)						
&	41	Run in N-7-D from S37 in 10-12 min & stir 5 min.						
CP	42	Record: pH <u>9.1</u> (9.0-9.5) & if necessary add pH 9.0-9.5						
8		& Record: pH <u>✓</u> Assume 77%					27-D	
		Dilute 10 parts water to 1 part N-7-D) Assume 50%					7-D	
		Siphon N-7-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.2</u> (9.0-10.0) Time <u>12:30 A.M.</u>						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete.						
		Start	Finish	Opnr				
		Time SP Step	Time SP Step					
		<u>2:00 PM</u>	<u>3:00 PM</u>	<u>145</u>				
		<u>3:00 P</u>	<u>11:00 P</u>	<u>235</u>				
		<u>3:00 P</u>	<u>11:00 PM</u>	<u>235-301</u>				
		<u>11:00 P.M.</u>	<u>12:55 A.M.</u>	<u>381-223</u>				
Note		STEP 18: - Color Dirty + Orange						
		PUMPED TO VAT 240						

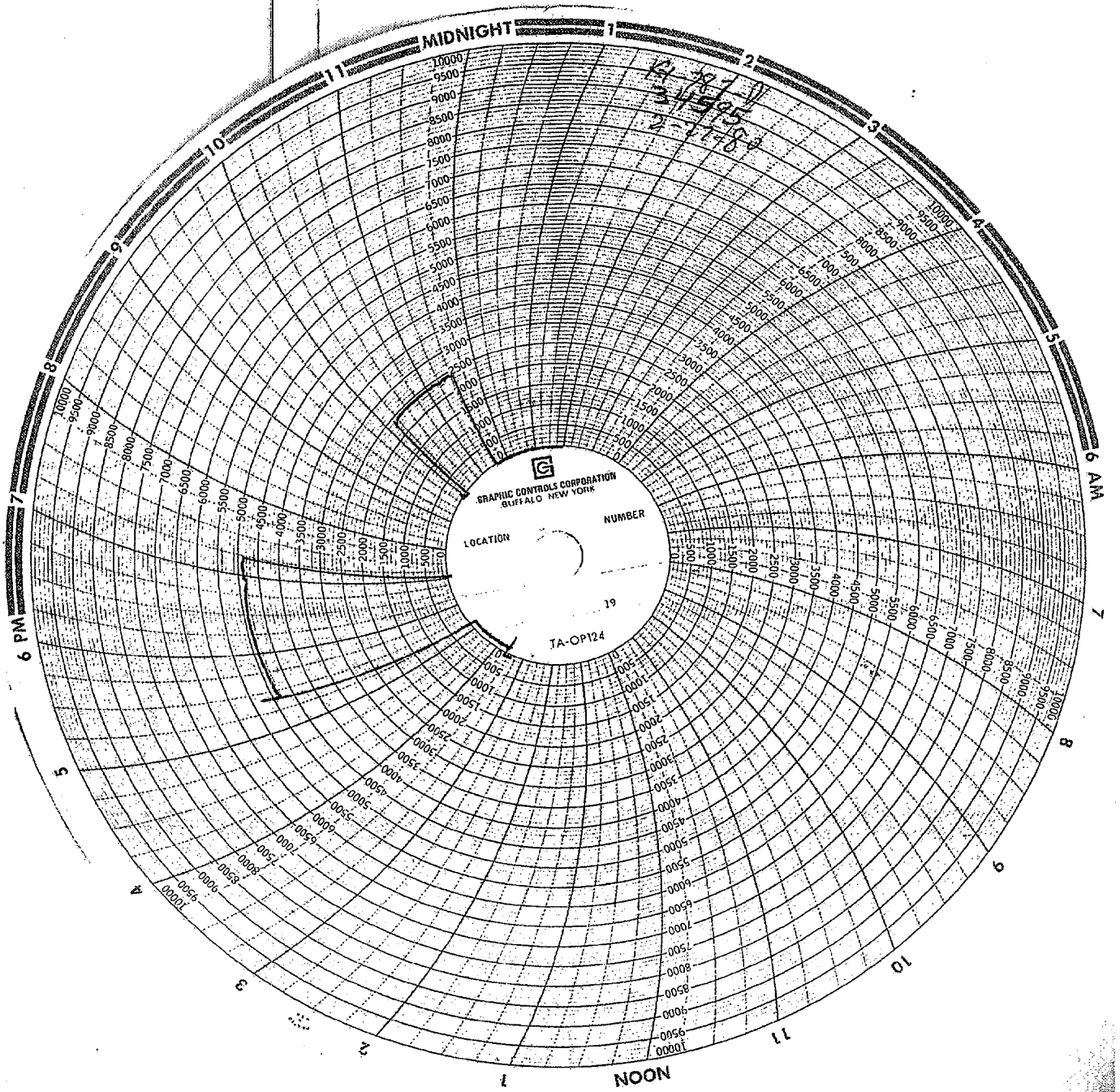


GRAPHIC CONTROLS CORPORATION BUFFALO

N32472.01

DUP050461393





N32472.02

DUP050461395

V-243