

S.V. 243, 244 (Automated)

CG 03 CODE KY-907-D PKG.

EST. WGT. 1080 LBS.

STD. HRS. TIME

14 YC-2-B 93 4 Lot 24475, 2400#
 14 YC-2-B 93 4 Lot
 14 YC-2-B 93 4 Lot

PUNCHED & CHECKED

APR - 8 1980

D.V.

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	

Homog #4 - 1st Pass
 " #3 - 2nd "

Total Weight - 3480#

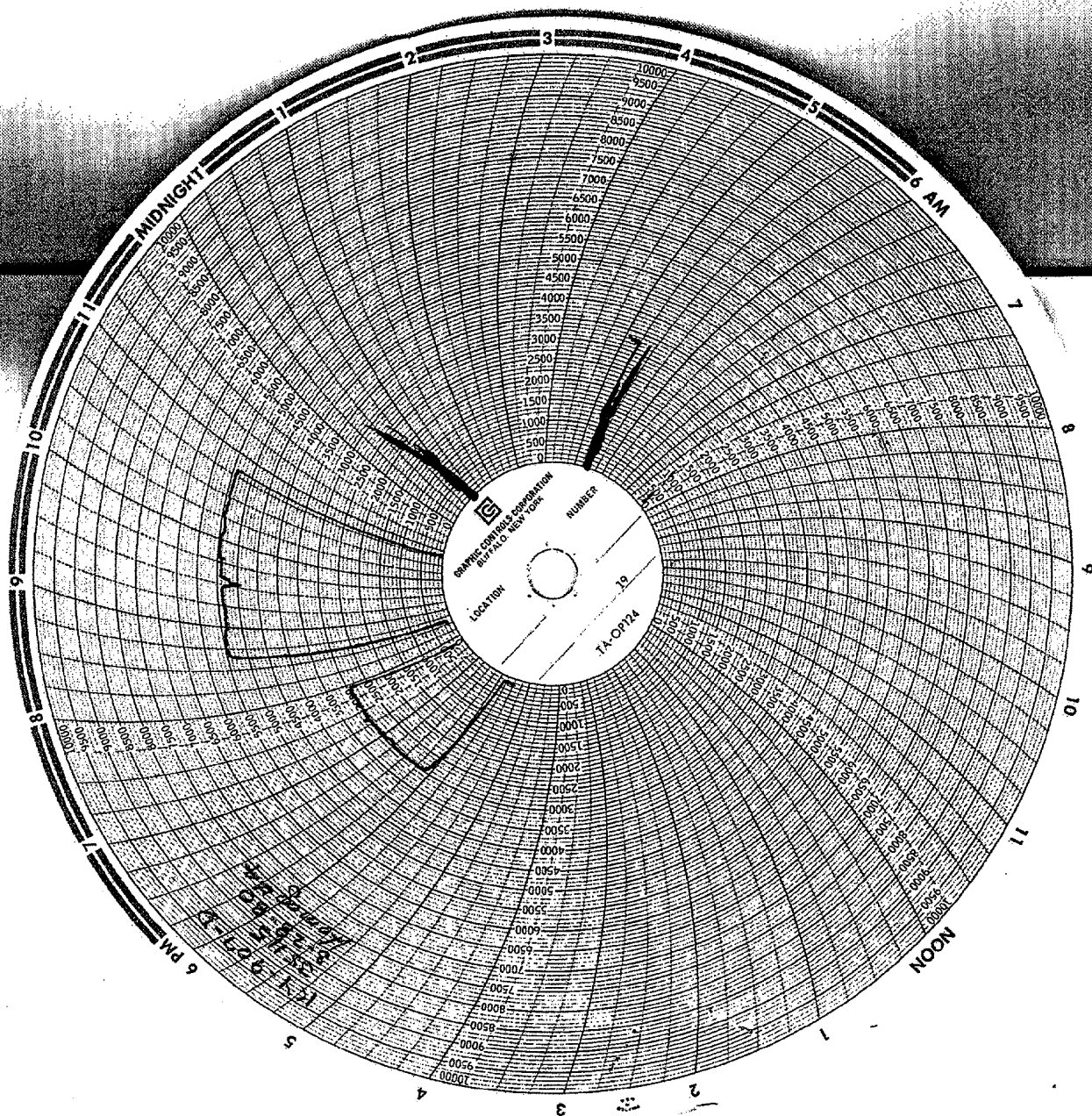
NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205	60" KROLORE YELLOW MEDIUM			
1	1 Run 32" (560 G) water into V-203. SET AGITATOR ON HIGH SPEED			
	2 Pour in	320	32-D	320
	3 Dump in	48 x 50	YC-2-B	2400
	Record: Start 3:45 PM			
	Fin. 5:15 PM			
	4 Adj 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, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record V-205 Vol 44" & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 Run 10" (514 G) water into SV & start agitator			
205 & SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
2	Record: Time Start 8:30 PM Total Min 1:35			
	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	12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
3	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 48% - preset #1 80 Gal		15-A	160
	15 Set strike flow controllers as follows:			
	a. 8FC10 (N-27-D Controller) in Manual 0.83 GPM		27-D	275
	b. 3PC20 (N-27-D Water) in Manual Local 5.28 GPM			
	c. 8FC10 (N-27-D/Water Ratio) 0.64			
	d. 8FC10 (N-32-D Controller) in Manual 1.08 GPM		32-D	1840
	e. 3PC20 (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	16 Operator Step PB			
SP & CP	17 Record Level 2 LG 92%. If below 35% follow solution			
	Make-up procedure for N-27-D			
	18 Adj to 48" (2470 G)			
4	19 Record: pH 10.5			
	20 Adj to 11.1-11.3 using N-7-D diluted to 5% Assume 50%	30	7-D	15
	(10 parts water to 1 part N-7-D)			
	Siphon into SV Record: pH 11.2			
	21 Operator Step PB			

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EQUIPMENT	PAGE	2	CG 03	CODE	KY-907-D (D)	EST. WGT.	3480	LBS.	USE	N	ACCT.
									LBS.	CODE	LBS.
SV SP & CP 5	22	SP Step 06/39 - After heat up	Record: pH	9.8	(9.5-10.0)						
	23	Switch 3FC20, 8FC10, 8FC20 to Auto									
	24	Operator Step PB									
	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits									
		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	12.50					
		13/46 (30 min)	9.8	9.0-10.0	1.30						
		14/47 (60 min)	9.8	9.0-10.0	1.30						
		15/48 (2 hrs)	9.8	9.0-10.0	1.30						
		16/49 (2 hrs 25 min)	9.6	9.0-10.0	3.15						
		17/50 (3 hrs Final)	7.3	7.5-8.5	3.50						
		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 & Assume 78%									
	29	Sift in	Record: pH					50		27-D 128-A	50
	302	30 Add 17" (208 G) water to V-302									
	6	31 Add & stir 2 min for S58				Assume 50%		100		7-D	50
PT 7	32	During strike pump into PT						318		169-A	318
	33	Pump in						36		155-A	36
	34	Pump in						36		160-A	36
	35	Stir 10 min with lightning mixer for S39									
356 8	36	During strike run 20" (244 G) water into V-356									
	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 81-82°C									
	42	Stir 30 min at 178-182°F for S49									
SV & SP 9	43	Do not shut off agitator									
	44	When S29 complete, heat SV to 198-200°F in 5-10 min									
	45	Close water line & discharge valves at stearate pump									
	46	Open V-356 Discharge valves to stearate pump inlet									
	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									

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 S51 complete	turn off	Homog & stearate pump						
	53	Stir 5 min at	198-200°F							
	54	Shut off	steam							
	55	When S54 complete,	Operator PB							
	56	SP Step 23/53	Record pH	3.6 (3.3-3.7)						
	57	If necessary adj pH to (3.3-3.7) (DOWN ONLY)	Record: pH						15-A	
		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	4.2 (4.2-4.4) & if necessary adj pH 4.2-4.4							
		& Record: pH		4.4			Assume 50%		7-D	
		(Dilute 10 parts water to 1 part N-7-D)					Assume 78%	40	27-D	28
		Siphon N-7-D into SV								
	60	Operator Step	PB							
	61	Operator Step	PB							
	62	SP Step 60 - Batch complete								
Pump to VAT 240										
START FINISH OPTR										
Time SP Step Time SP Step										
5:15P 11:00P 235										
11 PM 6:15 282										



N32156.01

DUP050456866

V-243