

S.V. 243,244 (AUTOMATED)

C.V.

PUNCHED & CHECKED

D.V.

CG 03 CODE KY-787-D PKG

APR 10 1980

APR - 8 35244 38162
EST WGT 1090 LBS

STD HRS 8.9 TIME 3P M

14 YC-2-B 93 4 LOT 24770, 2.000 #
LOT 24776, 4.000 #
LOT , #

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

HOMOG #3 - 1ST PASS
" #4 - 2ND PASS

APR 9 1980

TOTAL WGT 3490#

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205	1 RUN 60" (992 G) WATER INTO V-203, SET AGITATOR ON HIGH SPEED			
	2 WEIGH IN DRUM & POUR IN	320	32-D	320
1	3 DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
	RECORD: START 8:30 A.M.			
	FIN 9:15 A.M.			
	75" (1275 G) 24770			
	ADJ TO 70" (1290 G) 24776			
	4 PUMP V-203 THRU HOMOG #3 AT 4800-2200 PSI INTO V-205			
	5 WHEN V-203 MTY, WASH COLOR THRU HOMOG AT 1800-2000 PSI USING MINIMUM WATER			
	6 RECORD V-205 VOL 42" & ADJ TO 60" (2100 G)			
	7 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	8 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205 & SV	9 RUN 10" (514 G) WATER INTO SV. START AGITATOR			
2	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-243			
	RECORD: TIME START 3:40 P.M. TOTAL MIN 2:00			
	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 190-194F)			
	14 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 36% - PRESET #1 80 GAL 15-A 160			
	B. 13LG 5% - PRESET #6 135 GAL 20-A 135			
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	A. 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM 27 275			
	B. 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	C. 3PR10 (N-27-D/WATER RATIO) 0.64			
	D. 8FC20 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM 32-D 1840			
	E. 8EC20 (N-32-D/WATER) IN MANUAL LOCAL 4.47 GPM			
	F. 8FC20 (N-32-D WATER) IN REMOTE			
	G. 8PR10 (N-32-D/WATER RATIO) 0.83			
SV	16 OPERATOR STEP PB			
SP & CP	17 RECORD LEVEL 2 LG 36% IF BELOW 35% FOLLOW SOLUTION			
4	18 MAKE-UP PROCEDURE FOR N-27-D			
	ADJ TO 48" (2470 G)			
	19 RECORD: pH 10.5			
	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)	20	7-D	10
	SIPHON INTO SV. RECORD pH 11.1			
	21 OPERATOR STEP PB			

EQUIPMENT	PAGE 2	CG (3)	CODE	KY-787-D	EST. WGT.	2500	LBS.	USE LBS	N CODE	ALC-1 B5
	22	IF STIR 10/43 - WHEN 3FC20, 3FC20 FLOW IN LIMITS, SWITCH					19.5-10.01			
	23	SWITCH 3FC20, 3FC20, 3FC20 TO AUTO								
	24	QUANTITY STILL IN								
	25	IF STIR 10/43 - WHEN 3FC20, 3FC20 FLOW IN LIMITS, SWITCH								
	26	SWITCH 3FC20 TO AUTO								
	27	IF STIR 10/43 - WHEN 3FC20, 3FC20 FLOW IN LIMITS, SWITCH								
	28	3FC20 M. REMOTE								
	29	OPERATOR STILL IN								
	30	DURING STIR, RECORD PH & TIME AS FOLLOWS:								
	31	SP 2100								
	32	V-245/V-244	PH	RANGE	TIME					
	33	13/46 (10 MIN)		9.0-10.0						
	34	14/47 (10 MIN)		9.0-10.0						
	35	15/48 (2 HRS)		9.0-10.0						
	36	16/49 (2 HRS 30 MIN)		9.0-10.0						
	37	17/50 (3 HRS 30 MIN)		7.5-8.5						
	38	NOTES: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG								
	39	IF FINAL PH IS ABOVE 8.5, ASSUME 7.5-8.5 &								
	40	RECORD: PH						ASSUME 17%		
339 6	41	WHILE STIRRING, RUN 30" (234 G) WATER INTO V-339								
	42	ADD IN 7-8 MIN						350		
	43	ADD TO 1" (382 G) A-80 - 100°F								
	44	STIR 5 MIN & RECORD PH					19.5-10.5			
	45	STIR 5 MIN OR LONGER TO DISSOLVE FOR SP 26								
	46	RECORD VOL. & CALCULATE					(VOL) X 0.70 =			
	47	SET PRESET #8 TO G FROM S 34								
302 7	48	ADD 30" (360 G) WATER TO V-302								
	49	ADD & STIR 2 MIN FOR S 43						ASSUME 50%		80
343 SP & CF B	50	SP STIR 10/43 - AFTER CHECKING PH, 10/43, 10/43, 10/43								
	51	STIR IN								
	52	SP STIR 10/43 - 10/43, 10/43, 10/43								
	53	RUN IN N. 10/43, 10/43, 10/43, 10/43, 10/43, 10/43								
	54	RECORD: 10/43, 10/43, 10/43, 10/43, 10/43, 10/43								
	55	& RECORD: 10/43, 10/43, 10/43, 10/43, 10/43, 10/43								
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MAKING INSTRUCTIONS: BATCH UNIT

S V 243,244 (AUTOMATED) C V
CG 03 CODE KY-787-D PKG

EST WGT 1090 LBS

STD HRS 8.9 TIME M

14 YC-2-B 93 4 LOT #
LOT #
LOT #

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

TOTAL WGT 3490#

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203	1 RUN 60" (992 G) WATER INTO V-203			
&	2 WEIGH IN DRUM & POUR IN	320	32-D	320
205	3 DUMP IN AND STIR 5 MIN LOT	48 X 50	YC-2-B	2400
1	RECORD: START			
	FIN			
	4 ADJ TO 70" (1200 G)			
	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 " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN 10" (514 G) WATER INTO SV START AGITATOR			
&	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-			
SV	RECORD: TIME START TOTAL MIN			
2	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	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)			
CP	14 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
3	A. 11LG % - PRESET #1 80 GAL 15-A 160			
	B. 13LG % - PRESET #6 135 GAL 20-A 135			
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	A. 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM 27 275			
	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 32-D 1840			
	E. 8EC20 (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	17 RECORD LEVEL 2 LG % IF BELOW 35% FOLLOW SOLUTION			
&	MAKE-UP PROCEDURE FOR N-27-D			
CP	18 ADJ TO 48" (2470 G)			
4	19 RECORD: pH			
	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)		7-D	
	SIPHON INTO SV. RECORD pH			
	21 OPERATOR STEP PB			

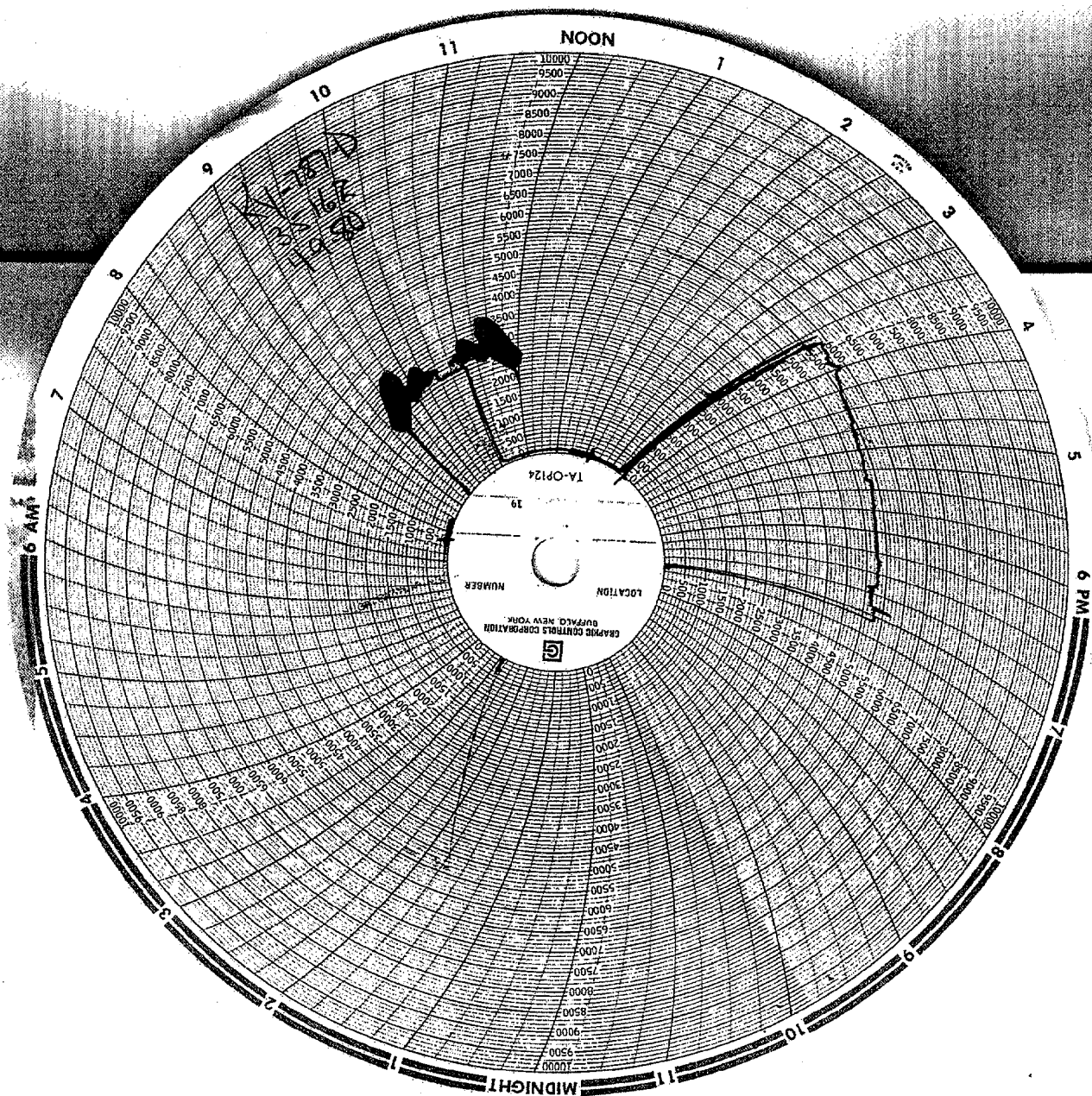
3529 REV.

N32152.01

DUP050456850

V-243

EQUIPMENT	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>7.7</u> (9.5-10.0)								
SP	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO <u>8:45</u>								
&	24	OPERATOR STEP PB								
CP	25	SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS								
5	26	SWITCH 3FC10 TO AUTO OPERATOR STEP PB								
	26	SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH								
	27	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>9.7</u>	9.0-10.0	<u>9:10</u>					
		14/47 (60 MIN)	<u>9.7</u>	9.0-10.0	<u>9:40</u>					
		15/48 (2 HRS)	<u>9.7</u>	9.0-10.0	<u>10:40</u>					
		16/49 (2 HRS 25 MIN)	<u>9.95</u>	9.0-10.0	<u>11:05</u>					
		17/50 (3 HRS FINAL)	<u>9.5</u>	7.5-8.5	<u>11:40</u>					
		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 <u>8.3</u> ASSUME 77%								
								20	27-D	15
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>9.8</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>38.22</u>								
	35	SET PRESET #8 TO <u>38.22</u> FROM S 34								
302	36	ADD 30" (360 G) WATER TO V-302 <u>V-314</u>								
7	37	ADD & STIR 2 MIN FOR S 41						160	7-D	80
V-314		ASSUME 50%								
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 <u>3.7</u> (3.7-4.2)								
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
CP	42	RECORD: pH <u>9.2</u> (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5								
8		& RECORD: pH							27-D	
		(DILUTE 10 PARTS WATER TO 1 PART N-7-D)							7-D	
		ASSUME 77%								
		ASSUME 50%								
		SIPHON N-7 INTO SV								
	43	OPERATOR STEP PB								
	44	SP STEP 29/58 RECORD: pH <u>9.2</u> (9.0-10.0) TIME <u>1:10 A.M.</u>								
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE								
		START		FINISH						
		TIME	SP STEP	TIME	SP STEP	OPTR				
		<u>10:30 AM</u>		<u>3:00 PM</u>		<u>381-438</u>				
		<u>3:45 PM</u>		<u>1:00 PM</u>		<u>126-101</u>				
		<u>11:2 PM</u>		<u>1:10 A.M.</u>		<u>54-235</u>				



N32152.02

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