

S.V. 243 Automated C.V.

MAKING INSTRUCTIONS: BATCH UNIT

CG 03 CODE KY-781-D PKG.

EST. WGT. 1178-1128 LBS.

STD. HRS. TIME M

14 YC-3-B 93 4 23863 250 #

14 YC-3-B 93 4 24417 2700 #

14 YC-3-B 93 4 24422 350 #

4478 Total Wgt. 4428# (Req)

PROCESSES		APPROVED BY
()	KY-781-D (N)	FWP 101378
()	()	AMJ 101378
()	()	
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TYPED BY		
EMW101378		

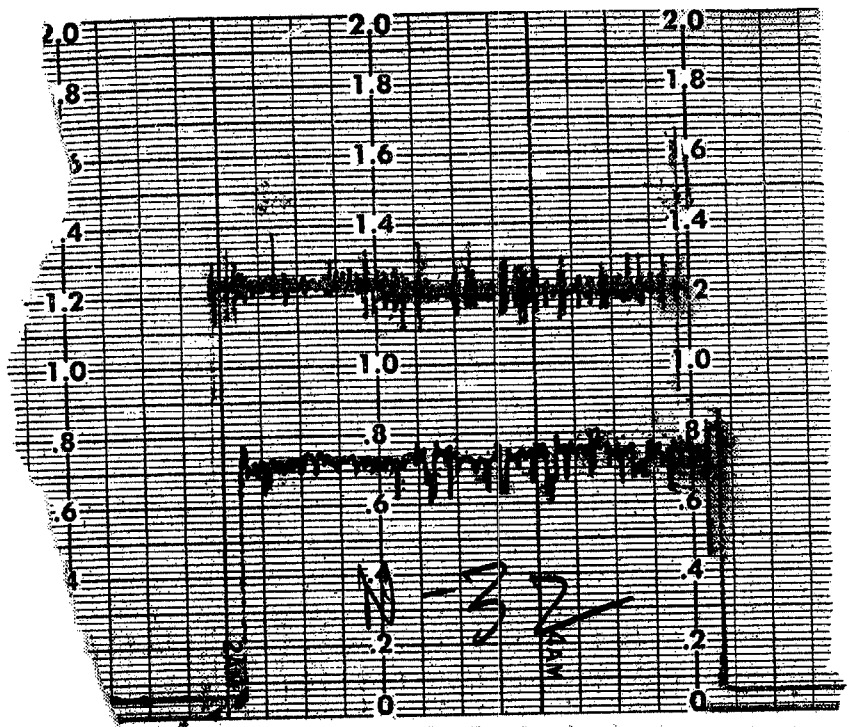
HOMO 4.1st Pass

EQUIPMENT		NAME:	USE LBS.	N CODE	ACCT. LBS.
		KROLOR® YELLOW LIGHT			
203	1	Run 60" (992 G) water in V-203 & add	Assume 50%	36	7-D 18
	&	2 Weigh in drum & pour in		442	32-D 442
205	3	Dump in & stir 5 min	Lot	66 x 50	YC-3-B 3300
1		Record: Start 11.00			
		Fin 12.00			
		28" (12756) 2400-2600			
	4	Add to 80" (1360 G) & Record: pH (10.5-11.5)			
	5	Pump V-203 thru Homog # 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 " & adj. to 45" (1662 G)			
	8	Inspect Homog strainer & clean if necessary			
205	9	Run 12" (200 G) water into SV & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into V-			
		Record: Time Start 9:00 A Total Min 195			
	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 & CP	12	SP Step 01 - Set Formula Selector to position #1 (V-243) or #6 (V-244)			
	13	Press SV Cam Reset PB-Set 22TC in Auto Remote (Temperature is set at 190-194°F)			
	14	Record levels and set Raw Material Counter #1 as follows:			
		a) 21LG % - preset #3 187 Gal		15-A	374
	15	Set strike flow controllers as follows:			
		a) 2FC10 (N-27-D Controller) in Manual 0.9 GPM		27-D	373
		b) 3EC20 (N-27-D Water) in Manual Local 6.3 GPM			
		c) 3PR10 (N-27-D / Water Ratio) 0.7			
		d) 8FC20 (N-32-D Controller) in Manual 1.20 GPM		32-D	2527
		e) 3EC20 (N-32-D Water) in Manual Local 5.4 GPM			
		f) 3EC20 (N-32-D Water) in Remote			
		g) 8FR10 (N-32-D / Water Ratio) 0.9			
SV	16	Operator Step PB			
SP & CP	17	Record Level 2LG 26%. If below 35% follow solution make-up procedure for N-27-D			
	18	Add 223 SV to 54" (2800 G)			
	19	Record: pH 10.0			
	20	Add pH to 11.4-11.6 using Assume 50%		7-D	12
		(Dilute to 5% (10 parts water to 1 part N-7-D)			
		Siphon into SV. Record: pH 11.5			
	21	Operator Step PB			

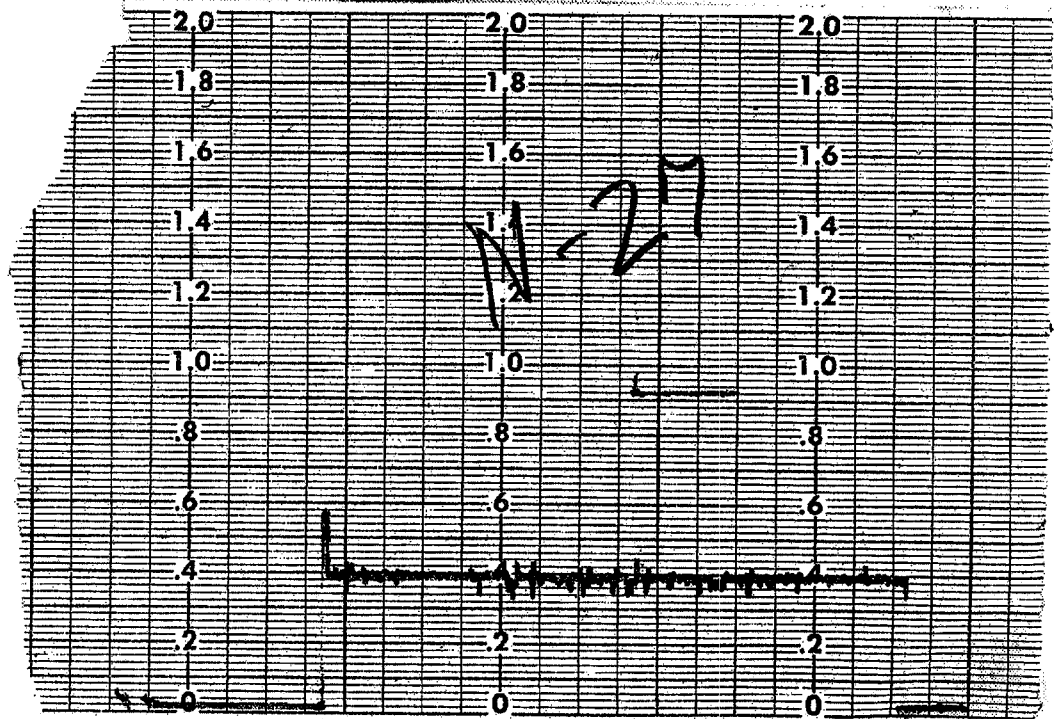
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V-243

EQUIPMENT	PAGE	CG	03 CODE	KY-781-D	N	EST. WGT.	1128	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV SP & CP 5	22	SP	Step 06/39.	After heat up Record:	pH	9.7	(9.6-10.2)				
	23	Switch	3FC20, 8FC10, 8FC20,	to Auto							
	24	Operator	Step PB								
	25	SP	Step 10/43 - When 3FC20, 8FC10, 8FC20 water flow in limits	switch 3FC10 to Auto. Operator Step PB							
	26	SP	Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20	to Remote. Operator Step PB							
	27	During	Strike, Record pH & Time as follows:								
		SP	Step	pH	Range	Time					
		13/41	(30 min)	9.6	9.3-10.0	2:50 P					
		14/47	(60 min)	9.65	9.3-10.0	3:20					
			(2 hrs)	9.7	9.3-10.0	4:20					
			(3 hrs)	9.7	9.3-10.0	5:20					
		17.50	(Final)	7.6	7.5- 8.5	± 6:05					
		NOTE:	If pH not as specified notify Supervisor & note in Log. If final pH is above (8.5) Adj to pH 7.5-8.5								
										27-D	
V-302 6	28	Add	31" (379 G) water to V-302								
	29	Add & stir	5 min			Assume 50%		124		7-D	62
SV SP & CP 7	30	SP	Step 17/50 after checking pH, Operator PB								
	31	SP	Step 23/53 Record: pH	3.5	(3.3-3.7)						
	32	If necessary	adj pH (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								
	33	SP	Step 18/50					150		128-A	200
	34	Run	in N-7-D from S 29 & stir 5 min								
	35	Record:	pH	4.2	(4.2-4.4)						
	36	If necessary	adj pH to (4.2-4.4) with dilute N-7-D (10 parts H ₂ O to 1 part N-7-D) or N-27								
										27-D	
										7-D	
		Siphon	(if N-7-D) into SV. Record: pH								
	37	Operator	Step PB								
	38	SP	Step 24/54 - Add N-978-A & stir 15 min					20		978-A	20
	39	Operator	Step PB								
	40	SP	Step 60 - Batch Complete								
		START		FIN		OPTR					
		TIME	SP STEP	TIME	SP STEP						
		11:00 PM		7:00 AM		381-909					
		7:00 P		3:00 P		126					
		3:00 P		7:25 PM		235-323					



No. 315A164



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

