

(243) 244 (Automated)

C.V.

D.V.

CG 03 CODE KY-787-D PKG.

EST. WGT. JAN 14 1090 33799 LBS.

STD. HRS. 8.9 TIME 3P M

14 - YC-2-B 98 4 Lot 24083 2000#
Lot 24072 400#
Lot 24000 2400#

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 #4 - 12 Pass

Total Wgt. - 3490#

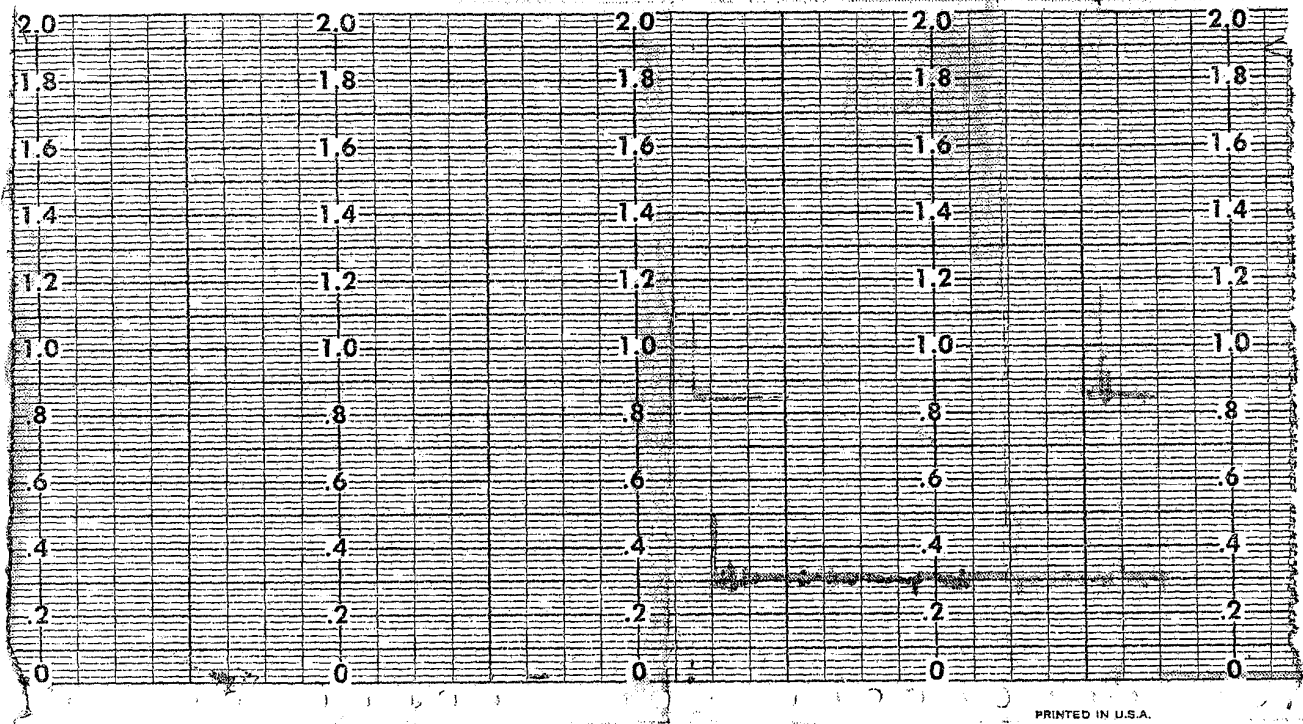
NON-BLEEDING

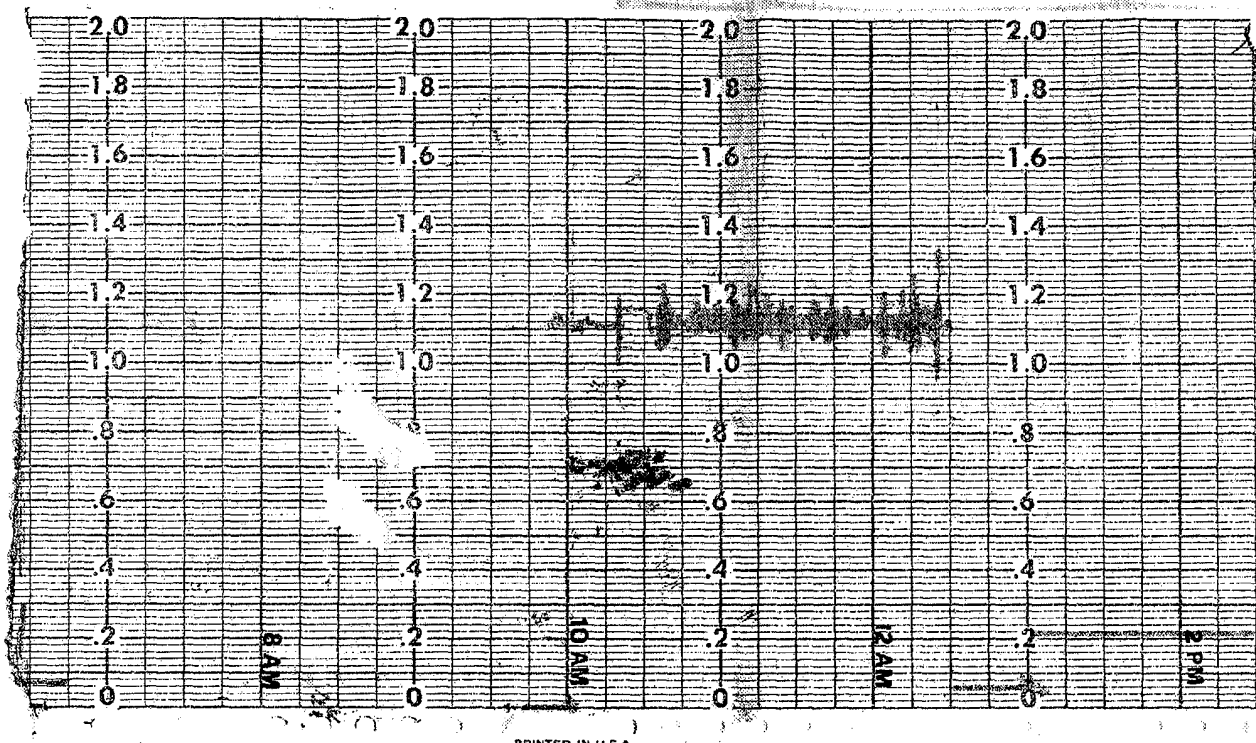
INVENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	10" "KROLOR" - YELLOW MEDIUM			
203 & 205	1 Run 10" (992 G) water into V-203			
1	2 Weigh in drum & pour in	320	32-D	320
263	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 11:45 PM Lot 24083	49		
	Fin 1:00 PM Lot 24072			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205-263	16		
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water 263			
	7 Record V-205 Vol 48 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514G) water into SV & start agitator			
263	10 Pump V-205 thru Homog at 4800-5200 psi into V-			
SV	Record: Time start 11 PM Total Min 1:30			
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)			
& CP	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
3	14 Record Levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 23% - preset #1 80 Gal 15-A 160			
	b. 13LG 23% - 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-D 275			
	b. 3EC20 (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 0.83			
	g. 8FR10 (N-32-D/Water Ratio)			
SV	16 Operator Step PB			
SP	17 Record Level 2 LG 46%. If below 35% follow solution make-up procedure for N-27-D			
& CP	18 Adj to 48" (2470 G)			
4	19 Record pH 10.7			
	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)			
	Siphon into SV. Record pH 11.3			
	21 Operator Step PB			

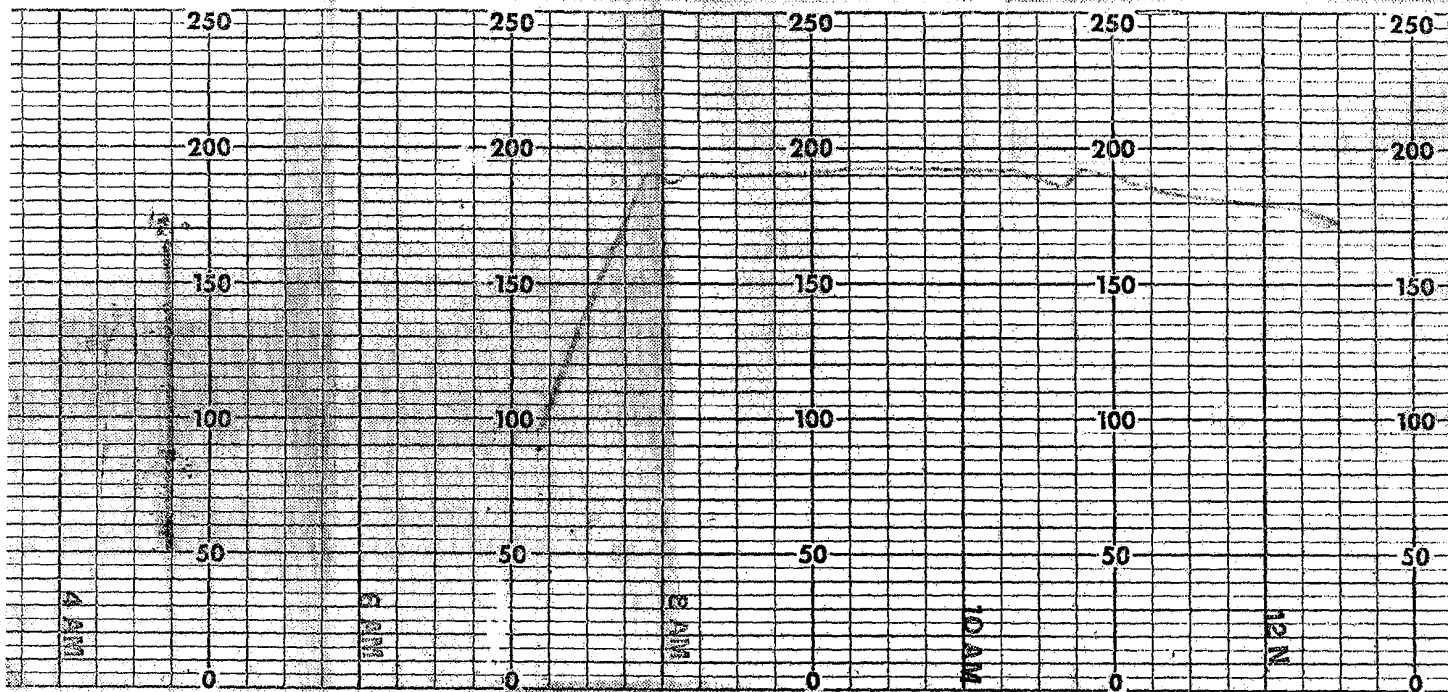
2/12/77

V-243

PMENT	PAGE	CG	CD	CD	EST. WGT.	LBS.	USE	N	ACCT
							LBS.	CODE	LBS.
SV	22	SP	Step 06/39	- After heat up Record: pH	9.9	(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)		7.7	9.0-10.0	2:55			
		14/47 (60 min)		9.7	9.0-10.0	3:23			
		15/48 (2 hrs)		7.7	9.0-10.0	4:23			
		16/49 (2 hrs 25 min)		9.7	9.0-10.0	4:50			
		17/50 (3 hrs Final)		7.9	7.5-8.5	5:25			
		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 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	Add	to 49" (382 G) at 80 - 100°F						
	32	Stir	5 min & record pH 10.2 (9.5-10.5)						
	33	Stir	15 min or longer to dissolve for SP Step 26						
	34	Record	Vol 49" & calculate 49" (Vol) x 0.78 = 38.2 G						
	35	Set	preset #8 to 38.2 G from S 34						
202	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	SIFT	in 2 Bags				100	128-A	100
SP	40	SP	Step 23/53 - Record: pH 3.4 (3.7-4.2)						
&	41	Run	in N-7-D from S37 in 10-12 min & stir 5 min						
CP	42	Record:	pH 9.2 (9.0-9.5) & if necessary add pH 9.0-9.5						
8		& 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						
	43	Operator	Step PB						
	44	SP	Step 29/58 Record: pH 9.1 (9.0-10.0) Time 7:15 PM						
	45	Operator	Step PB						
	46	SP	Step 60 - Batch complete						
		Start	Finish	Optr					
		Time	SP Step	Time	SP Step				
		1:00 AM		2:00 AM		235-342			
		7:00 AM		7:00 PM		435-100			
		3 PM		7 PM		120-101			







GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

