

243

MAY 13 1980

MAKING INSTRUCTIONS: BATCH UNIT

S V

243

(AUTOMATED)

C V

D V

CG 03 CODE KY-787-D PKG
 EST WGT 1090 LBS
 STD HRS 8.9 TIME 3P M

Note STEP 28
 OK
 HP

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	

14 YC-2-B 93 4 LOT 24465, 2000 #
 LOT 24788, 400 #
 LOT , #

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HOMOG #3 185 PASS
 HOMOG #4 - 200

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 RUN AGITATOR ON HIGH SPEED	320	32-D	320
1	2 WEIGH IN DRUM & POUR IN	48 X 50	YC-2-B	2400
	3 DUMP IN AND STIR 5 MIN			
	RECORD: START 5:00 AM	24465		
	FIN 6:45 AM	24788		
	25" (1275 G)	400		
	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 HOMOG AT 1800-2000 PSI USING MINIMUM WATER			
	7 RECORD V-205 VOL 4 " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	9 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205 & SV	10 RUN 10" (514 G) WATER INTO SV START AGITATOR			
2	11 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-203			
	RECORD: TIME START 4:45 PM TOTAL MIN 160			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	12 WHEN V-205 MTY, RUN IN 5" (240 G) WATER AND PUMP THRU HOMOG AT 4800-5200 PSI			
SP & CP	13 SP STEP 01 - SET FORMULA SELECTOR TO POSITION #2 (V-243) OR #7 (V-244)			
3	14 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
	15 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 60% - PRESET #1 80 GAL		15-A	160
	B. 13LG 24% - PRESET #6 135 GAL		20-A	135
	16 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. 8FC20 (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 SP & CP	17 OPERATOR STEP PB			
4	18 RECORD LEVEL 2 LG 65%. IF BELOW 35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
	19 ADJ TO 48" (2470 G)			
	20 RECORD: pH 11.2			
	21 ADJ TO 11.1 & 11.3 USING N-7-D DILUTED TO 5% ASSUME 50% (10 PARTS WATER TO 1 PART N-7-D)			
	22 SIPHON INTO SV. RECORD pH 11.2			
	23 OPERATOR STEP PB			

V-243

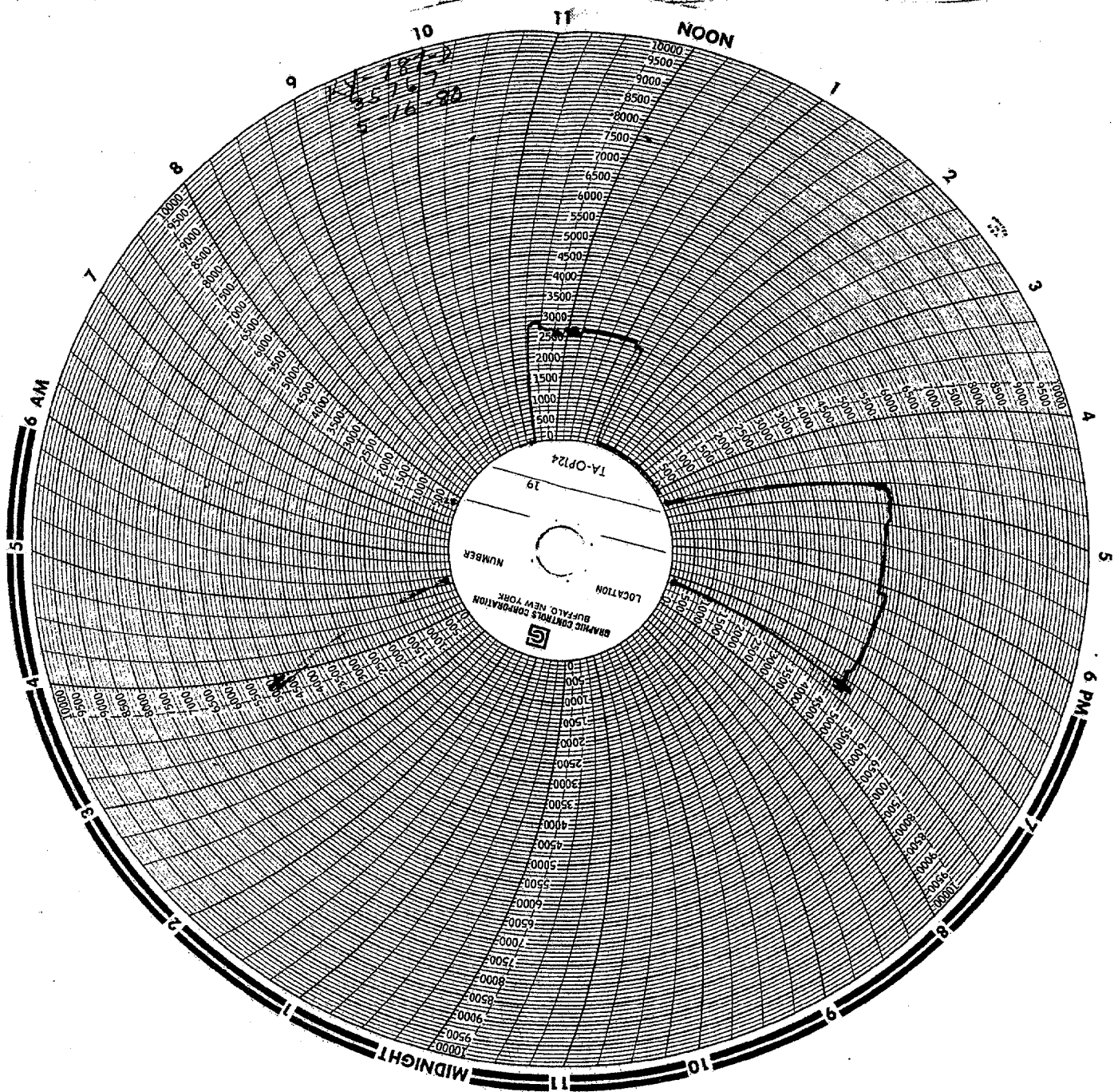
EQUIPMENT	PAGE 2	CG 03	CODE	KY-787-D	EST. WGT.	3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP STEP 06/39	- AFTER HEAT UP RECORD: pH	10.0	(9.5-10.0)					
SP	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO								
&	24	OPERATOR STEP PB								
CP	25	SP STEP 10/43	- WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS							
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								
		13/46 (30 MIN)	pH	9.8	RANGE	9.0-10.0	TIME	8:55		
		14/47 (60 MIN)	pH	9.8	RANGE	9.0-10.0	TIME	9:25		
		15/48 (2 HRS)	pH	9.25	RANGE	9.0-10.0	TIME	10:25		
		16/49 (2 HRS 25 MIN)	pH	9.75	RANGE	9.0-10.0	TIME	10:50		
		17/50 (3 HRS FINAL)	pH	9.2	RANGE	7.5-8.5	TIME	11:25		
		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				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	10.0	(9.5-10.5)						
	33	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26								
	34	RECORD VOL 51 " & CALCULATE 52 " (VOL) X 0.78 = 39.8								
	35	SET PRESET #8 TO 39.8 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	SIFT IN 2 BAGS					100		128-A	100
SP	40	SP STEP 23/53 - RECORD pH	3.75	(3.7-4.2)					6.5	
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
CP	42	RECORD: pH	9.2	(9.0-9.5) & IF NECESSARY ADJ 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 INTO SV								
	43	OPERATOR STEP PB								
	44	SP STEP 29/58 RECORD: pH	9.2	(9.0-10.0) TIME	12:35 PM					
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE								
		START		FINISH						
		TIME	SP STEP	TIME	SP STEP	OPTR				
		11:AM		3:11M		54-301				
		3:00P		11:00P		235-237				

8:25 PM

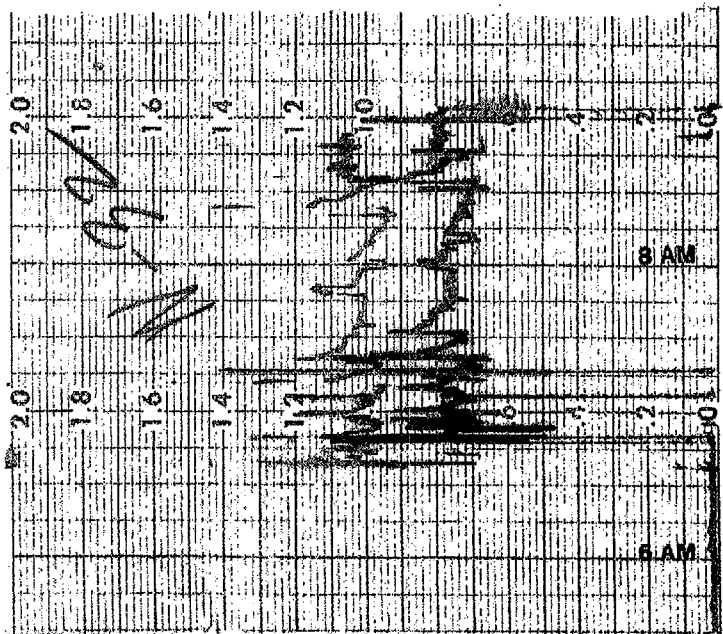
Manual
Auto

Note

STEP 28: N-33 WOULDN'T COME IN LIMITS BLEED LINE
N.G. CHANGED TO MANUAL, ADJ MANUAL EVERY
15 MIN. TRIED AUTO EVERY 30 MIN. NO GOOD
Finally got Auto in limits After 2 Hrs 10:25 PM.
SEE N-32 CHART.

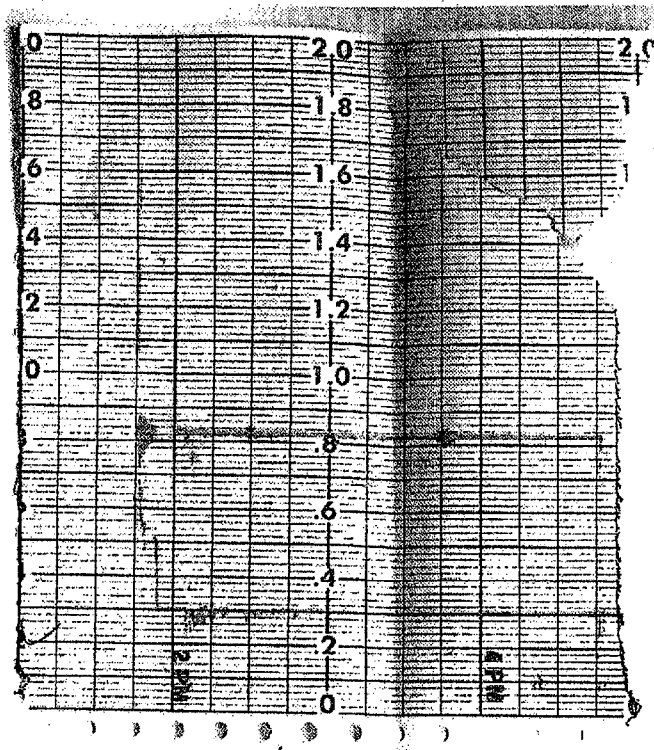


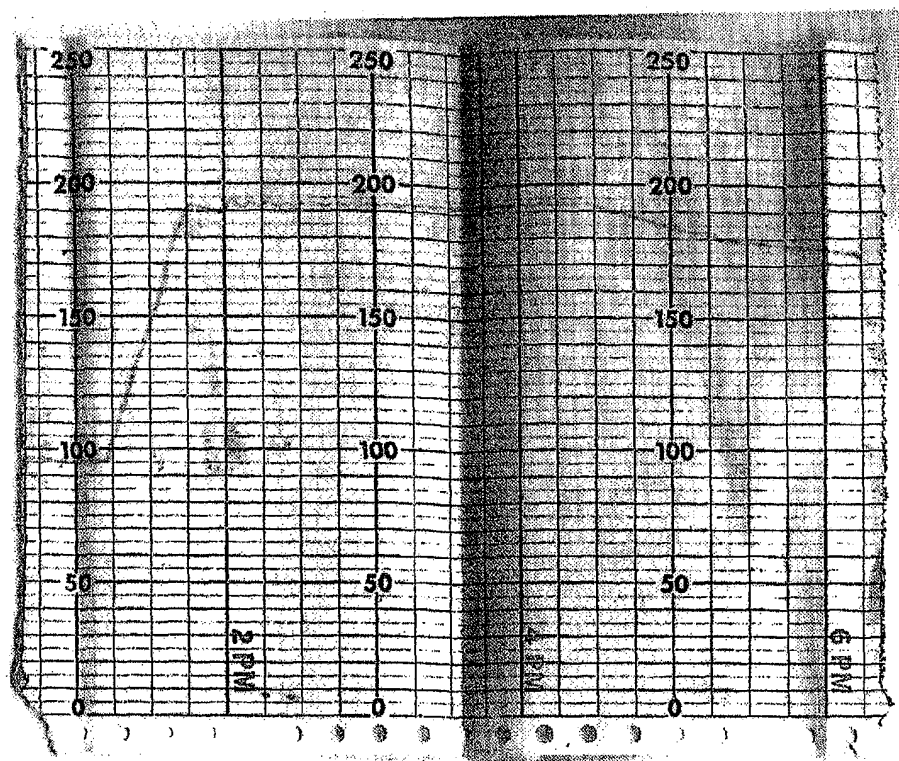
V-243



DUP050456570

N32091.02





DUP050456572