

CG 03 CODE KY-788-D PKG.
 → MAR 21 34992 PUNCHED & CHECKED OK
 EST. WGT. 950 860 LBS.
 STD. HRS. 8.8 TIME
 14 YC-3-B 98 4 Lot 24694 2,600 JP
 14 YC-3-B 98 4 Lot
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PROCESSES APPROVED BY
 () KY-788-D (J) EWK 9/28/76
 () () MTW 9/30/76
 () () DCG 9/30/76
 () ()
 TYPED BY
 NE 2-18-77

Total Wgt. 3560# 3460

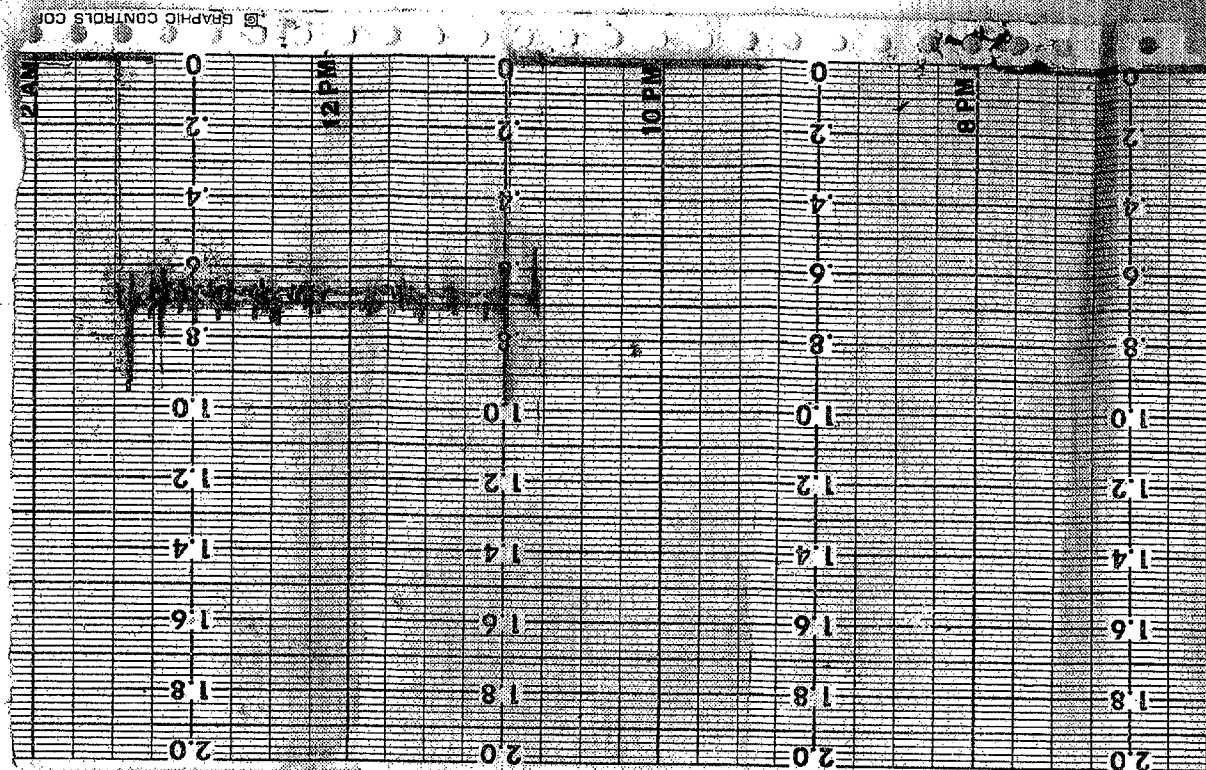
MAR 21 1980

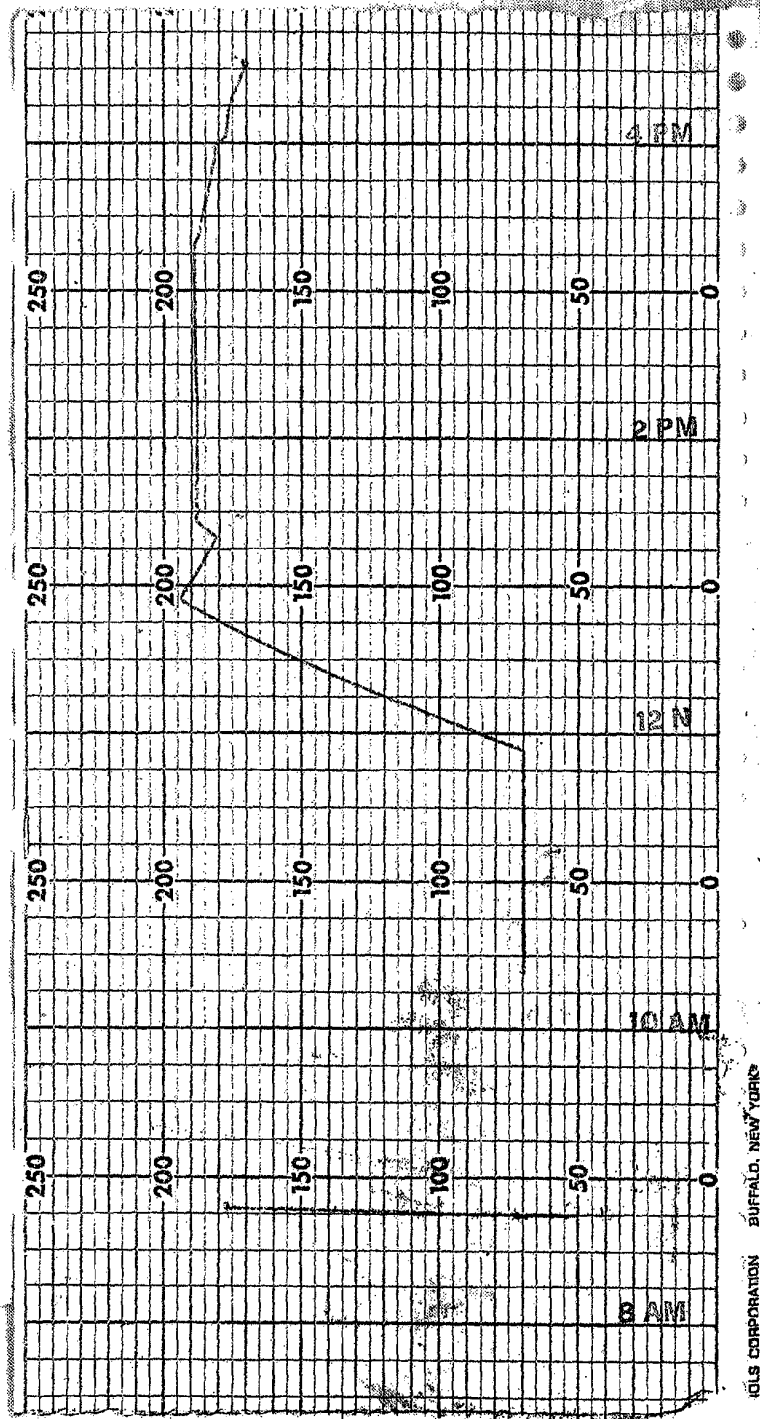
NON-BLEEDING

JIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1 Run 23" (360 G) water into V-203. <u>SET AGITATOR ON HIGH SPEED</u>			
	2 Weigh in drum & pour in	345	32-D	345
	3 Dump in & stir 5 min	Lot	YC-3-B	2600
	Record: Start <u>24694</u>	<u>2,600</u>		
	Fin <u>75" (1275 G)</u>			
	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 washcolor thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-205 Vol <u>43</u> "& adj to 60" (2100 G)			
	8 Inspect homog. strainer & clean if necessary			
	<u>DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED.</u>			
205 & SV 2	9 Run 10" (514 G) water into V- <u>244</u> & start agitator			
	10 Pump V-205 thru Homog at 4800-5200 psi into V- <u>244</u>			
	Record: Time Start <u>415</u> total min <u>725</u>			
	Note: If Homog pressure falls below 4800 ps., 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 3	12 SP Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
	13 Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG <u>38</u> % - preset #2 208 Gal		15-A	416
	b. 13LG <u>145</u> % - preset #6 135 Gal		20-A	135
	15 Set strike flow controllers as follows:			
	a. 3EC10 (N-27-D Controller) in Manual 0.54 GPM		27-D	180
	b. 3EC20 (N-27-D Water) in Manual Local 4.4 GPM			
	c. 3FR10 (N-27-D/Water) Ratio 0.8			
	d. 8EC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1215
	e. 8EC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 8EC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water) Ratio 1.1			
320 & SP 4	16 Operator Step PB			
	17 Record level 21G <u>70</u> %. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH <u>10.3</u> . Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH <u>11.3</u>	<u>15</u>	7-D	<u>7</u>
	20 Operator Step PB			

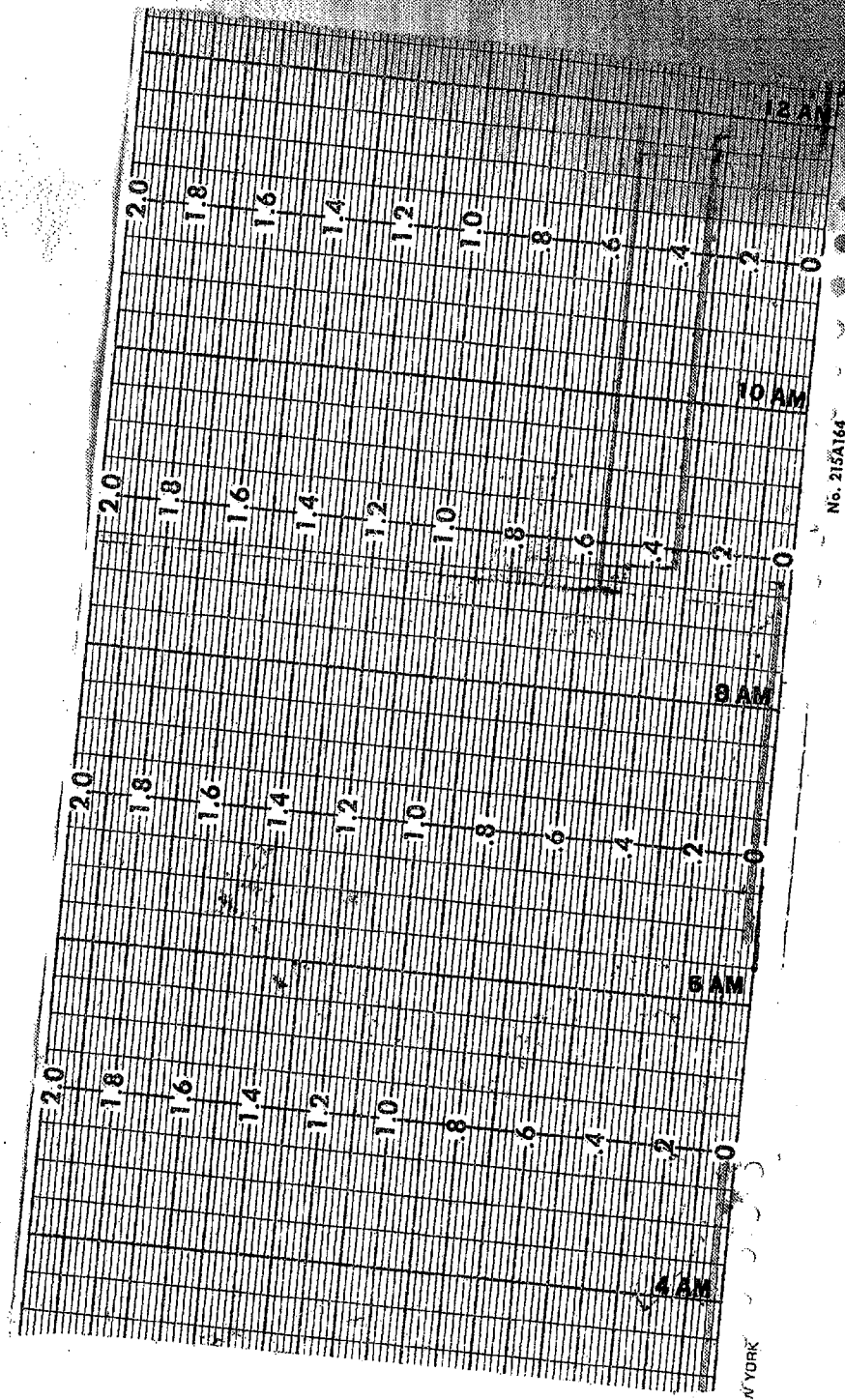
244

UIPMENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3500	LBS.	USE LBS.	N CODE	ACC LBS.	
SV	21	SP Step 06/39 - After heat up Record: pH 9.8 (9.5-10.0)							
SP	22	Switch 3FC20 8FC10, 3FC20 to Auto							
	23	Operator Step PB							
5	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits. Switch 3FC10 to Auto. Operator Step PB							
	25	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote							
	26	Operator Step PB							
	27	During strike, record pH & time as follows:							
		SP Step							
		V-243/V-244	pH	Range	Time	9:45			
		13/45 (30 min)	9.6	9.3-10.0	10:15				
		14/47 (60 min)	9.6	9.3-10.0	10:45				
		15/48 (2 hrs)	9.6	9.3-10.0	11:45				
		16/49 (2 hrs 25 min)	9.6	9.3-10.0	12:10				
		17/50 (Final 3 hrs)	8.1	7.5-8.5	12:45				
		Note: If not as specified notify Supervisor & Note in log							
		If final pH is above 8.5, adj 7.5-8.5							
		& Record: pH Assume 77%							
							27-D		
339	28	While striking run 30" (234 G) water into V-339							
6	29	Add in 7-8 min					350	530-A	350
	30	Adj to 49" (382 G) at 80-100 °F							
	31	Stir 5 min & record pH 10.0 (9.5-10.5)							
	32	Stir 15 min or longer to dissolve for SP Step 26/56							
	33	Record Vol 50 " & Calculate 50 " (Vol X 0.78= 39.0 G)							
	34	Set preset #8 to 39.0 G from S 33							
302	35	Run 40" (440 G) water into V-302							
7	36	Add & stir 2 min for S 40					Assume 50%	360	7-D 180
SV	37	SP Step 17/50 After checking pH. Operator Step PB							
SP	38	SP Step 23/53 Record: pH 3.0 (3.7-4.2)							
8	39	Run in N-7-D from S 36 in 10-12 min & stir 5 min							
	40	Record: pH 9.4 (9.0-9.5) & if necessary adj to pH 9.0-9.5							
		& 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							
	42	Operator Step PB							
	43	SP Step 29 - Record: pH 9.4 (9.0-10.0) Time 7:45							
	44	Operator Step PB							
	45	SP Step 60 - Batch complete							
		Start	Finish	Optr					
		Time	SP Step	Time	SP Step	223-224			
		11:00	7	7:45	100				





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