

CG 03 CODE KY-788-D PKG.

→ MAR 15 34887

EST. WGT. 960 860 LBS.

STD. HRS. 8.8 TIME 3 P M
 14 YC-3-B 98 4 Lot 24406 22.00
 14 YC-3-B 98 4 Lot 24405 PUNCHED & CHECKED
 14 YC-3-B 98 4 Lot 24407 2.00

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	

MAR 19 1980

Total Wgt. 3560# 3460

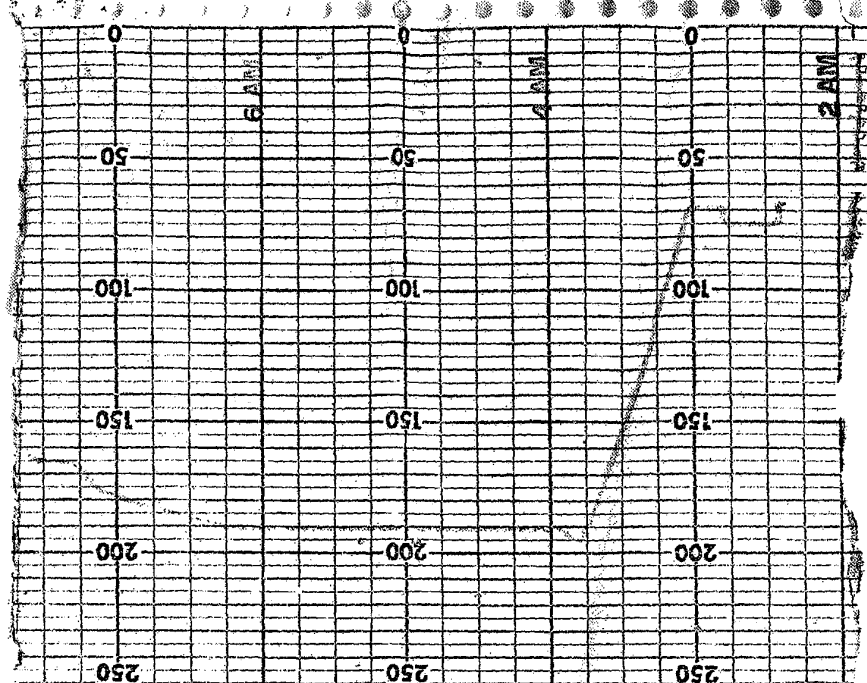
NON-BLEEDING

U/PMENT	NAME	USE LBS.	N CODE	ACC LBS.
203	"KROLOR" YELLOW - LIGHT			
203	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED			
205	2 Weigh in drum & pour in	345	32-D	345
1	3 Dump in & stir 5 min	52 x 50	YC-3-B	2600
	Record: Start 12:30 PM	24406		
	Fin 2:00 PM	24405		
	75" (1275 G)	2447		
	4 Adj to 70" (1200 G) 2400-2600			
	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 41" & adj to 60" (12100 G)			
	8 Inspect homog. strainer & clean if necessary			
205	9 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
SV	10 Run 10" (514 G) water into V-205 & start agitator			
2	11 Pump V-205 thru Homog at 4800-5200 psi into V-			
	Record: Time Start 4:05 PM total min 1.00			
	Note: If Homog pressure falls below 4800 ps., 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	13 SP Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
&	14 Press SV Cam Reset PB- set 22 TC in Auto Remote			
CP	(Temperature is set at 190-194 F)			
3	15 Record levels and set Raw Material Counter #1 as follows			
	a. 11LG % - preset #2 208 Gal 15-A 416			
	b. 13LG 26 % - preset #6 135 Gal 20-A 135			
	16 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.54 GPM 27-D 180			
	b. 3FC20 (N-27-D Water) in Manual Local 4.4 GPM			
	c. 3PR10 (N-27-D/Water) Ratio 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 0.92 GPM 32-D 1215			
	e. 8FC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8PR10 (N-32-D/Water) Ratio 1.1			
320	17 Operator Step PB			
243	18 Record Level 21G %.. If below 35% follow solution			
SP	make-up procedure for N-27-D			
&	19 Adj SV to 47" (2400 G)			
CP	20 Record pH 11.3. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
4	Siphon into SV & Record: pH			
	21 Operator Step PB			

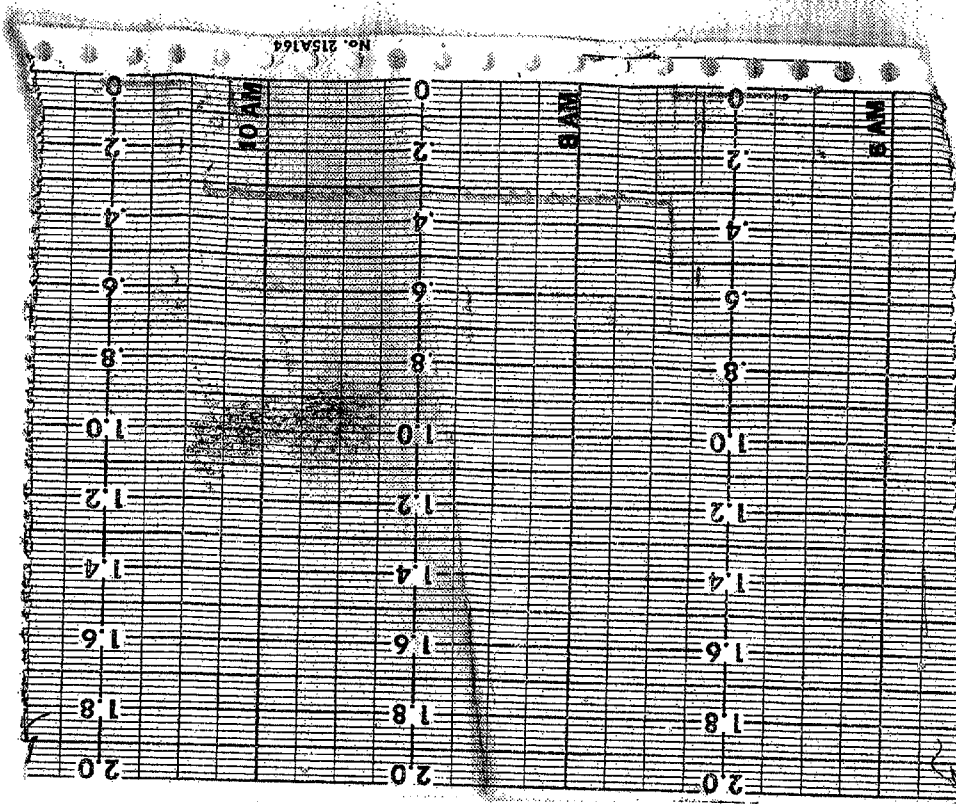
V-243

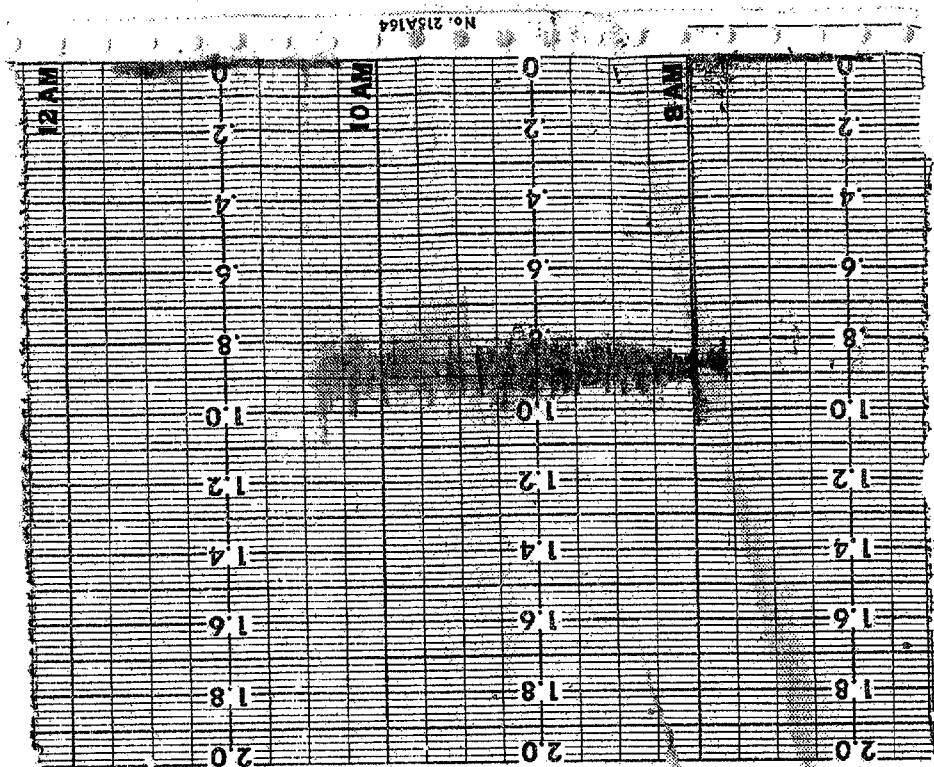
EQUIPMENT	PAGE 2 CG 03 CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	21 SP Step 06/39 - After heat up Record: pH <u>9.8</u> (9.5-10.0)					
SP	22 Switch 3FC20, 8FC10, 8FC20 to Auto					
	23 Operator Step PB					
5	24 SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits					
	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:					
	SR Step					
	V-222/V-224 pH Range Time					
	13/45 (30 min) 9.7 9.3-10.0 7:15					
	14/47 (60 min) 9.7 9.3-10.0 7:45					
	15/48 (2 hrs) 9.6 9.3-10.0 8:45					
	16/49 (2 hrs 25 min) 9.6 9.3-10.0 9:10					
	17/50 (Final 3 hrs) 9.5 7.5-8.5 9:15					
	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 Add to 49" (382 G) at 80-100 °F					
	31 Stir 5 min & record pH (9.5-10.5)					
	32 Stir 15 min or longer to dissolve for SP Step 26/56					
	33 Record Vol. " & Calculate " (Vol X 0.78 = 35.2 G)					
	34 Set preset #8 to 49 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 Sift in 2 bags			100	128-A	100
	39 SP Step 23/53 Record: pH <u>3.2</u> (3.7-4.2)					
8	40 Run in N-7-D from S 36 in 10-12 min & stir 5 min					
	41 Record: pH <u>9.2</u> (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 <u>9.1</u> (9.0-10.0) Time <u>10:35</u>					
	44 Operator Step PB					
	45 SP Step 60 - Batch complete					
	Start Finish Optr					
	Time SP Step Time SP Step					
	2:00 PM 3:00 PM 2:35					
	3:00 PM 10:35 120					

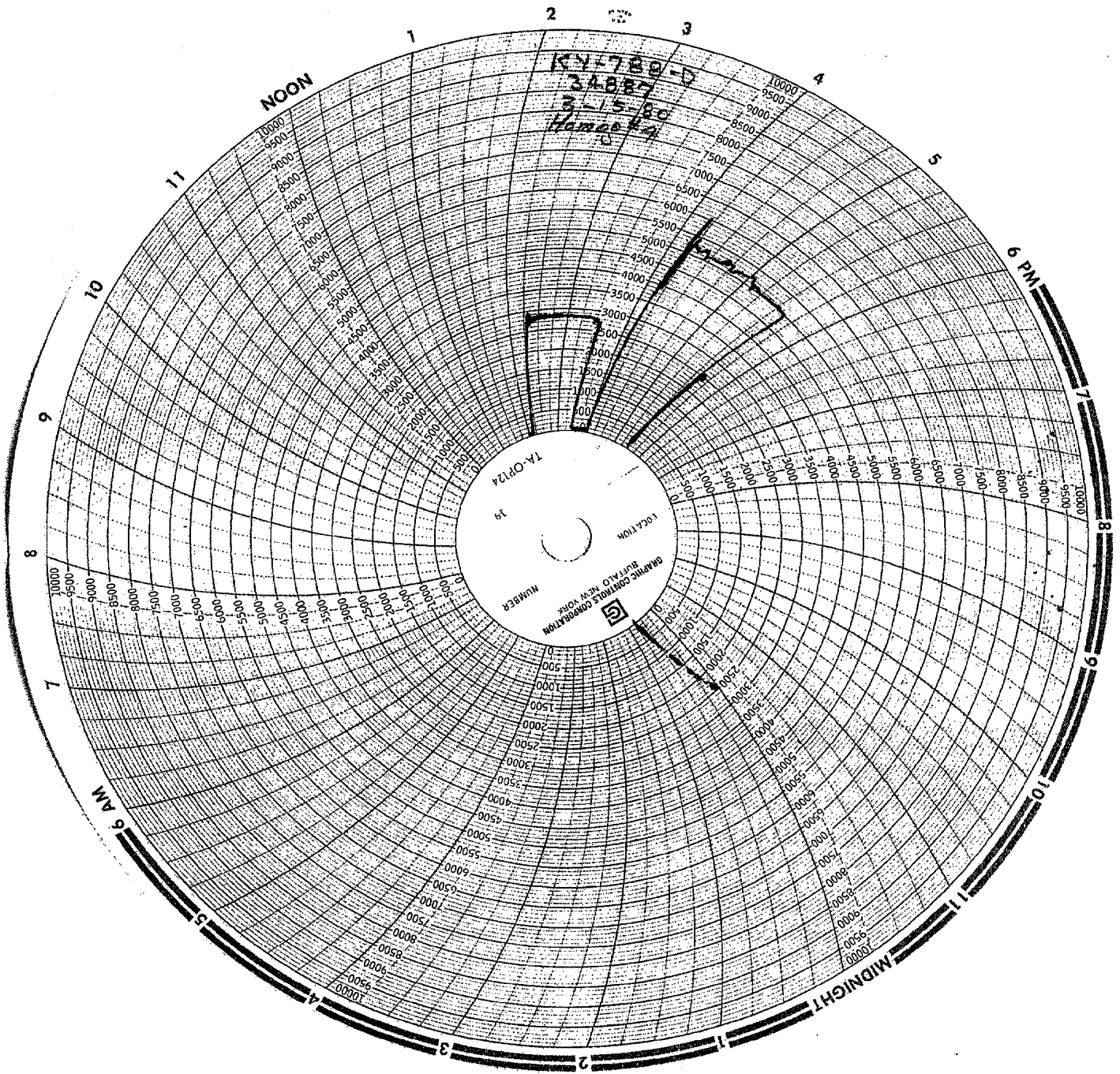
GRAPHIC CONTROLS



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