

CG 03 CODE KY-787-D PKG. _____

EST. WGT. 1090 990 LBS. 34559STD. HRS. 8.9 TIME 7 A M14 - YC-2-B 98 4 Lot 24064, 2400 # 4
Lot _____ # _____
Lot _____ # _____

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	

PUNCHED & CHECKED #4, 1ST P. 3-200 11Total Wgt. - 3490#

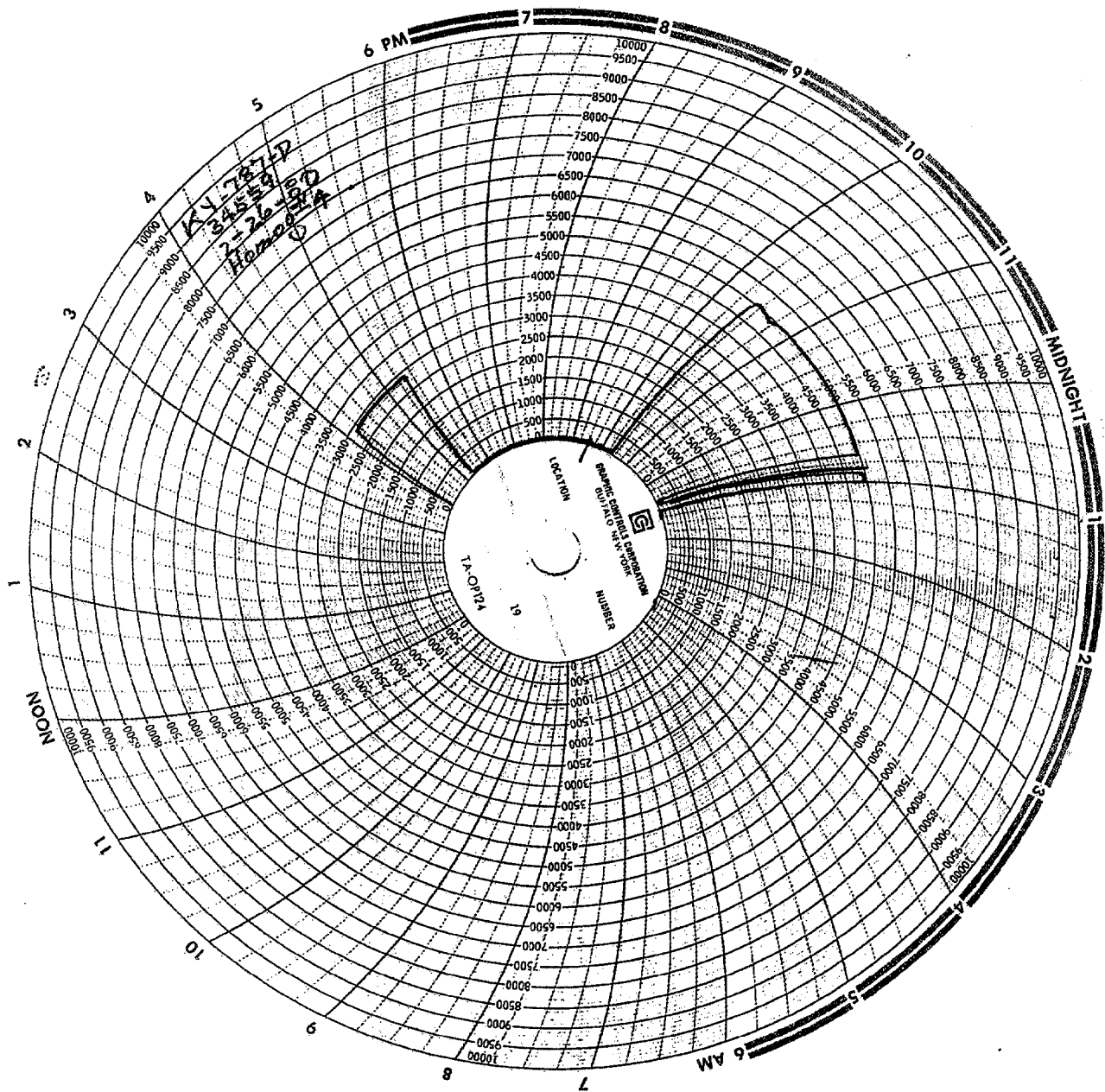
FEB 23 1977

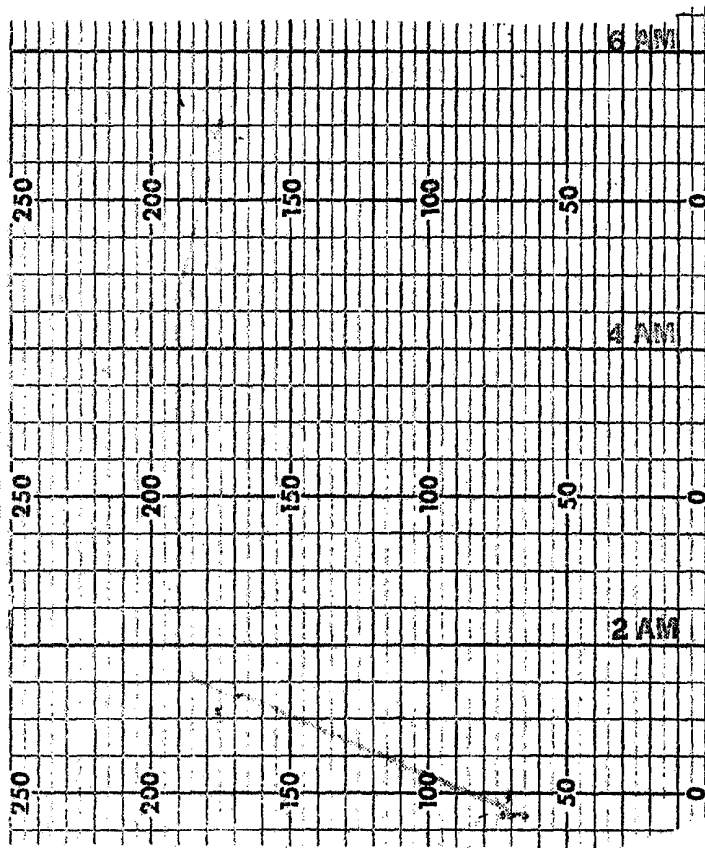
NON-BLEEDING

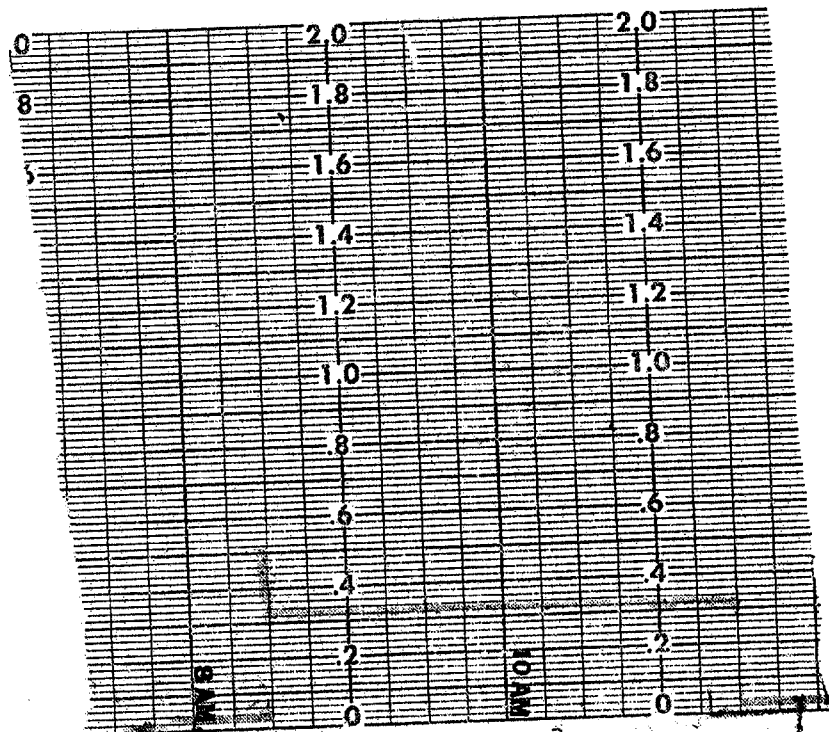
UIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	"KROLOR" - YELLOW MEDIUM			
203	1 Run 60" (992 G) water into V-203. Set agitator on high speed			
&	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start <u>12:30 PM</u> Lot <u>24064</u> Fin <u>7:50 (12756)</u>	<u>2400</u>		
	4 Adj to 70" (1200 G) <u>2400-2600</u>			
	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 <u>4-1</u> " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	During homog run V-203 agitator on low speed.			
205	9 Run 10" (514G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V- <u>243</u>			
2	Record: Time start <u>10:30 PM</u> Total Min <u>1:50</u>			
	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)			
&	13 Press SV Cam Reset PB-set 22TC in Auto Remote			
CP	(Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 14G <u>60</u> % - preset #1 80 Gal		15-A	160
	b. 13G <u>66</u> % - 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. 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. 8EC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 4FR10 (N-32-D/Water Ratio) 0.83			
SV	16 Operator Step PB			
SV	17 Record Level 2 LG <u>60</u> %. If below 35% follow solution make-up procedure for N-27-D			
&	18 Adj to 48" (2470 G)			
CP	19 Record pH <u>10.4</u>			
4	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 <u>11.1</u>			
	21 Operator Step PB			

V-243

JIPMENT	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 <u>9.6</u> (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: <u>2.55</u>					
	SP STEP					
	V-243/V-244 pH Range Time					
	13/46 (30 min) <u>9.5</u> 9.0-10.0 <u>3.05</u>					
	14/47 (60 min) <u>9.5</u> 9.0-10.0 <u>3.35</u>					
	15/48 (2 hrs) <u>9.5</u> 9.0-10.0 <u>4.35</u>					
	16/49 (2 hrs 25 min) <u>9.5</u> 9.0-10.0 <u>5</u>					
	17/50 (3 hrs Final) <u>7.5</u> 7.5-8.5 <u>3.35</u>					
	NOTE: If not as spec. 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 White 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 <u>9.8</u> (9.5-10.5)					
	33 Stir 15 min or longer to dissolve for SP Step 26					
	34 Record Vol. <u>49</u> " & calculate <u>49</u> " (Vol) x 0.78 = <u>38.2</u> G					
	35 Set preset #8 to <u>38.2</u> 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 STEP IN 2 Bags			100	128-A	100
SP	40 SP Step 23/53 - Record: pH <u>3.6</u> (3.7-4.2)					
&	41 Run in N-7-D from 27 in 10-12 min & stir 5 min.					
CP	42 Record: pH <u>9.5</u> (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-D into SV					
	43 Operator Step PB					
	44 SP Step 29/58 Record: pH <u>9.5</u> (9.0-10.0) Time <u>6:25 A</u>					
	45 Operator Step PB					
	46 SP Step 60 - Batch complete					
	Start Finish Optr					
	Time SP Step Time SP Step					
	<u>3:00 P</u> <u>11:00 P</u> <u>6:30 P</u> <u>2:35</u>					
	<u>11:00 P</u> <u>6:30 P</u> <u>126</u>					







No. 215A164

