

CO 03 CODE KY-787-D

PKG.

JAN 12

33774

EST. WGT.

1090

LBS.

STD. MRS.

8.9

TIME

11P M

14 - YC-2-B 98 4

Lot

24078, 400

Lot

24079, 1000

Lot

, 2000

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			

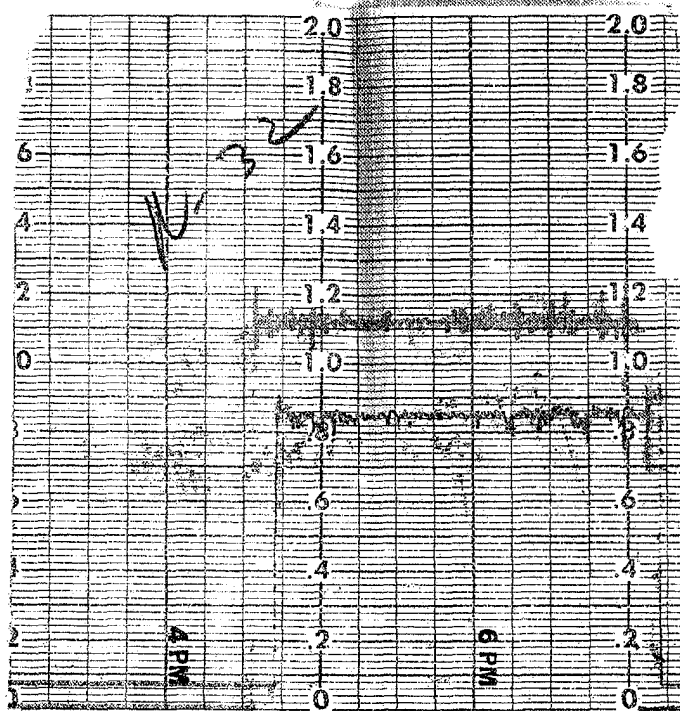
Total Wgt. - 3490#

NON-BLEEDING

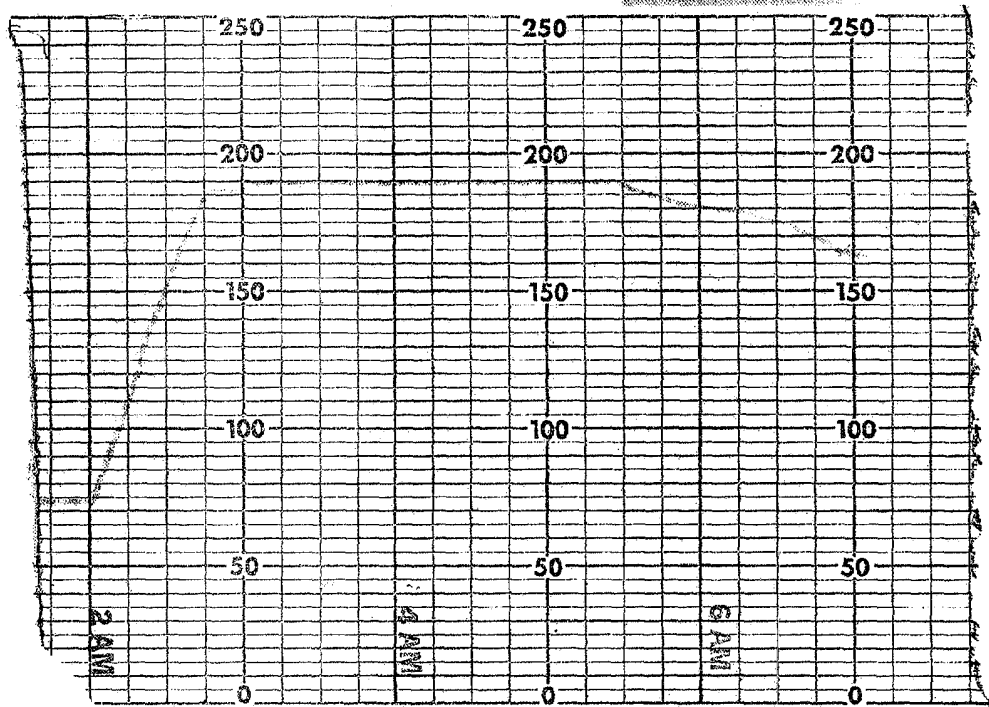
IPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	10" "KROLOR" - YELLOW MEDIUM			
203 & 205	1 Run 10" (922 G) water into V-203			
203	2 Weigh in drum & pour in	320	32-D	320
1	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
263	Record: Start 1000	24078		
	Fin 2000	24079		
	Adj to 70" (1200 G)	2400-2600		
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water			
263	7 Record V-205 Vol 36" & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
203 & SV	9 Run 10" (514G) water into SV & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into V-203			
	Record: Time start 2:00 PM Total Min 70			
	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 82% - preset #1	80 Gal	15-A	160
	b. 13LG 48% - 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. 3FC18 (N-32-D Controller) in Manual	1.08 GPM	32-D	1840
	e. 3FC20 (N-32-D Water) in Manual Local	4.47 GPM		
	f. 3FR20 (N-32-D Water) in Remote			
	g. 3FR10 (N-32-D/Water Ratio)	0.83		
SV	16 Operator Step PB			
SP	17 Record Level 2 LG 67% . If below 35% follow solution make-up procedure for N-27-D			
& CP	18 Adj to 48" (2470 G)			
4	19 Record pH 10.5			
	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			

243

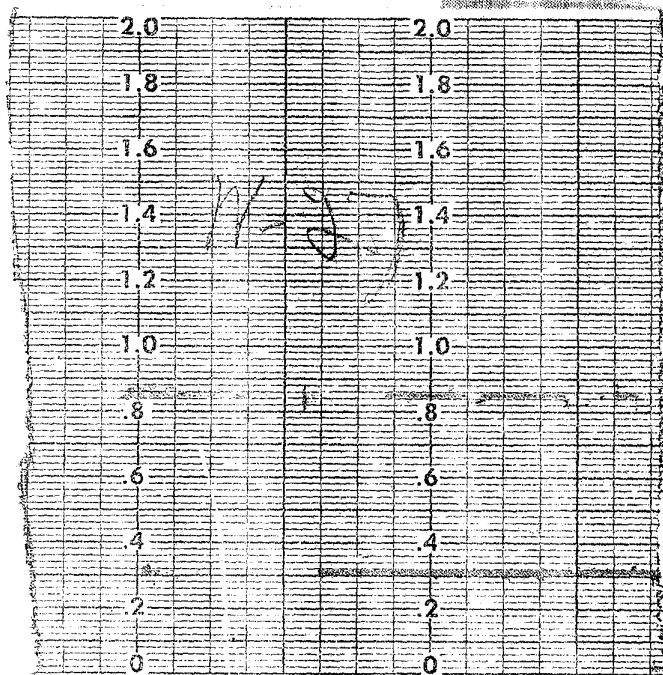
PMENT	PAGE 2 CG 03 CPDE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22 SP Step 06/39 - After heat up Record: pH <u>9.9</u> (9.5-10.0)					
SP	23 Switch 3FC20, 8FC10, 8FC20 to Auto					
&	24 Operator Step PB					
CP	25 SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits					
5	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:					
	SP STEP					
	V-243/V-244 pH Range Time					
	13/46 (30 min) <u>9.8</u> 9.0-10.0 <u>1:40</u>					
	14/47 (60 min) <u>9.8</u> 9.0-10.0 <u>2:10</u>					
	15/48 (2 hrs) <u>9.8</u> 9.0-10.0 <u>2:10</u>					
	16/49 (2 hrs 25 min) <u>9.75</u> 9.0-10.0 <u>2:35</u>					
	17/50 (3 hrs Final) <u>9.1</u> 7.5-8.5 <u>4:10</u>					
	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 Adj to 49" (382 G) at 80 - 100°F					
	32 Stir 5 min & record pH <u>10.2</u> (9.5-10.5)					
	33 Stir 15 min or longer to dissolve for SP Step 26					
	34 Record Vol <u>50</u> & calculate <u>50</u> (Vol) x 0.78 = 39.0 G					
	35 Set preset #8 to 39.0 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 <u>3.6</u> (3.7-4.2)					
&	41 Run in N-7-D from S37 in 10-12 min & stir 5 min					
CP	42 Record: pH <u>9.1</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>9.3</u> (9.0-10.0) Time <u>5:10 AM</u>					
	45 Operator Step PB					
	46 SP Step 60 - Batch complete					
	Start Finish Optr					
	Time SP Step Time SP Step					
	<u>3:00 AM</u> <u>11:00 AM</u> <u>3:00 AM</u> <u>5:10 AM</u>					
	<u>11:00 AM</u> <u>5:10 AM</u> <u>3:00 AM</u> <u>5:10 AM</u>					



GRAPHIC CONTROLS CORPORATION BUFFALO, N.Y.



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