

243-244 (Automated)

C.V.

D.V.

CO 03 CODE KY-787-D PKG.

MAR-4 34895

EST. WGT. 1090 990 LBS.

STD. HRS. 8.9 TIME 11PM 12AM

14 - YC-2-B 98 4 Lot 24066 1200 #

Lot 24079 1200 PUNCHED & CHECKED

Lot

Total Wgt. - 3490# 3590

MAR - 5 1969 # 3

1ST PASS

2ND PASS

NON-BLEEDING

PROCESSES		APPROVED BY	
() KY-787-D	()	EWK	9/22/76
()	()	DCG	9/27/76
()	()	MTW	9/30/76
()	()		
TYPED BY			
N.E. 2/12/77			

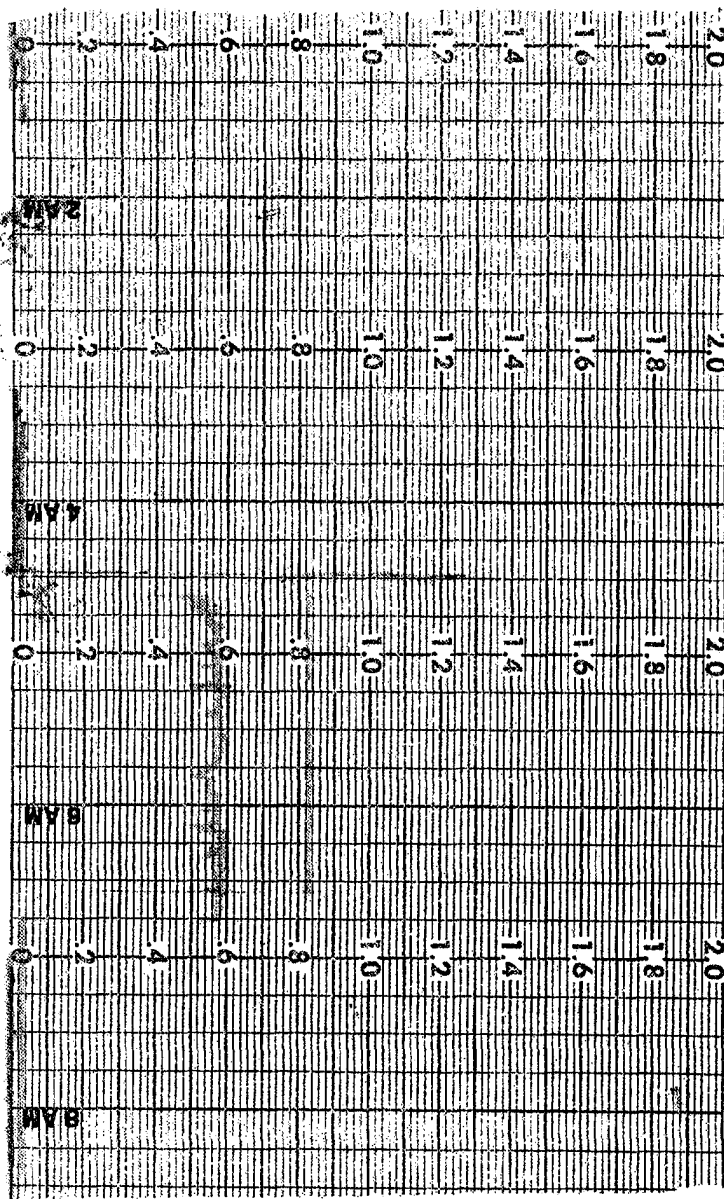
MENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	"KROLOR" - YELLOW MEDIUM			
03	1 Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED			
&	2 Weigh in drum & pour in	320	32-D	320
05	3 Dump in and stir 5 min			
1	Record: Start 11.30	48 x 50	YC-2-B	2400
	Fin 12.30			
	75" (1275 G)			
	4 Add to 70" (1200 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 40 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 DRAINING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
05	10 Run 10" (514G) water into SV & start agitator			
&	11 Pump V-205 thru Homog at 4800-5200 psi into V-205			
SV	Record: Time start 6:10AM Total Min 150			
2	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	13 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
&	14 Press SV Cam Reset PB-set 22TC in Auto Remote			
CP	(Temperature is set at 190-194F)			
3	15 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 48 % - preset #1 80 Gal		15-A	160
	b. 13LG % - 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-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. 8FC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f. 8FC20 (N-32-D Water) in Remote 0.83			
	g. 8FR10 (N-32-D/Water Ratio) 0.83			
SV	17 Operator Step PB			
SP	18 Record Level 2 LG 68 %. If below 35% follow solution make-up procedure for N-27-D			
&	19 Add to 48" (2470 G)			
CP	20 Record pH 10.8			
4	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)	20	1-D	10
	Siphon into SV. Record pH 11.3			
	22 Operator Step PB			

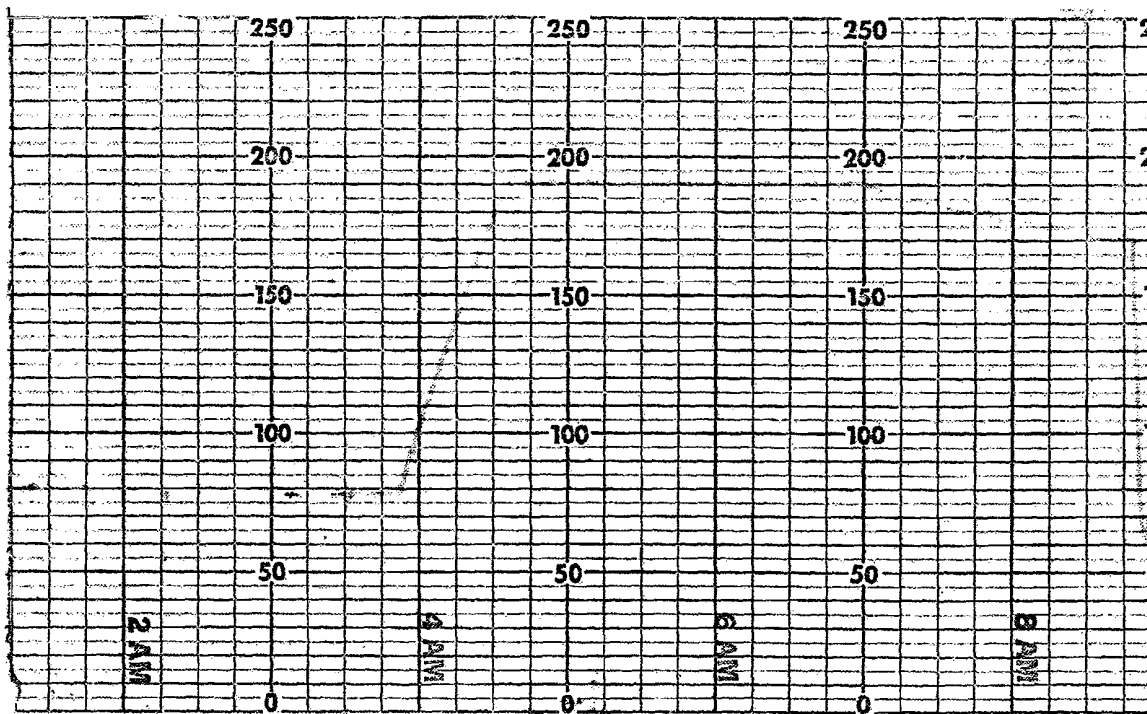
REV.

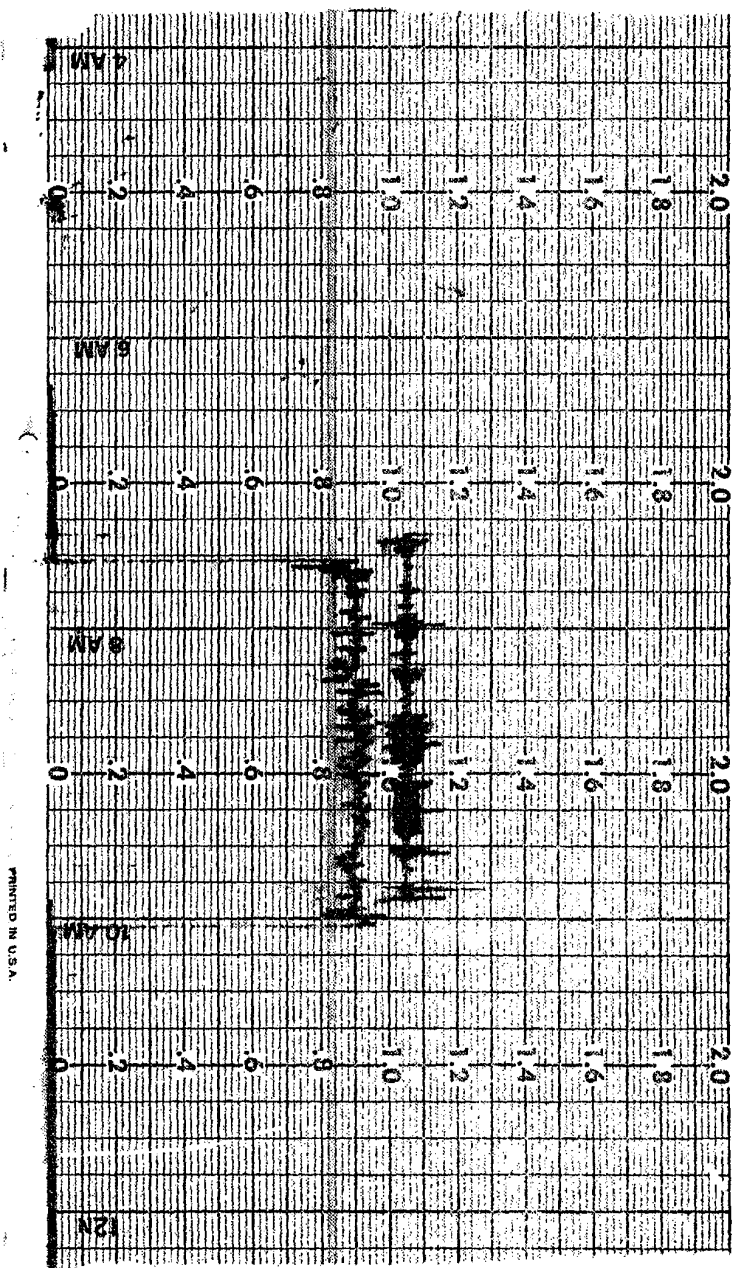
V-243

JIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE	N	ACCT
	2	03	KY-787-D	3490		LBS.	CODE	LBS.
SV	29	SP Step 06/39 - After heat up Record: pH <u>9.8</u> (9.5-10.0)						
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB <u>11:55A</u>						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
5	25	Switch 3FC10 to Auto. Operator Step PB						
	26	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20						
	26	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>9.6</u>	9.0-10.0	<u>12:25P</u>			
		14/47 (60 min)	<u>9.6</u>	9.0-10.0	<u>12:55</u>			
		15/48 (2 hrs)	<u>9.6</u>	9.0-10.0	<u>1:55</u>			
		16/49 (2 hrs 25 min)	<u>9.6</u>	9.0-10.0	<u>2:20</u>			
		17/50 (3 hrs Final)	<u>7.3</u>	7.5-8.5	<u>2:55P</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						
	31	Add to 49" (382 G) at 80 - 100°F					350	530-A 350
	32	Stir 5 min & record pH <u>9.9</u> (9.5-10.5)						
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol. <u>51</u> " & calculate <u>51</u> "(Vol) x 0.78 = <u>40.16</u>						
	35	Set preset #8 to <u>40.16</u> G from S 34						
302	26	Add 30" (360 G) water to V-302						
7	27	Add & stir 2 min For S 41 Assume 50%					160	7-D 80
243	28	SP Step 17/50 - After checking pH, Operator Step PB						
	29	SP Step 23/53 - Record: pH <u>3.8</u> (3.7-4.2)					100	128-A 100
SP	40	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
&	41	Record: pH <u>7.1</u> (9.0-9.5) & if necessary add pH 9.0-9.5						
CP	42	& Record: pH Assume 77%						27-D
8		(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>8.8</u> (9.0-10.0) Time <u>4:10 PM</u>						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time	SP Step	Time	SP Step			
		<u>11:00 PM</u>		<u>2:00 AM</u>		<u>409-381</u>		
		<u>7:00 A</u>		<u>3:00 P</u>		<u>126-201</u>		
		<u>3:00 PM</u>		<u>5:15 PM</u>		<u>320</u>		

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