(243) 244 (Automated) C.V. D.V.

CG 03 CODE KY-788-D PKG.

→ MAR 13 34864

EST. WGT. ~~960~~ 860 LBS.

STD. HRS. 8.8 TIME 3P M

14	YC-3-B	98	4	Lot 24405 ,	2.000 #
14	YC-3-B	98	4	Lot 24407 ,	600
14	YC-3-B	98	4	Lot ,	

PROCESSES		APPROVED B
( )KY-788-D	(J)	EWK 9/28/76
( )	( )	MTW 9/30/76
( )	( )	DCG 9/30/76
( )	( )	
TYPED BY		
NE 2-18-77		

O/R

HP

PUNCHED & CHECKED 1ST PASS

MAR 17 1980 # 3 2ND PASS

Total Wgt. ~~3560#~~ 3460

NON-BLEEDING

PMENT		NAME: 60" (5906) "KROLOR" YELLOW - LIGHT	USE LBS.	N CODE	ACC LBS.
203	1	Run ~~29" (360 G)~~ water into V-203. SET AGITATOR ON HIGH SPEED.			
&	2	Weigh in drum & pour in	345	32-D	345
205	3	Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
1		Record: Start 2.30 24405	2000		
		Fin 2.30 24407	600		
		75" (10756)	2.600		
	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 minimun water			
	7	Record: V-205 Vol 40 "& adj to 60" (2100 G)			
	8	Inspect homog. strainer & clean if necessary			
		DURING HOMOG, RUN V-323 AGITATOR ON LOW SPEED.			
205	9	Run 10" (514 G) water into V- #3 & startagitator			
&	10	Pump V-205 thru Homog at 4800-5200 psi into V- 242			
SV		Record: Time Start 1:45PM Total min 120			
2		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	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)			
CP	14	Record levels and set Raw Material Counter #1 as follows			
3		a. 11LG 30 % - preset #2 208 Gal		15-A	416
		b. 13LG 20 % - preset #6 135 Gal		20-A	135
	15	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. 3FR10 (N-27-D/Water)Ratio 0.8			
		d. 8FC10 (N-32-D Controller) in Manual 0.72 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. 8FR10 (N-32-D/Water)Ratio 1.1			
			N 27530		
20	16	Operator Step PB			
43	17	Record Level 21G 64 %. If below 35% follow solution make-up procedure for N-27-D			
SP	18	Adj SV to 47" (2400 G)			
	19	Record pH 10.1 . 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 11.1	10	7-D 721	10
	20	Operator Step PB			

FM

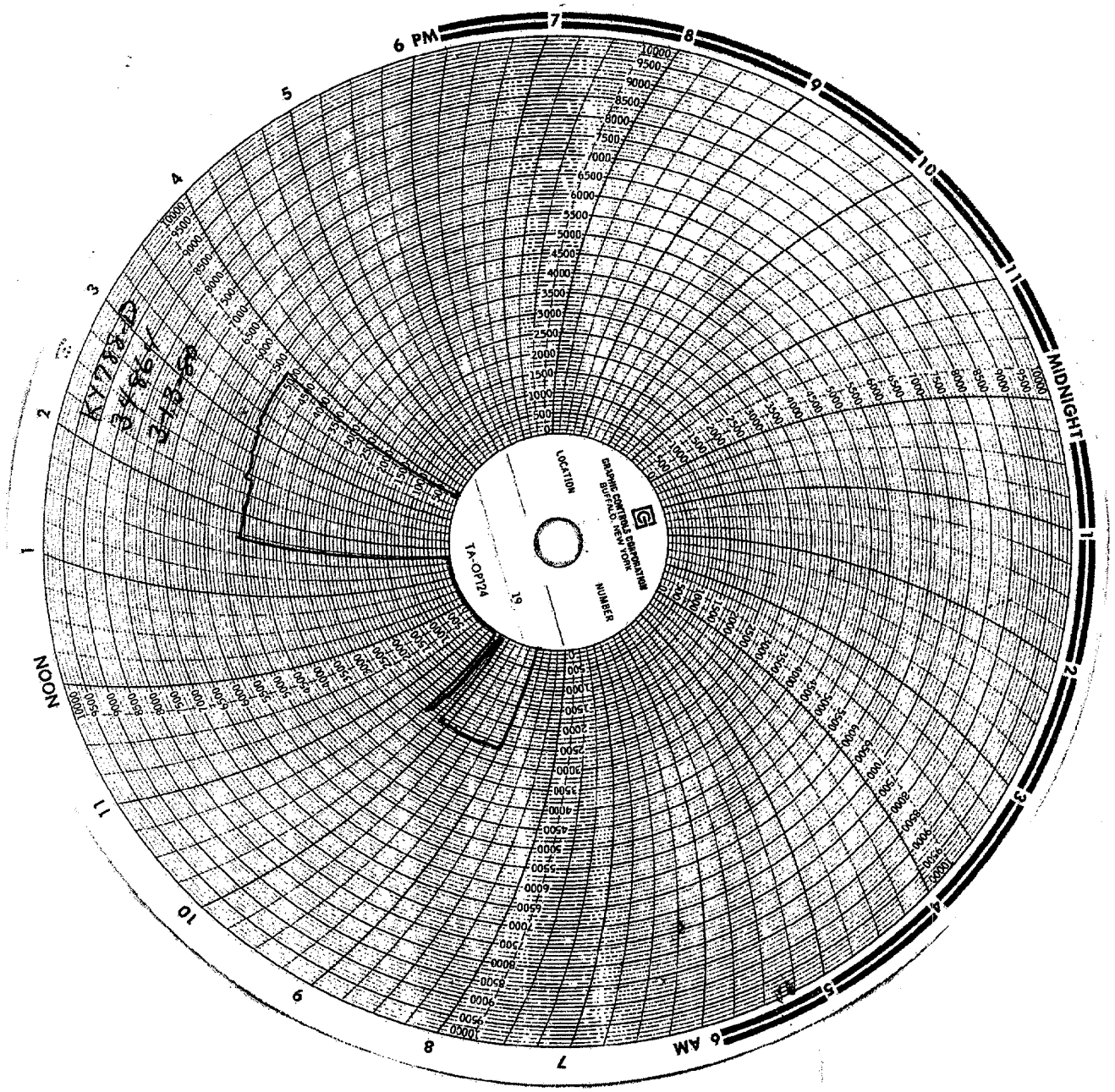
C.V.

V-243

ENT		PAGE 2 CG 03 CODE KY-788-D EST. WGT. 3560 LBS.	USE LBS.	N CODE	ACC LBS
	21	SP Step 06/39 - After heat up Record: pH 9.5 (9.5-10.0) 7:35P			
	22	Switch 3FC20, 8FC10, 8FC20 to Auto			
	23	Operator Step PB			
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits. Swich 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			
		13/46 (30 min) 9.0 9.3-10.0 8:05	N-27	Stopped	
		14/47 (60 min) 9.4 9.3-10.0 8:35	Fill	± 10 min	
		15/48 (2 hrs) 9.4 9.3-10.0 9:35			
		16/49 (2 hrs 25 min) 9.0 9.3-10.0 10:00			
		17/50 (Final 3 hrs) 8.8 7.5-8.5 10135			
		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	
	28	While striking run 30" (234 G) water into V-339			
	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 9.8 (9.5-10.5)			
	32	Stir 15 min or longer to dissolve for SP Step 26/56			
	33	Record Vol 52" & Calculate 52" (Vol X 0.78= 40.6 G)			
	34	Set preset #8 to 40.6G from S 33			
	35	Run 40" (440 G) water into V-302			
	36	Add & stir 2 min for S 40 Assume 50%	360	7-D	180
	37	SP Step 17/50 After checking pH. Operator Step PB			
	38	~~Sift in 2 bags~~	~~100~~	~~128-A~~	~~100~~
	39	SP Step 23/53 Record: pH 3.0 (3.7-4.2			
	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min			
	41	Record: pH 9.0 (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 9.0 (9.0-10.0) Time 12:00 AM			
	44	Operator Step PB			
	45	SP Step 60 - Batch complete			
		PUMP TO V-240			

Start Time	SP Step	Finish Time	SP Step	Optr
7:00AM		3:00PM		409
2:00P		11:00P		126
11:00 PM		12:15 AM		237

DUP050094669



[redacted]

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