

CG 03 CODE KY-788-D

PKG

PUNCHED & CHECKED

MAR 14 34875

EST. WGT. 960 860 LBS.

MAR 19 1980

OK

STD. MRS. 8.8 TIME

14 YC-3-B 98 4 Lot 24406, 2400 STP
 14 YC-3-B 98 4 Lot _____
 14 YC-3-B 98 4 Lot _____

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

Homog #3 - 1st Pass

Total Wgt. 3560# 3460

NON-BLEEDING

AGENT	NAME	USE LBS.	N CODE	ACC LBS.
60	"KROLOR" YELLOW - LIGHT			
03	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED			
05	2 Weigh in drum & pour in	345	32-D	345
1	3 Dump in & stir 5 min Lot 24406	52 x 50	YC-3-B	2600
	Record: Start 12:30 p			
	Fin 1:10 p			
	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 44 "& adj to 60" (2100 G)			
	8 Inspect homog. strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
05	9 Run 10" (514 G) water into V-244 & start agitator			
02	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
2	Record: Time Start 3:35 p Total min 12.5			
	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			
P	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)			
P	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11G 55% - preset #2 208 Gal		15-A	416
	b. 13G 68% - preset #6 135 Gal		20-A	135
	15 Set strike flow controllers as follows:			
	a. 3FE10 (N-27-D Controller) in Manual 0.54 GPM		27-D	180
	b. 3FE20 (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 0.22 GPM	0.24	32-D	1215
	e. 8FC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 8FE20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water) Ratio 1.1			
	16 Operator Step PB			
	17 Record Level 21G 95%. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.7. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
	Siphon into SV & Record: pH 11.3			
	Operator Step PB			

V-244

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 <u>9.8</u> (9.5-10.0)					
	22 Switch 3FC20, 8FC10, 8FC20 to Auto					
	23 Operator Step PB					
	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: <u>7:35 PM</u>					
	SP Step					
	V-243/V-244	pH	Range	Time		
	13/46 (30 min)	<u>9.6</u>	9.3-10.0	<u>8:05 PM</u>		
	14/47 (60 min)	<u>9.3</u>	9.3-10.0	<u>8:35 PM</u>		
	15/48 (2 hrs)	<u>9.3</u>	9.3-10.0	<u>9:35 PM</u>		
	16/49 (2 hrs 25 min)	<u>9.3</u>	9.3-10.0	<u>10:00 PM</u>		
	17/50 (Final 3 hrs)	<u>10.5</u>	7.5-8.5	<u>10:35 PM</u>		
	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 <u>10.2</u> (9.5-10.5)					
	32 Stir 15 min or longer to dissolve for SP Step 26/56					
	33 Record Vol <u>53</u> " & Calculate <u>53</u> " (Vol X 0.78 = <u>41.3</u> G)					
	34 Set preset #8 to <u>41.3</u> G from S 33					
2	35 Run 40" (440 G) water into V-302					
	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
3	39 SP Step 23/53 Record: pH <u>3.1</u> (3.7-4.2)					
	40 Run in N-7-D from S 36 in 10-12 min & stir 5 min					
	41 Record: pH <u>9.0</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>9.0</u> (9.0-10.0) Time <u>12:30 PM</u>					
	44 Operator Step PB					
	45 SP Step 60 - Batch complete					
	Start	Finish	Optr			
	Time SP Step	Time SP Step				
	<u>1:00 PM</u>	<u>3:00 PM</u>	<u>235</u>			
	<u>3:00 PM</u>	<u>11:00 PM</u>	<u>201</u>			
	<u>11:00 PM</u>	<u>12:30 PM</u>	<u>320</u>			

NOTE
IF PH
DROPS
INCREASE
SILICONE
SETTING
IN 102
THERMIST







