

EST. WGT. 4080 3747 LBS.

PUNCHED & CHECKED

STD. HRS.

TIME

APR 25 1980

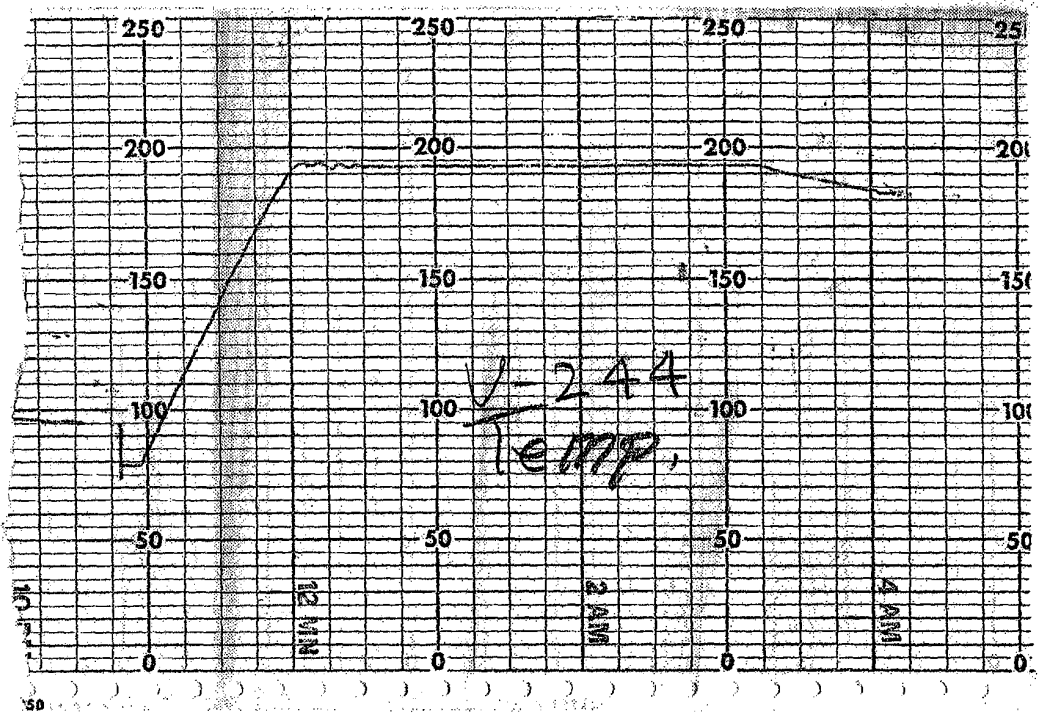
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TYPED BY		
JTC 11-28-77		

Homog #3 - 2nd Pass

NON-BLEEDING

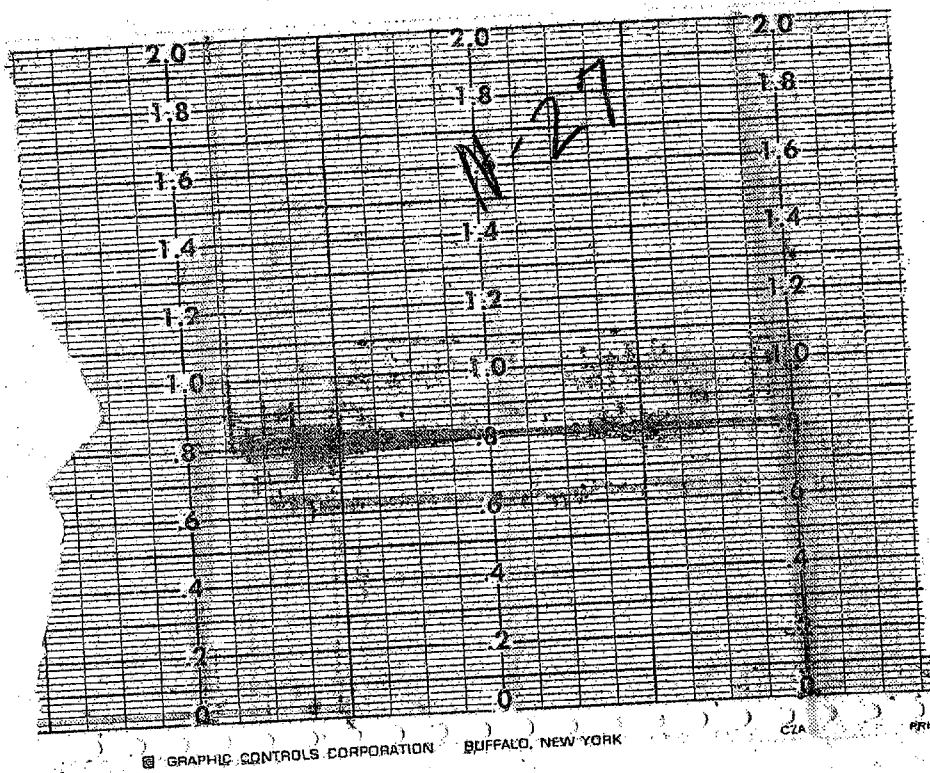
EQUIPMENT	NAME: KROLO® YELLOW + PRIMROSE	USE LBS.	N CODE	ACCT LBS.
203 & 205	1 Run 27" (435 G) water into V-203. RUN AGITATOR ON HIGH SPEED			
1	2 Pour in	415 475	32-D	415 475
	3 Dump in	LOT 59 62 x 50	104-B	2100
	Record: Start 4:30 AM	9148		
	Fin 6:20 AM	9648		2950
	75" (12256) 2400-2600	9966		
	4 Adj to 70" (1195 G) & Record: pH 9.1 (7.0-9.0)	350		
	5 Pump V-203 thru Homog at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Proceed to S's 7, 8, 9, & 10 ASAP			
	7 Record: V-205 Vol 40 " & adj to 55" (2016 G)			
	8 Inspect Homog, strainer, & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205 & SV	9 Run 12" (617 G) water into V-205 & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into V-204			
	Record: Time Start 1:17 Total Min 2:00			
	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 & CP	12 SP Step 01 - Set Formula Selector to position #4 (V-243) or #9 (V-244)			
3	13 Press SV Cam Reset PB - set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
	14 Record levels and set Raw Material Counter #1 as follows:			110
	1 LG 67% - preset #3 56.59 Gal		15-A	118
	15 Set strike flow controller as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.80-0.94 GPM		27-D	333.35
	b. 3FC20 (N-27-D Water) in Manual Local 7.20-7.49 GPM			
	c. 3FR10 (N-27-D/Water) Ratio 0.9			
	d. 8FC10 (N-32-D Controller) in Manual 1.03-1.19 GPM		32-D	2975
	e. 8FC20 (N-32-D Water) in Manual Local 5.676-20 GPM			2175
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water) Ratio 1.1			
SV & CP	16 Operator Step PB			
4	17 Record level 2LG 51%. If below 35%, follow solution, make-up procedure for N-27-D			
	18 Adj SV to 63" (3238 G) & Record: pH 8.0 (7.0-9.0)			
	19 Operator Step PB			

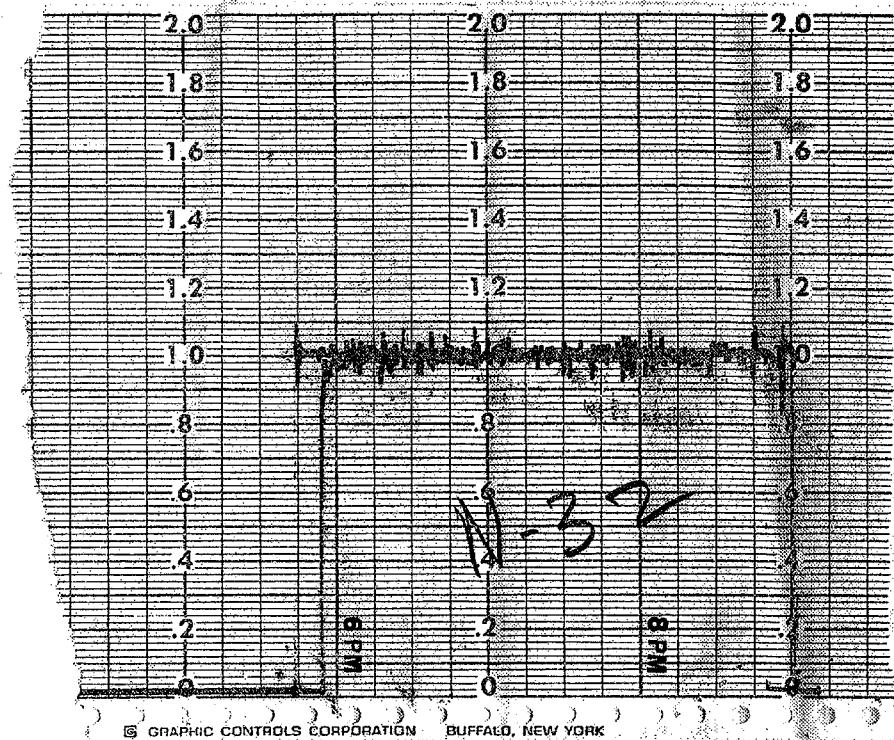
U/PMENT	PAGE 2 CG 03 CODE KY-790-D (C)	EST. WGT. 4088	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	20 SP Step 06/39 after heat up. Record: pH	7.7	(9.0-9.5)			
SP	21 Adj pH to (9.0-9.5) (up only)		Assume 50%	22	7-D	11
&	Dilute to 5% (10 parts water to 1 part N-7-D)					
CP	Siphon into SV. Record: pH	9.75				
4	22 Switch 3FC20, 8FC20 to Auto					
ont'd)	23 Operator Step PB					
	24 SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flow in limits.					
	switch 3FC10 to Auto. Operator Step PB					
	25 SP Step 11/44 - When 3FC10, 3FC20, flow in limits. switch					
	3FC20 to Remote. Operator Step PB					
	26 During strike, record pH & time as follows:					
	SP Step					
	V-243/V-244	pH	Range	Time		
	13/46 (30 min)	9.65	9.0-9.8	5:35		
	14/47 (60 min)	9.65	9.0-9.8	6:05		
	15/48 (2 hrs)	9.65	9.0-9.8	7:05		
	16/49 (3 hrs)	9.65	9.0-9.8	8:05		
	17/50 (Final)	7.6	7.5-8.5	8:50		
	Note: If pH not as specified, notify Supervisor & note in					
	log. If final pH is above 8.5, adj to pH 7.5-8.5 &					
	Record: pH		Assume 78%		27-D	
	27 SP Step 17/50 after checking pH. Operator PB					
	28 Sift in 3 bags			150	128-A	150
	29 SP Step 23/53 Record: pH	4.0	(3.3-3.7)			
	30 If necessary, adj pH to 3.3-3.7 (DOWN ONLY) Record: pH	3.7		35	15-A	35
	NOTE: Dissolve extra N-15-A in water at 110-120°F in drum.					
	Use ±30 gal of water to 80# N-15-A. Stir SV 5 min					
	after each addition.					
	31 Adj pH to (4.0-4.4) with dilute N-7-D (10 parts water to 1					
	part N-7-D)					
	Siphon N-7-D into SV & Record: pH	4.05	Assume 50%	20	7-D	10
	32 Operator Step PB					
	33 SP Step 60 - Batch Complete					
	START	FIN	OPTR			
	TIME	SP STEP	TIME	SP STEP		
	10:00 A.M.		3:00 P.M.	54-60		
	3:00 P.		9:20 P.M.	235-320		

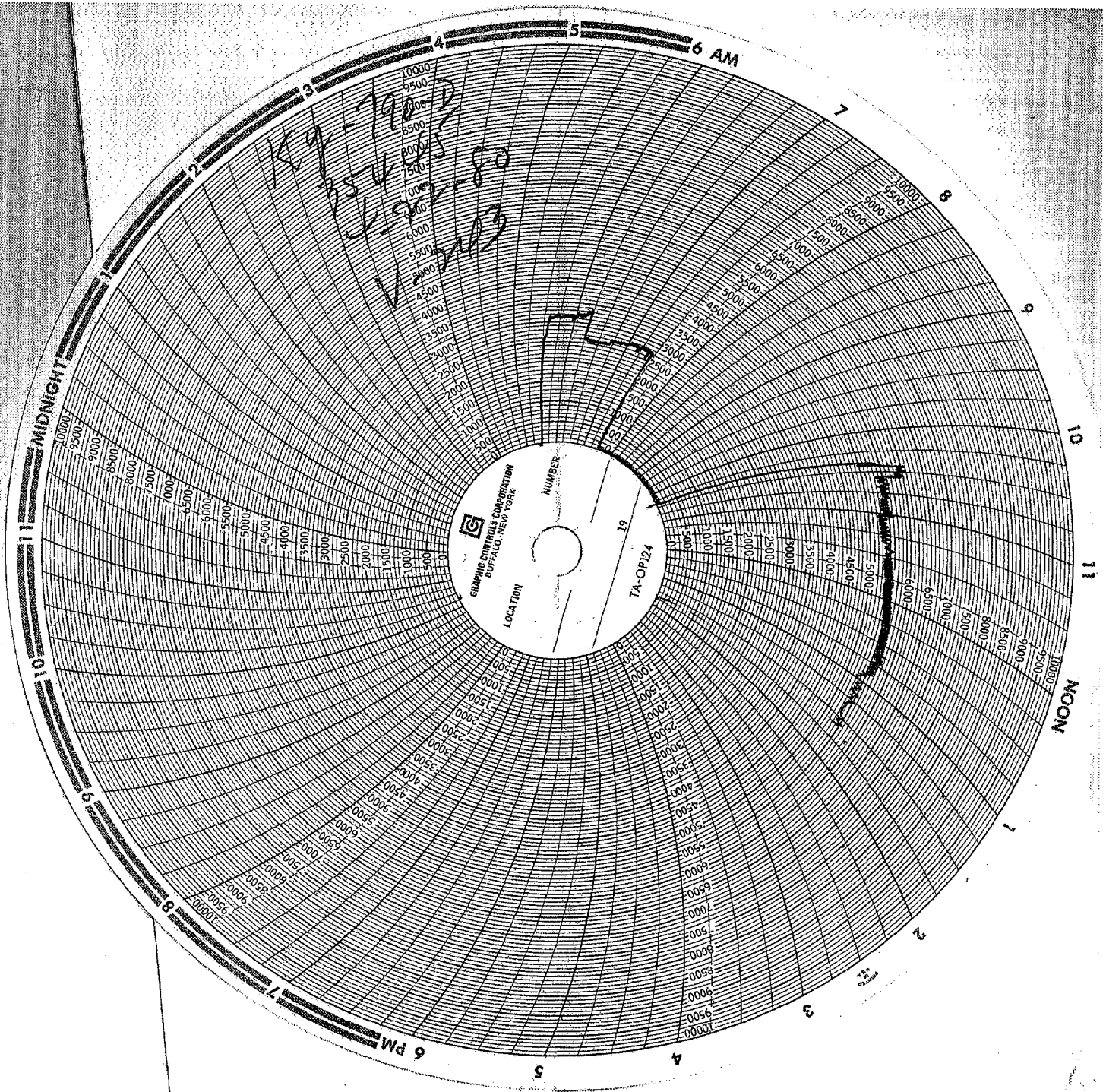


N32301.01

DUP050457481







N32301.02

DUP050457484

V-244