

MAR 24 1980

APR 1 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244 (Automated) C.V.

D.V.

CG 03 CODE KY-907-D PKG.

MAK 30 35101

EST. WGT. 1080 LBS.

STD. HRS. TIME 7 A M

14 YC-2-B 93 4 Lot 24462 460 #
 14 YC-2-B 93 4 Lot 24463 2000 #
 14 YC-2-B 93 4 Lot #

PROCESSES		APPROVED BY	
() KY-907-D	(D)	EWK	12/12/77
()	()	DCG	12/13/77
()	()	MW	12/15/77
()	()		
TYPED BY			
RJ 2/3/78			

Homog #3 - 1ST Pass

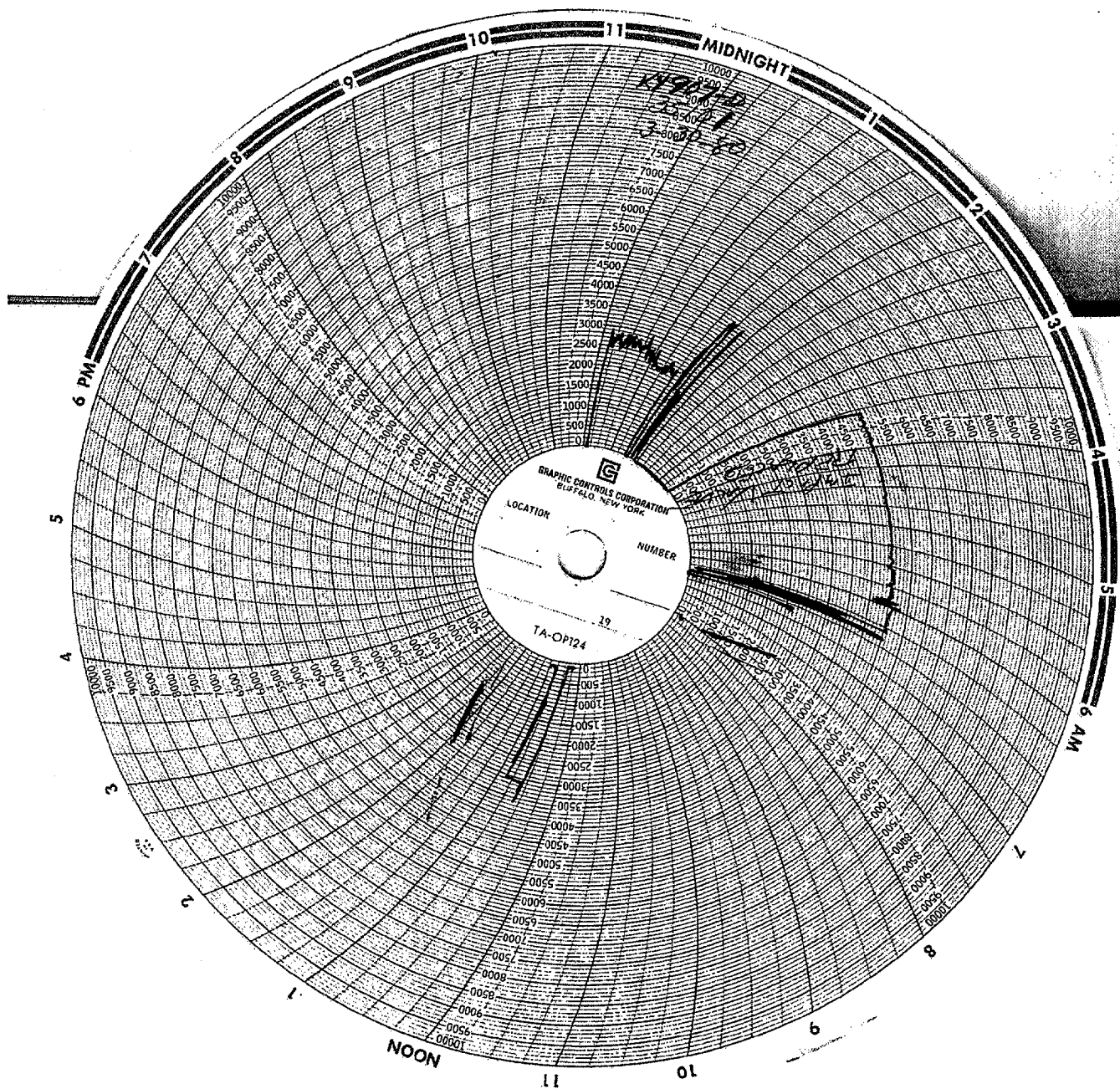
Total Weight - 3480#

NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	60" (1905) KROLOR® YELLOW MEDIUM			
203 & 22053	1 Run 33" (560 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
1	2 Pour in	320	32-D	320
	3 Dump in	48 x 50	YC-2-B	2400
	Record: Start 8 AM	24462		
	Fin 9 AM	24463		
	75" (1275 G)	2000		
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 263			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water 263			
	7 Record V-205 Vol 43 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
21053	9 Run 10" (514 G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
2	Record: Time Start 3:30 AM Total Min 160			
	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 #2 (V-243) or #7 (V-244)			
3	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194°F)			
	14 Record levels and set Raw Materials Counter #1 as follows: 111.8 48 % - preset #1 80 Gal		15-A	160
	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. 3FC20 (N-27-D/Water Ratio) 0.64			
	d. 8EC10 (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			
	g. 8ER10 (N-32-D/Water Ratio) 0.83			
SV	16 Operator Step PB			
SP & CP	17 Record Level 2 LG 86 %. If below 35% follow solution make-up procedure for N-27-D			
4	18 Adj to 48" (2470 G)			
	19 Record: pH 10.5			
	20 Adj to 11.1-11.3 using N-7-D diluted to 5% Assume 50%	24	7-D	12
	(10 parts water to 1 part N-7-D)			
	Siphon into SV Record: pH 11.2			
	21 Operator Step PB			

V-243

EQUIPMENT	PAGE 2 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV SP & CP 5	22 SP Step 06/39 - After heat up Record: pH <u>9.7</u> (9.5-10.0)			
	23 Switch 3FC20, 8FC10, 8FC20 to Auto			
	24 Operator Step PB			
	25 SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits			
	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>9.7</u> 9.0-10.0 <u>9:15 AM</u>			
	14/47 (60 min) <u>9.7</u> 9.0-10.0 <u>9:35 AM</u>			
	15/48 (2 hrs) <u>9.7</u> 9.0-10.0 <u>10:35 AM</u>			
302 6	16/49 (2 hrs 25 min) <u>9.7</u> 9.0-10.0 <u>11:00 AM</u>			
	17/50 (3 hrs Final) <u>7.7</u> 7.5-8.5 <u>11:35 AM</u>			
	NOTE: (1) If pH not as specified notify Supervisor & note			
	in log (2) If final pH is above 8.5, adj pH to 7.5-8.5 &			
	Record: pH Assume 78%			
	29 Sift in	50	27-D 128-A	50
	30 Add 17" (208 G) water to V-302			
	31 Add & stir 2 min for S58 Assume 50%	100	7-D	50
	32 During strike pump into PT	318	169-A	318
	33 Pump in	36	155-A	36
	34 Pump in	36	160-A	36
	35 Stir 10 min with lightning mixer for S39			
	36 During strike run 20" (244 G) water into V-356			
	37 Turn on steam			
PT 7	38 Add to 26" (317 G) at 178-182°F <u>81-82°C</u>			
	39 Pump PT mixture from S35 thru undersurface			
	Distributor AFAP			
	40 Rinse PT with hot water from hot water mixer & pump in			
	41 Shut off pump			
	42 Stir 30 min at 178-182°F for S49 <u>81-82°C</u>			
	43 Do not shut off agitator			
	44 When S29 complete, heat SV to 198-200°F in 5-10 min			
	45 Close water line & discharge valves at stearate pump			
	46 Open V-356 Discharge valves to stearate pump inlet			
	47 Open water valve at stearate pump & run water thru			
	Homog at 2900-3100 psi to sewer			
	48 While Homog water at 2900-3100 psi, open Homog			
	Discharge valve to SV & close valve to sewer			
356 8	49 Immediately open stearate pump discharge valve.			
	Turn on pump & Homog V-356 to SV at 2900-3100 psi			
	Maintain SV at 198-200°F			
	50 While Homog V-356 to SV, shut off water valve at			
	Stearate pump ASAP			
	51 When Homog complete, rinse in V-356 with hot water			
	From hot water mixer			
SV & SP 9				



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