

CG 03 CODE KY-787-D

FEB 1976

34143

EST. WGT. 1090

LBS.

STD. MRS. 8.9

TIME 7:15 AM

14 - YC-2-B 98 4

Lot 24464 2400 #

Lot

Lot

Total Wgt. - 3490# (REQ 3202)

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

OK

HP 200 PASS # 3 HOMO

NON-BLEEDING

ITEM	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" "KROLOR" - YELLOW MEDIUM			
205	1 Run 10" (992 G) water into V-203			
1	2 Weigh in drum & pour in	320	32-D	320
263	3 Pump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 7:45 Am			
	Fin 8:30 Am			
	75" (2756)			
	Adj to 70" (1200 G)			
	8 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	9 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water			
	10 Record V-203 Vol 45" & adj to 60" (2100 G)			
	11 Inspect Homog strainer & clean if necessary			
205	12 Run 10" (514G) water into SV & start agitator			
203	13 Pump V-203 thru Homog at 4800-5200 psi into V-205			
2	Record: Time start 9:15 AM Total Min 10			
	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
	14 When V-203 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
SP	15 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
&	16 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
CP	17 Record levels and set Raw Materials Counter #1 as follows:			
3	a. 11LG 42% - preset #1 80 Gal		15-A	160
	b. 13LG 40% - preset #6 135 Gal		20-A	135
	18 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			
	g. 8FR10 (N-32-D/Water Ratio) 0.83			
SV	19 Operator Step PB			
SP	20 Record Level 2 LG 42%. If below 35% follow solution make-up procedure for N-27-D			
&	21 Adj to 48" (2470 G)			
CP	22 Record pH 10.2			
4	23 Adj to 11.1 - 11.3 using N-7-D diluted to 5% Assume 50% (10 parts water to 1 part N-7-D)			
	Siphon into SV. Record pH 11.3			
	24 Operator Step PB			

30 T-D 15

V-243

IPMENT	PAGE 2 CG 03 CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACC LBS
SV	24 SP Step 06/39 - After heat up Record: pH <u>9.7</u> (9.5-10.0)					
SP	25 Switch 3FC20, 8FC10, 8FC20 to Auto					
8	26 Operator Step PB					
CP	27 SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits					
5	Switch 3FC10 to Auto. Operator Step PB					
	28 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: <u>3:00 P</u>					
	SP STEP					
	V-243/V-244 pH Range Time					
	13/46 (30 min) <u>9.6</u> 9.0-10.0 <u>3:30 P</u>					
	14/47 (60 min) <u>9.6</u> 9.0-10.0 <u>4:00 P</u>					
	15/48 (2 hrs) <u>9.6</u> 9.0-10.0 <u>5:00 P</u>					
	16/49 (2 hrs 25 min) <u>9.6</u> 9.0-10.0 <u>5:25 P</u>					
	17/50 (3 hrs Final) <u>8.5</u> 7.5-8.5 <u>6:00 P</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	
39	29 While striking, run 30" (234 G) water into V-339					
6	30 Add in 7-8 min			350	530-A	350
	31 Add to 49" (382 G) at 80 1000F					
	32 Stir 5 min & record pH <u>10.2</u> (9.5-10.5)					
	33 Still 5 min or longer to dissolve for SP Step 26					
	34 Record Vol <u>52</u> & calculate <u>52</u> (Vol) x 0.78 = <u>40.6 G</u>					
	35 Set preset #8 to <u>40.6 G</u> from S 34					
02	36 Add 30" (360 G) water to V-302					
7	37 Add & stir 2 min For S 41 Assume 50%			160	7-D	80
13	38 SP Step 17/50 - After checking pH, Oper Step PB					
	39 SIFT in 2 Bags			100	128-A	100
SP	40 SP Step 23/53 - Record: pH <u>3.7</u> (3.1-4.2)					
&	41 Run in N-7-D from S 37 in 10-12 min & stir 5 min					
CP	42 Record: pH <u>9.2</u> (9.0-9.5) & if necessary add pH 9.0-9.5					
8	& Record: pH <u>9.4</u> Assume 77%				27-D	
	(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>9.4</u> (9.0-10.0) Time <u>7:00 P.M.</u>					
	45 Operator Step PB					
	46 SP Step 60 - Batch complete					
	Start Finish Optr					
	Time SP Step Time SP Step					
	<u>3:00 P</u> <u>11:00 AM</u>			<u>229-323</u>		
	<u>11:00 AM</u> <u>7:00 AM</u>			<u>438-407</u>		
	<u>7:00 P</u> <u>3:00 P</u>			<u>27-201</u>		
	<u>3:00 P</u> <u>7:00 P.M.</u>			<u>54-259</u>		



