

S.V. 243 Automated

JUN 20 1980

MAKING INSTRUCTIONS: BATCH UNIT

CG 03 CODE KY-781-D

PKG

PUNCHED & CHECKED

D.V.

PROCESSES

KY-781-D (M)

APPROVED BY

FWP 101378

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AMJ 101378

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TYPED BY

GWW101378

EST. WGT. 1128 LBS.

STD. HRS. TIME

14 YC-3-B 93 4 23880 3300 #

14 YC-3-B 93 4 #

14 YC-3-B 93 4 #

Total Wgt. 4428# (Req

Homog #4 - 2nd Pass

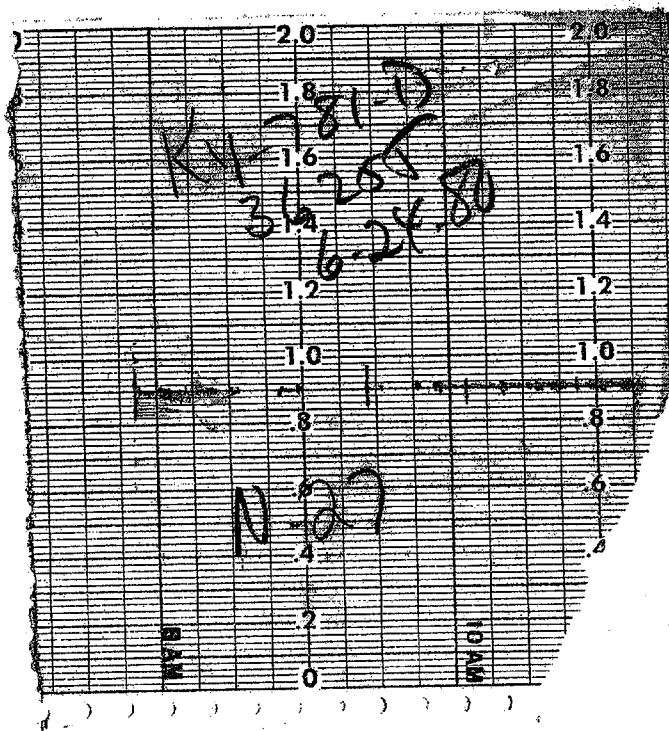
NON-BLEEDING

CLEAN UP
AS YOU GO ALONG

EQUIPMENT	NAME:	KROLOR® YELLOW LIGHT	USE LBS.	N CODE	ACCT. LBS.
203	1	Run 60" (992 G) water in V-203 & add	Assume 50%	36	7-D 18
&	2	Weigh in drum & pour in		442	32-D 442
205	3	Dump in & stir 5 min	ES Lot	66x50	YC-3-B 3300
1		Record: Start 2:30 AM	23880	3300	
		Fin 4:50 AM			
		TS (12756)			
	4	Adj to 80" (1360 G) & Record: pH 10.6 (10.5-11.5)			
	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			
	7	Record: V-205 Vol 40 " & adj to 45" (1662 G)			
	8	Inspect Homog strainer & clean if necessary			
		DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED			
205	9	Run 12" (200 G) water into SV & start agitator			
&	10	Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV		Record: Time Start 5:00 PM Total Min 95			
2		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	12	SP Step 01 - Set Formula Selector to position #1 (V-243) or			
&		#6 (V-244)			
CP	13	Press SV Cam Reset PB-Set 22TC in Auto Remote			
3		(Temperature is set at 190-194°F)			
	14	Record levels and set Raw Material Counter #1 as follows:			
		a) 11LG 54 % - preset #3 187 Gal		15-A	374
	15	Set strike flow controllers as follows:			
		3FC10 (N-27-D Controller) in Manual 0.9 GPM		27-D	373
		3FC20 (N-27-D Water) in Manual Local 6.3 GPM			
		3FR10 (N-27-D / Water Ratio) 0.7			
		8FC10 (N-32-D Controller) in Manual 1.20 GPM		32-D	2527
		8FC20 (N-32-D Water) in Manual Local 5.4 GPM			
		8FC20 (N-32-D Water) in Remote			
		8FR10 (N-32-D / Water Ratio) 0.9			
SV	16	Operator Step PB			
SP	17	Record Level 2LG 69 %. If below 35% follow solution			
&		make-up procedure for N-27-D			
CP	18	Adj SV to 54" (2800 G)			
4	19	Record: pH 10.2			
	20	Adj pH to 11.4-11.6 using Assume 50%	20	7-D	10
		(Dilute to 5% (10 parts water to 1 part N-7-D)			
		Siphon into SV. Record: pH 11.4			
	21	Operator Step PB			

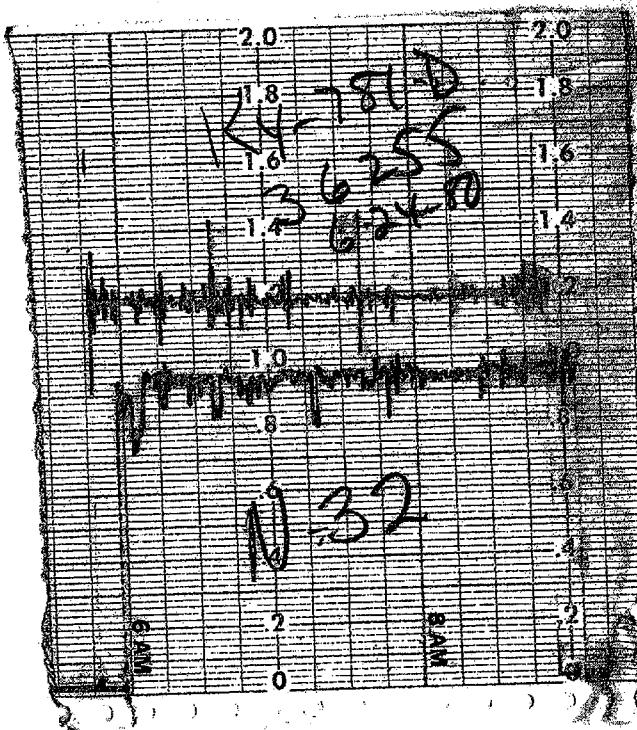
V-243

EQUIPMENT	PAGE 2	CG 03	CODE	KY-781-D	N EST. WGT.	1128 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	28	SP Step 06/39.	After heat up Record:	pH 10.0 (9.6-10.2)					
SP	29	Switch 3FC20, 8FC10, 8FC20, to Auto							
&		Operator Step PB							
CP	5	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flow in limits							
		switch 3FC10 to Auto. Operator Step PB							
	28	SP Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20							
		to Remote. Operator Step PB							
	27	During Strike, Record pH & Time as follows:							
		SP Step	pH	Range	Time	8:40 PM			
		13/41 (30 min)	9.8	9.3-10.0	9:10 PM				
		14/47 (60 min)	9.25	9.3-10.0	9:40				
		(2 hrs)	9.8	9.3-10.0	10:40				
		(3 hrs)	9.8	9.3-10.0	11:40				
		17.50 (Final)	7.5	7.5-8.5	12:25 AM				
		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							
			M			%		27-D	
V-302	28	Add 31" (379 G) water to V-302							
6	29	Add & stir 5 min			Assume 50%		124	7-D	62
SV	30	SP Step 17/50 after checking pH. Operator PB							
SP	31	SP Step 23/53 Record: pH 3.6 (3.3-3.7)							
&	32	If necessary adj pH (DOWN ONLY) Record: pH						15-A	
CP		NOTE: Dissolve extra N-15-A in water at 110-120°F in drum							
	7	Use ±30 Gal of water to 50# N-15-A. Stir SV 5 min							
		after each addition							
	33	Sift in					150	128-A	150
	34	Run in N-7-D from S 29 & stir 5 min							
	35	Record: pH 4.6 (4.2-4.4)							
	36	If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts							
		H ₂ O to 1 part N-7-D) or N-27							
					M		%	27-D	
								7-D	
		Station (if N-7-D) into SV. Record: pH							
	37	Operator Step PB							
	38	SP Step 24/54 - Add N-978-A & stir 15 min					20	978-A	20
	39	Operator Step PB							
	40	SP Step 60 - Batch Complete							
		START		FIN		OPTR			
		TIME	SP STEP	TIME	SP STEP				
		7 AM		8 PM		120.54			
		13:00 P		11:00 P		235-237			
		11:00 PM		1:15 AM		381-223			
		PUMPED TO JAT 240							



N32232.01

DUP050457195



V-243