MAKING INSTRUCTIONS: BATCH UNIT

S.V. ~~243~~ 244 Automated C.V. PUNCHED & CHECKED

CG 03 CODE KY-907-D PKG.

APR 8 35204 4/8 APR 10 1980

EST. WGT. 1080 LBS.

STD. HRS. TIME 7A M

| 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 | | |

14 YC-2-B 93 4 Lot 24778, 2400 #
14 YC-2-B 93 4 Lot _____, _____ #
14 YC-2-B 93 4 Lot _____, _____ #

Homog #4 - 1st Pass
" #3 - 2nd "

V - 244 'M'T' 1.50/AM

Total Weight - 3480#

NON-BLEEDING

APR 9 1980

| EQUIPMENT | | NAME: (990G) 60" KROLOR® YELLOW MEDIUM | USE LBS. | N CODE | ACCT. LBS. |
|---|---|---|---|---|---|
| 203 & 205 1 | 1 | Run ~~33" (560 G)~~ water into V-203 SET AGITATOR ON HIGH SPEED | | | |
| | 2 | Pour in | 320 | 32-D | 320 |
| | 3 | Dump in Lot | 48 x 50 | YC-2-B | 2400 |
| | | Record: Start 9:[illegible] | | | |
| | | Fin 10:[illegible] 24778 | 2400 | | |
| | | 75" (1275G) | | | |
| | 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, wash color thru Homog at 1800-2200 psi using minimum water | | | |
| | 7 | Record V-205 Vol 43" & adj to 60" (2100 G) | | | |
| | 8 | Inspect Homog strainer & clean if necessary | | | |
| | | DURING HOMOG, SET V-203 AGITATOR ON LOW SPEED. | | | |
| 205 & SV 2 | 9 | Run 10" (514 G) water into SV & start agitator | | | |
| | 10 | Pump V-205 thru Homog at 4800-5200 psi into V- 244 | | | |
| | | Record: Time Start 2:00 AM Total Min 180 | | | |
| | | 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 3 | 12 | SP Step 01 - ~~Set Formula~~ Selector to position #2 (V-243) or #7 (V-244) | | | |
| | 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: | | | |
| | | 11LG 42 % - 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. 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 SP & CP 4 | 16 | Operator Step PB | | | |
| | 17 | Record Level 2 LG 89%. If below 35% follow solution make-up procedure for N-27-D | | | |
| | 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% (10 parts water to 1 part N-7-D) | 18 | 7-D | 9 |
| | | Siphon into SV Record: pH 11.3 | | | |
| | 21 | Operator Step PB | | | |

K 13829 REV.

N32460

V-244

| EQUIPMENT | | PAGE 2 OF 03 CODE KY-907-0 (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 10.0 (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) 9.7 9.0-10.0 2:30 A.M | | | |
| | | 14/47 (60 min) 9.3 9.0-10.0 8:00 P.M | | | |
| | | 15/48 ( 2 hrs) 9.8 9.0-10.0 9:00 P.M | | | |
| | | 16/49 ( 2 hrs 25 min) 7.8 9.0-10.0 9:25 P.M | | | |
| | | 17/50 ( 3 hrs Final) 8.3 7.5-8.5 10:00 P.M | | | |
| | | 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 | | | |
| | 29 | Sift in Assume 78% | 50 | 27-D<br>128-A | 50 |
| 302 6 | 30 | Add 17" (208 G) water to V-302 | | | |
| | 31 | Add & stir 2 min for S58 Assume 50% | 100 | 7-D | 50 |
| PT 7 | 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 | | | |
| 356 8 | 36 | During strike run 26" (244 G) water into V-356 14" | | | |
| | 37 | Turn on steam | | | |
| | 38 | Adj to 26" (317 G) at ~~170-180°F~~ 81-82°C | | | |
| | 39 | Pump PT mixture from S35 thru undersurface Distributor ASAP | | | |
| | 40 | Rinse PT with hot water from hot water mixer & pump in | | | |
| | 41 | Shut off pump 81-82°C | | | |
| | 42 | Stir 30 min at ~~170-180°F~~ for S49 | | | |
| | 43 | Do not shut off agitator | | | |
| SV & SP 9 | 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 | | | |
| | 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 | | | |

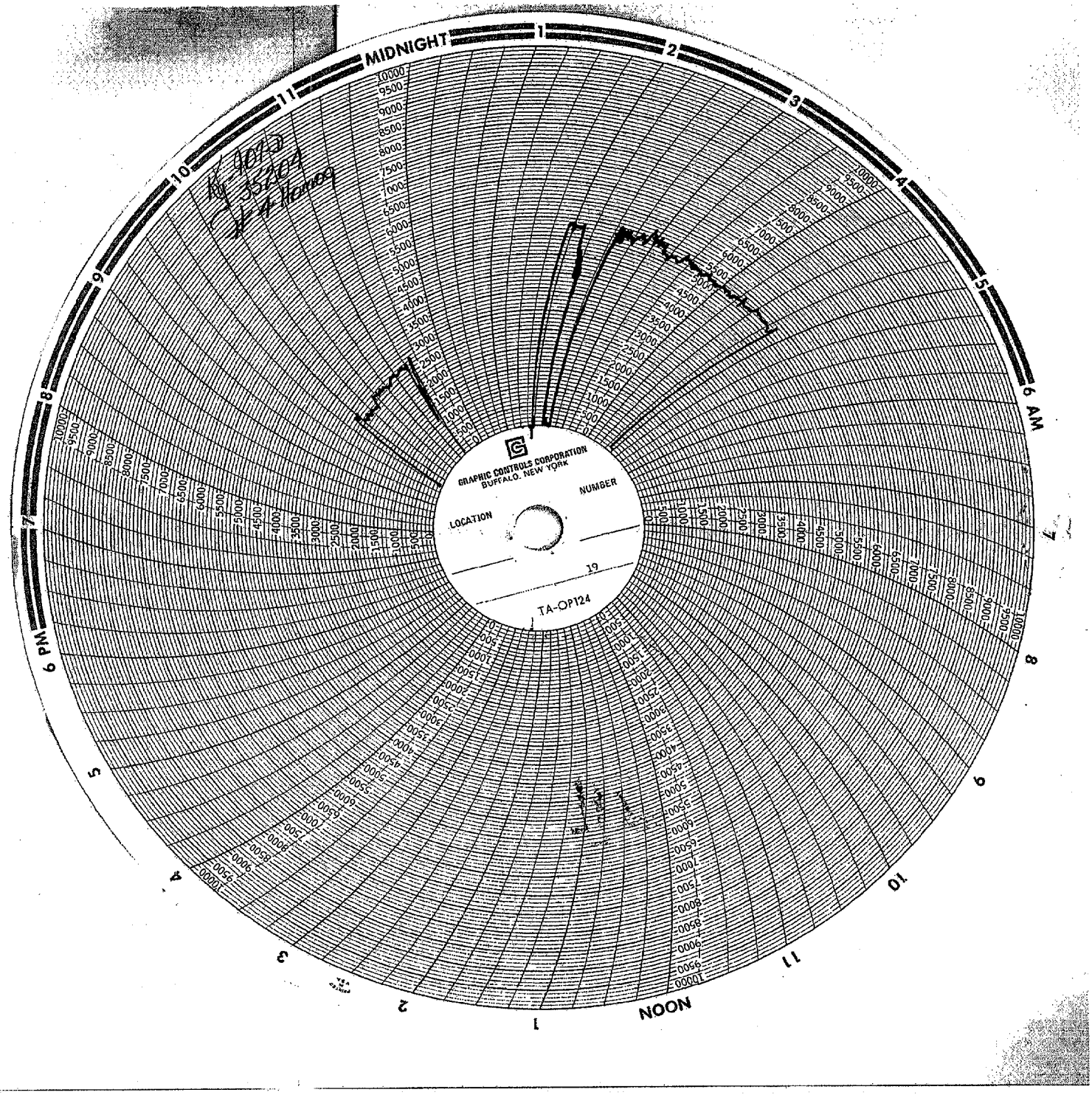
DUP050461346

V-244

| EQUIPMENT | | PAGE 3 OF 3 CG C3 CODE KY-907-D (D) EST. WGT. 3480 LBS. | USE LBS. | N CODE | ACCT LBS. |
|---|---|---|---|---|---|
| SV & SP 9 Con'T | 58 | When S54 complete turn off Homog & stearate pump | | | |
| | 59 | Stir 5 min at 198-200°F | | | |
| | 60 | Shut off steam | | | |
| | 61 | When S64 complete, Operator PB | | | |
| | 62 | SP Step 23/53 Record pH 4.0 (3.3-3.7) | | | |
| | 57 | If necessary adj pH to (3.3-3.7) (DOWN ONLY) Record: pH 3.5 | 140 | 15-A | 140 |
| | | NOTE: Dissolve extra N-15-A in water at 110-120°F in drum. Use ± 30 gal of water to 50# N-15-A. Stir SV 5 min after each addition. | | | |
| | 58 | Pmp in N-7-D from S31 in 10-12 min & stir 5 min | | | |
| | 59 | Record: pH 4.3 (4.2-4.4) & if necessary adj pH 4.2-4.4 & Record: pH ✓ | | | |
| | | (Dilute 10 parts water to 1 part N-7-D) Assume 78% | ✓ | 27-D | ✓ |
| | | Pmp N-7-D into SV Assume 50% | ✓ | 7-D | ✓ |
| | 60 | Operator Step PB | | | |
| | 61 | Operator Step PB | | | |
| | 62 | SP Step 60 - Batch complete | | | |

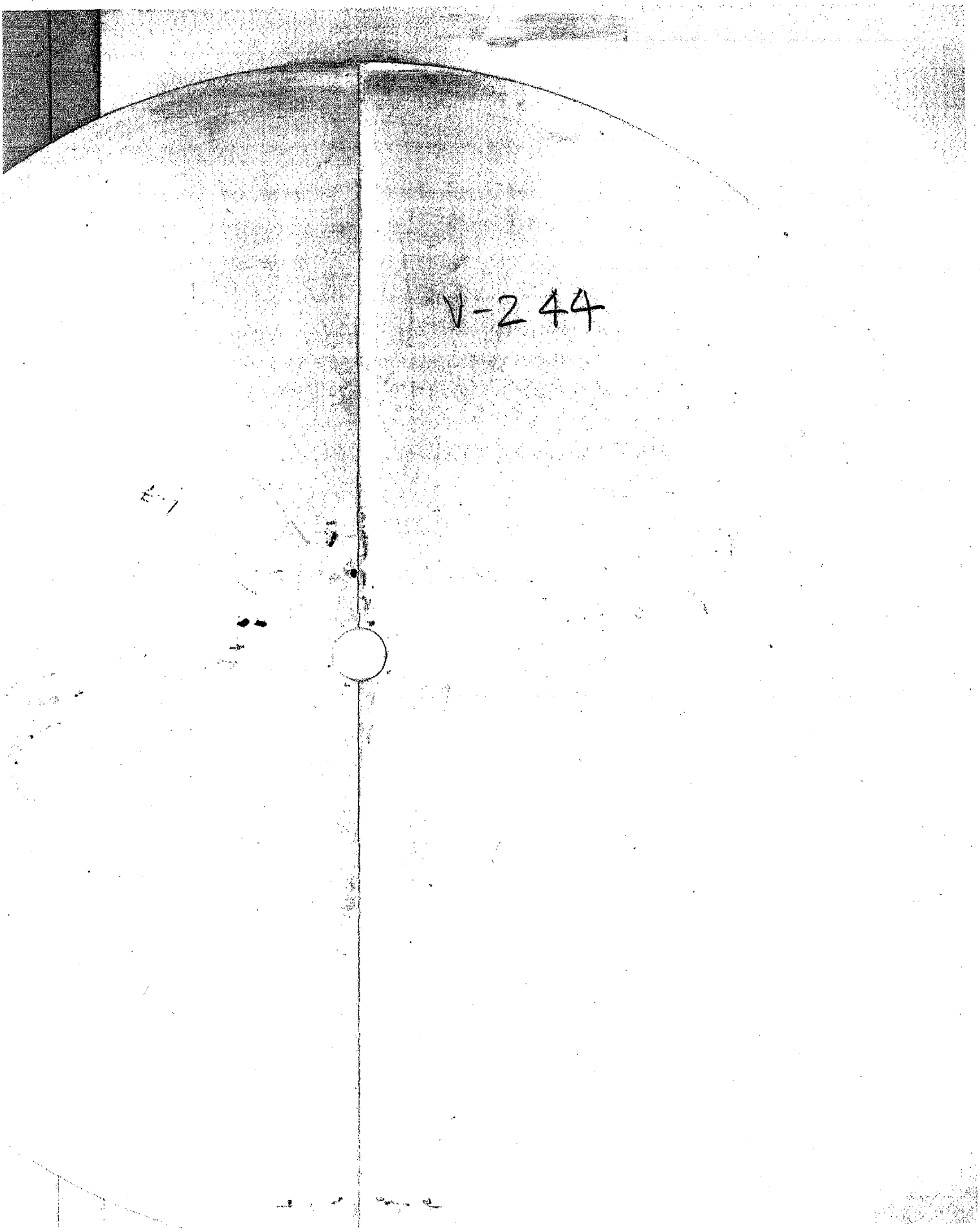
| START Time | SP Step | FINISH Time | SP Step | OPTR |
|---|---|---|---|---|
| 11:00P | | 7:00A | | 235-342 |
| 7:00A.M | | 11:20A.M | | 381.438 |

DUP050461347




N32460.01

DUP050461348


V-244