

S.V. 244 (Automated) C.V. _____

PROCESSES		APPROVED BY	
() KY-908-D	(D)	EWK	12/12/77
()	()	DCG	12/14/77
()	()	MW	12/19/77
TYPED BY			
rj 1/31/78			

CG 03 CODE KY-908-D PKG. _____
 → JAN 29 34073 JAN 31
 EST. WGT. 949 LBS.
 STD. HRS. _____ TIME 3A^M

OK
FP

14 YC-3-B 93 4 Lot 24422 1650 #
 14 YC-3-B 93 4 Lot _____ #
 14 YC-3-B 93 4 Lot _____ #

V-244 MTI 16:30P

Homog #3-2nd Pass
NON-BLEEDING

Total Wgt. 3549#

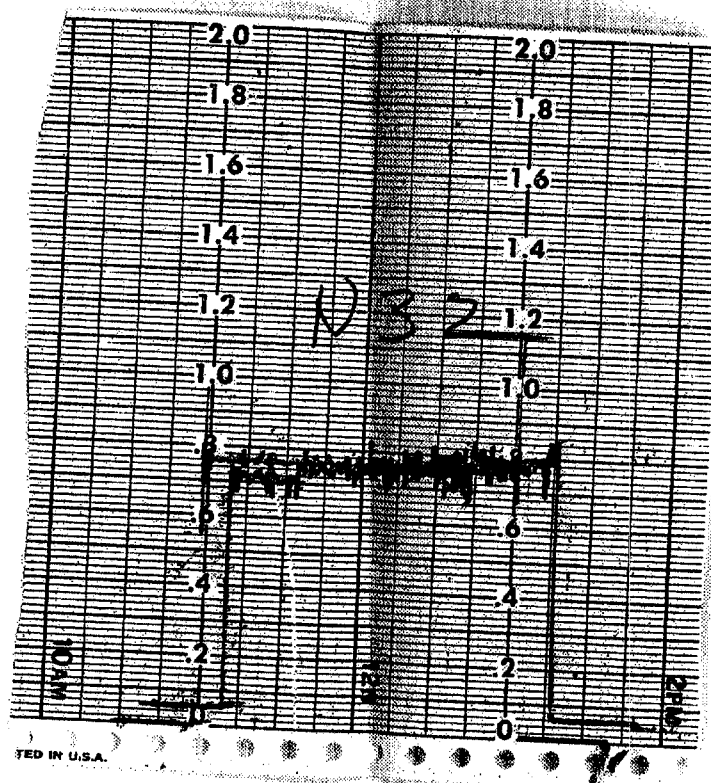
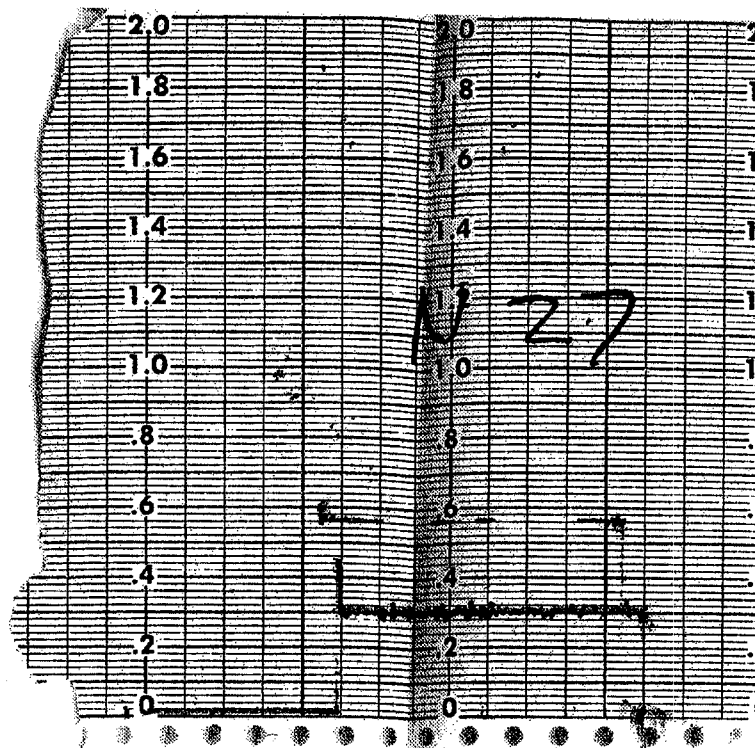
EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205	60" 9205 KROLOR® YELLOW - LIGHT			
1	1 Run 25" (360 G) water into V-203			
	2 Pour in	345	32-D	345
	3 Dump in	52 x 50	YC-3-B	2600
	Record: Start <u>P</u>			
	Fin <u>8:30 AM</u>	<u>24422</u>	<u>1650</u>	
		<u>24417</u>	<u>950</u>	
	4 Add to 78" (1200 G)			
	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 <u>42</u> & adj to 60" (2100-G)			
	8 Inspect Homog, strainer & clean if necessary			
205 & SV	9 Run 10" (514 G) water into V- <u>244</u> & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into V- <u>244</u>			
	Record: Time Start <u>6:40P</u> Total Min <u>120</u>			
	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 #3 (V-243) or #8 (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			
	11G <u>40</u> % - preset #2 208 Gal		15-A	416
	15 Set strike flow controllers as follows			
	a. 3FC10 (N-27-D Controller) in Manual 0.54 GPM		27-D	180
	b. 3FC20 (N-27-D water) in Manual Local 4.4 GPM			
	c. 3FR10 (N-27-D/Water) Ratio 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1215
	e. 8FC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water) Ratio 1.1			
SV & SP	16 Operator Step PB			
CP	17 Record Level 21G <u>56</u> %. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
4	19 Record pH <u>10.1</u> . Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	<u>30</u>	7-D	<u>15</u>
	Siphon into SV & Record: pH <u>11.2</u>			
	20 Operator Step PB			

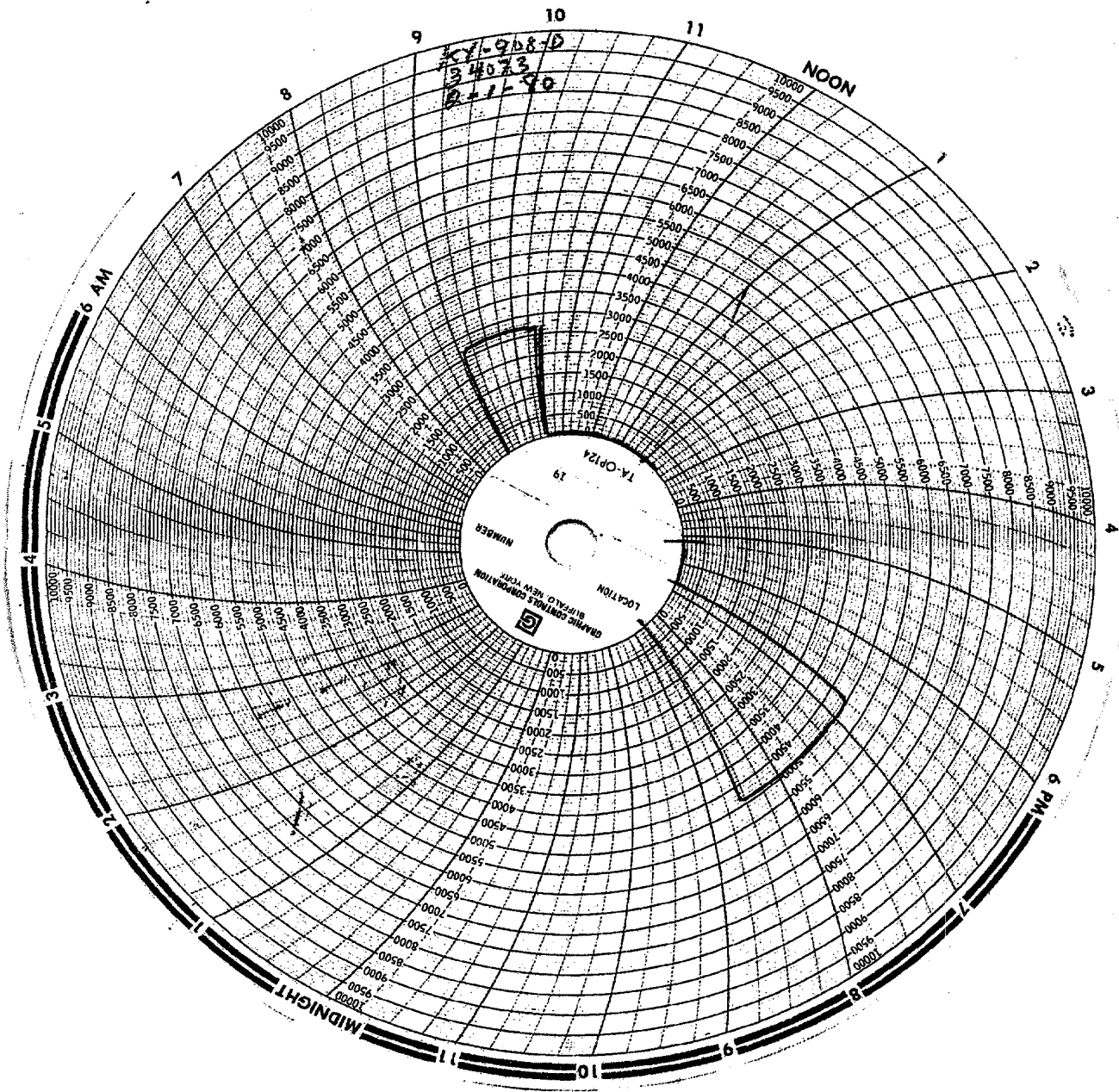
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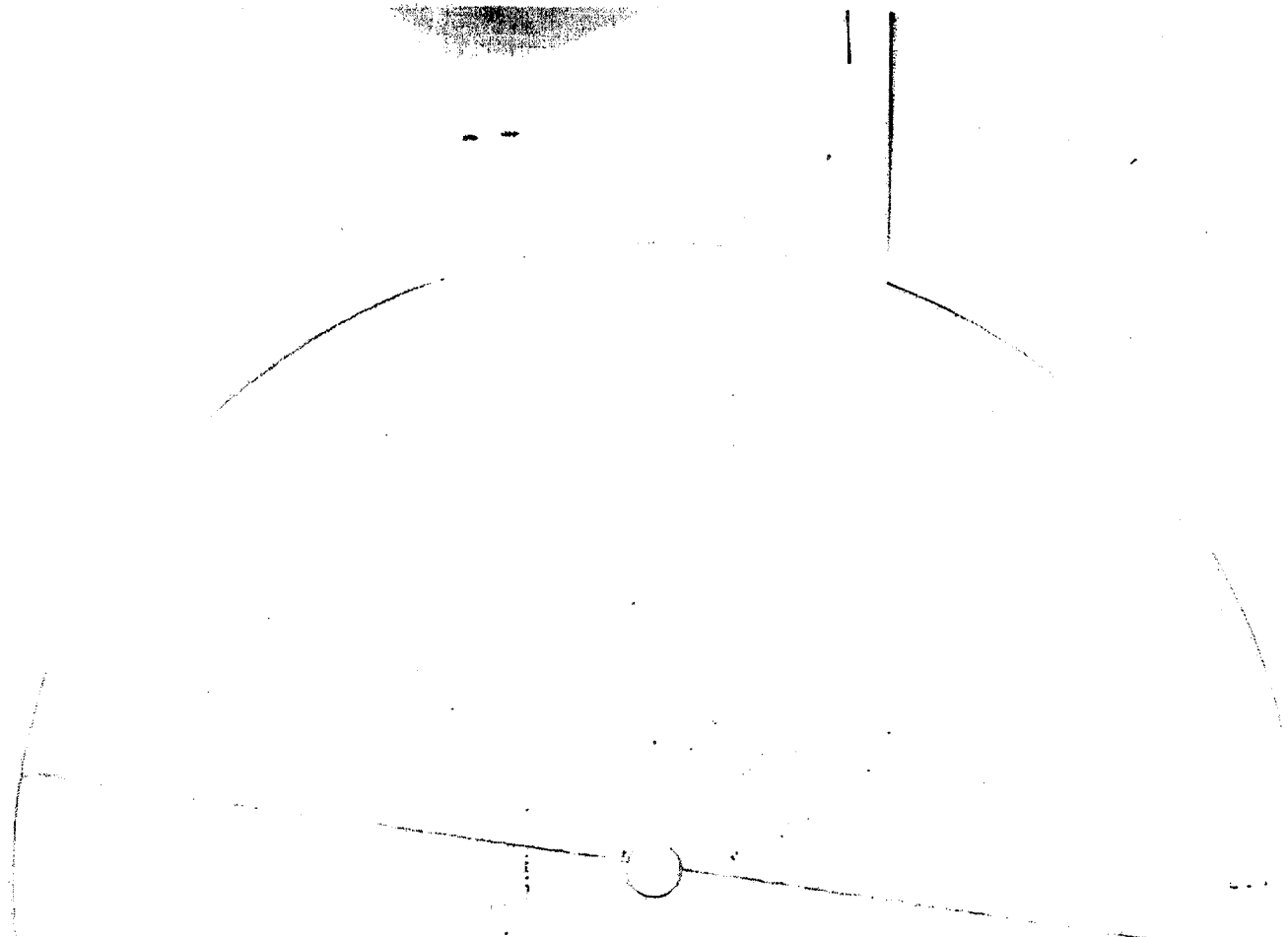
V-244

EQUIPMENT	PAGE 2 CG 03 CODE KY-908-D (D) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	21 SP Step 06/39 - After heat up Record: pH 9.85 (9.5-10.0)			
SP	22 Switch 3FC20, 8FC10, 8FC20 to auto			
5	23 Operator Step PB			
	24 SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits Switch 3FC10 to Auto. Operator Step PB			
	25 SP Step 11/44 - When 3FC10, 3FC20, flows in limits switch 3FC20 to Remote			
	26 Operator Step PB			
	27 During Strike, Record pH & Time as follows:			
	SP Step			
	V-243/V-244			
	13/46 (30 min)	pH 9.7	Range 9.3-10.0	Time 10:40
	14/47 (60 min)	9.7	9.3-10.0	11:10
	15/48 (2 hrs)	9.7	9.3-10.0	12:10
	16/49 (2 hrs 25 min)	9.5	9.3-10.0	12:35
	17/50 (Final 3 hrs)	8.2	7.5-8.5	1:10
	Note: (1) If pH not as specified notify Supervisor & note in Log (2) If final pH is above 8.5 adj to 7.5-8.5 & Record: pH Assume 78%			
	28 Sift in 31" (3796)	50	27-D 128-A	50
302	29 Add 17" (2086) water to V-302			
6	30 Add & stir 2 min for S57 Assume 50%	100/160	7-D	5080
PT	31 During Strike pump into PT	312	169-A	312
7	32 Pump in	36	155-A	36
	33 Pump in	36	160-A	36
	34 Stir 10 min with lightning mixer for S38			
356	35 During strike Run 20" (244G) water into V-356			
8	36 Turn on steam			
	37 Adj to 26" (317G) at 178-182°F 82°C			
	38 Pump PT mixture from S34 thru undersurface Distributor AFAP			
	39 Rinse PT with hot water from hot water mixer & pump in			
	40 Shut off pump			
	41 Stir 30 min at 178-182°F for S48 82°C			
	42 Do not shut off Agitator			
SV & SP	43 When S28 complete, heat SV to 198-200°F in 5-10 min			
9	44 Close water line & Discharge valves at stearate pump			
	45 Open V-356 Discharge valves to stearate pump inlet			
	46 Open water valve at stearate pump & run water thru Homog at 2900-3100 PSI to sewer			
	47 While Homog water at 2900-3100 PSI, open Homog Discharge valve to SV & close valve to sewer			
	48 Immediately open stearate pump Discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 PSI maintain SV at 198-200°F			
	49 While Homog V-356 to SV, shut off water valve at stearate pump ASAP			
	50 When Homog complete, Rinse in V-356 with hot water from hot water mixer			
	51 When S50 complete turn off Homog & stearate pump			
	52 Stir 5 min at 198-200°F			
	53 Shut off steam			

[illegible]







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