

243 244 (Automated) **PUNCHED & CHECKED**

CG 03 CODE KY-788-D

MAR 16 34926

EST. WGT. 960 - 860 LBS.

MAR 19 1980

OK

KP

STD. HRS. 8.8

TIME

7: A M

14 YC-3-B 98 4 Lot

24404

2600

14 YC-3-B 98 4 Lot

14 YC-3-B 98 4 Lot

PROCESSES	APPROVED BY
() KY-788-D	() EWK 9/28/76
()	() MTW 9/30/76
()	() DCG 9/30/76
()	()
TYPED BY	
NE 2-18-77	

Total Wgt. 3560# 3460

NON-BLEEDING

INVENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" (1170G) "KROLOR" YELLOW - LIGHT			
&	1 Run 23" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED			
205	2 Weigh in drum & pour in	345	32-D	345
1	3 Dump in & stir 5 min	52 x 50	YC-3-B	2600
	Record: Start 24404	2600		
	Fin			
	75" (2756)			
	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 washcolor 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			
205	DURING Homog, RUN V-203 AGITATOR ON LOW SPEED			
&	9 Run 10" (514 G) water into V- 243 & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V- 243			
2	Record: Time Start 5:45 P.M. Total min 100			
	Note: If Homog pressure falls below 4800 ps., 3-way valve will recirculate slurry to V-205			
	21 When V-205 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
SP	22 SP Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
&	23 Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
CP	24 Record levels and set Raw Material Counter #1 as follows			
3	a. 11LG 46 % - preset #2 208 Gal 15-A 416			
	b. 13LG 64 % - preset #6 135 Gal 20-A 135			
	25 Set strike flow controllers as follows:			
	a. 3PC10 (N-27-D Controller) in Manual 0.54 GPM 27-D 180			
	b. 3PC20 (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 0.92 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			
320	26 Operator Step PB			
243	27 Record Level 21G 56 %. If below 35% follow solution make-up procedure for N-27-D			
SP	28 Adj SV to 47" (2400 G)			
&	29 Record pH 10.2. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
CP	Siphon into SV & Record: pH 11.2			
4	20 Operator Step PB			

REV.

SS

DUD050004452

U/PMENT	PAGE 2 CG 03 CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACC LBS.
SV	21 SP Step 06/39 - After heat up Record: pH <u>9.7</u> (9.5-10.0)					
SP	22 Switch 3FC20, 8FC10, 8FC20 to Auto					
	23 Operator Step PB					
5	24 SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is 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: <u>9.00 A</u>					
	SP Step					
	V-234/V-234 pH Range Time					
	13/45 (30 min) <u>9.6</u> 9.3-10.0 <u>9.30 A</u>					
	14/47 (60 min) <u>9.6</u> 9.3-10.0 <u>10.00 A</u>					
	15/48 (2 hrs) <u>9.6</u> 9.3-10.0 <u>11.00 A</u>					
	16/49 (2 hrs 25 min) <u>9.6</u> 9.3-10.0 <u>11.25 P</u>					
	17/50 (Final 3 hrs) <u>8.0</u> 7.5-8.5 <u>12.00 P</u>					
	Note: If not as specified notify Supervisor & Note in log					
	If final pH is above 8.5, adj 7.5-8.5					
	& Record: pH Assume 77%				27-D	
339	28 While striking run 30" (234 G) water into V-339					
6	29 Add in 7-8 min			350	530-A	350
	30 Add to 49" (382 G) at 80-100 °F					
	31 Stir 5 min & record pH (9.5-10.5)					
	32 Stir 15 min or longer to dissolve for SP Step 26/56					
	33 Record Vol <u>99</u> " & Calculate <u>99</u> " (Vol X 0.78= <u>382 G</u>)					
	34 Set preset #8 to <u>382 G</u> from S 33					
302	35 Run 40" (440 G) water into V-302					
7	36 Add & stir 2 min for S 40 Assume 50%			360	7-D	180
SV	37 SP Step 17/50 After checking pH. Operator Step PB					
SP	38 SFC in 2 bags			100	128-A	100
	39 SP Step 23/53 Record: pH <u>3.5</u> (3.7-4.2)					
8	40 Run in N-7-D from S 36 in 10-12 min & stir 5 min					
	41 Record: pH <u>9.5</u> (9.0-9.5) & if necessary add to pH 9.0-9.5					
	& Record: pH Assume 77%				27-D	
	(Dilute 10 parts water to 1 part N-7-D) Assume 50%				7-D	
	Siphon N-7-D into SV					
	42 Operator Step PB					
	43 SP Step 29 - Record: pH <u>9.5</u> (9.0-10.0) Time <u>1.40 PM</u>					
	44 Operator Step PB					
	45 SP Step 60 - Batch complete					
	Start Finish Optr					
	Time SP Step Time SP Step					
	<u>11:00 AM</u> <u>7.00 PM</u> <u>1:00 PM</u> <u>2:59-323</u>					







