

(243, 244) (Automated)

C.V.

D.V.

CG 03 CODE KY-795-D PKG. _____

MAR-6 34736

EST. WGT. 1162 1110 LBS.

STD. HRS. 8.2 TIME 3P M

14 YC-2-B 93 4 Lot 24066 1200#

14 YC-2-B 93 4 Lot 24079 550#

14 YC-2-B 93 4 Lot 24478 550#

Total Wgt. 4612# 24476 1350 MAR - 7 1980

PROCESSES		APPROVED BY
() KY-795-D	(H)	EWK 10-05-76
()	()	DCG 10-07-76
()	()	MTW 10-11-76
()	()	FWP 12-22-78
TYPED BY		
GHW122278		

NON-BLEEDING

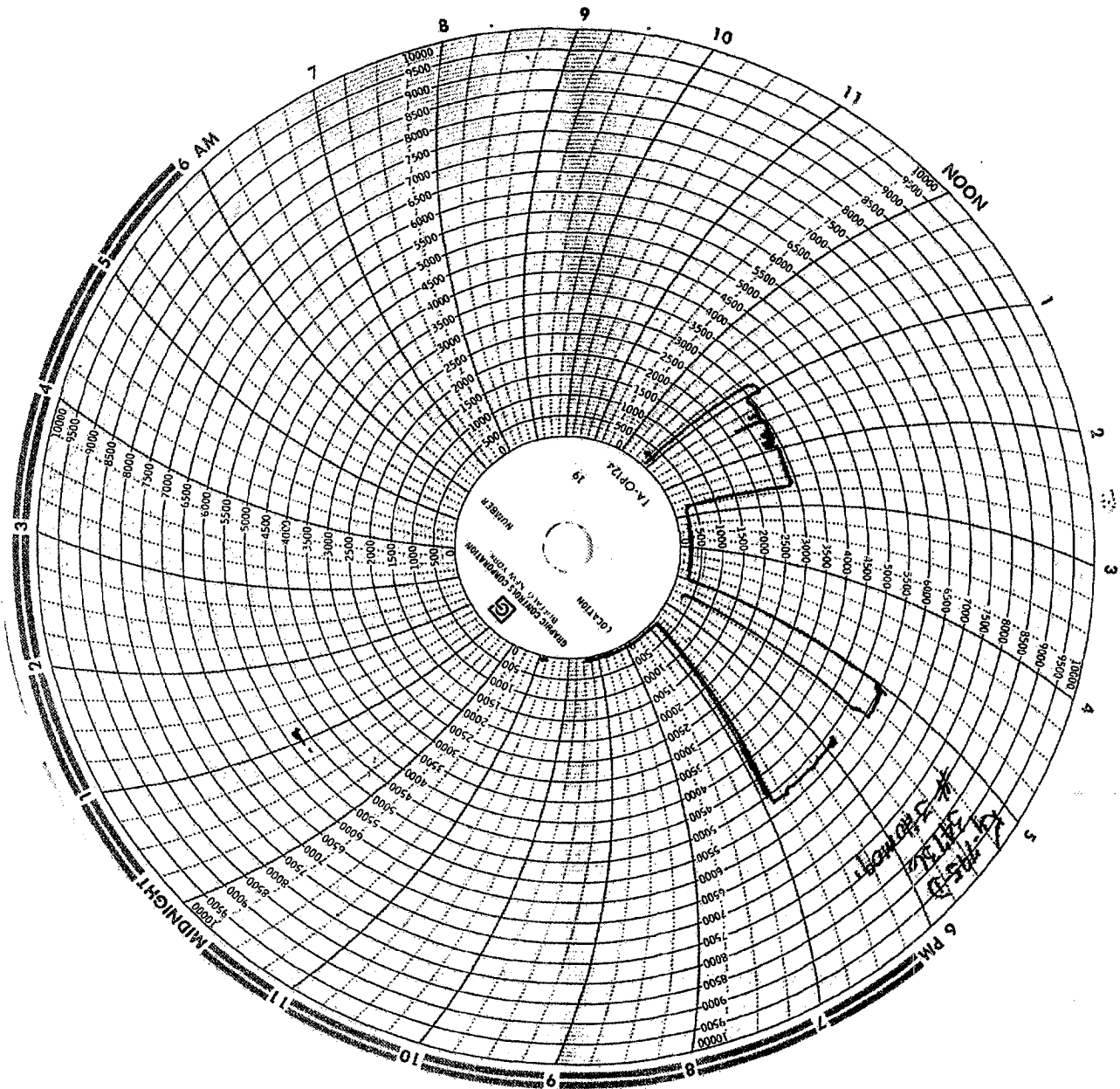
IMPMENT	NAME: KROLOR® YELLOW MEDIUM	USE LBS.	N CODE	ACCT LBS.
203	1 Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
&	1/2 Weigh in drum & pour in	475	32-D	475
205	1/3 Dump in & stir 5 min Lot	20 x 50	YC-2-B	3500
1	Record: Start 9:30 AM	69		3450
	Fin 11 PM	24079		
	75" (1275 G)	24478		
	1/4 Adj to 78" (1328 G)	24066		
	5 Pump V-203 thru Homog at 2400-2600 psi into V-205 24476	1350		
	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7 Record: V-205 Vol 51 " & adj to 51" (1874 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 PUMPING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
205	9 Run 10" (514 G) water into V-243 & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time Start 5:55 PM Total Min 135			
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. Rinse in using Hot Water			
SP	12 SP Step 01 - Set Formula Selector to position 15 (V-243) or #10 (V-244)			
&	13 Press SV Cam Reset PB set 22 TC in Auto Remote			
CP	(Temperature is set at 190-194°F)			
3	14 Record levels and set Raw Material Counter #1 as follows:			
	a. 11 LG 6.5% - preset #1 104 Gal		15-A	208
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual. 0.95 GPM		27-D	394
	b. 3FC20 (N-27-D Water) in Manual Local 7.7 GPM			
	c. 3FR10 (N-27-D / Water Ratio) 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 1.27 GPM		32-D	2675
	e. 8FC20 (N-32-D Water) in Manual Local 6.2 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D / Water) Ratio 1.0			
SV	16 Operator Step PB			
SP	17 Record Level 2LG 60% if below 35% follow solution make-up procedure for N-27-D			
&	18 Adj SV to 68" (3495 G)			
CP	19 Record: pH 10.9 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D) Assume 50%	14	7-D	7
4	Siphon N-7-D into SV & Record: pH 11.1			
	20 Operator Step PB			

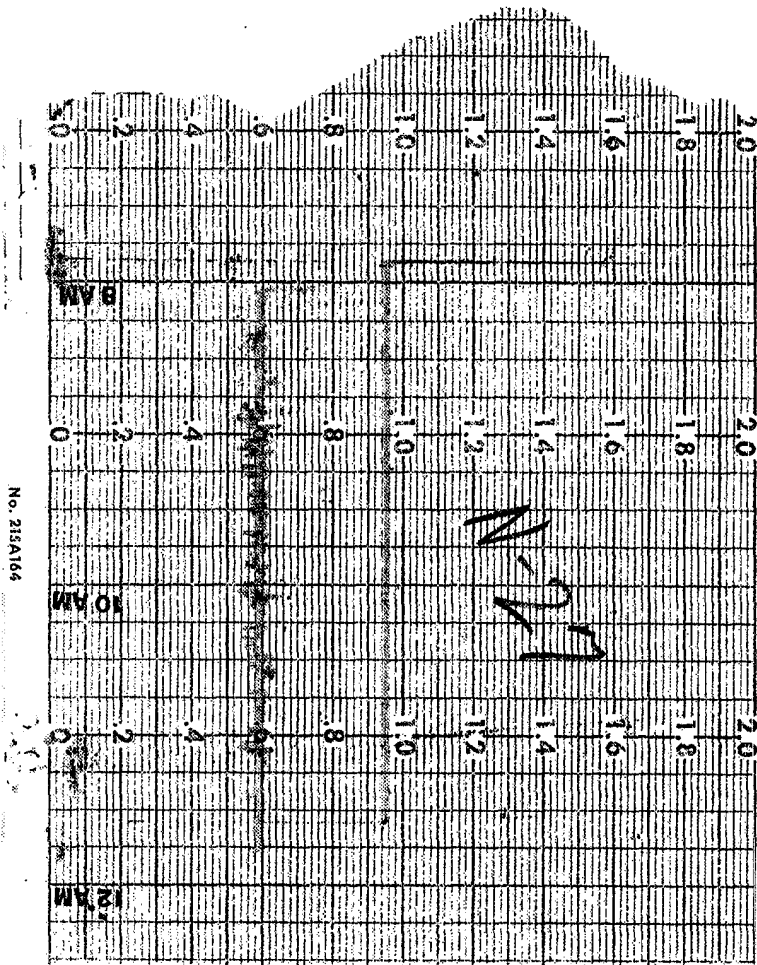
V-243

INVENTORY	PAGE 2	CG 03 CODE KY-795-D (H) EST. WGT.	4612 LBS.	USE LBS.	N CODE	ACC LBS
SV	21	SP Step 06/39 - After heat up Record: pH <u>9.8</u> (9.5-10.0)				
SP	22	Switch 3FC20, 8FC10, 8FC20, to Auto				
&	23	Operator Step PB				
CP	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits				
5		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 <u>9.7</u> Range 9.0-10.0 Time <u>10:45 PM</u>				
		14/47 (60 min) pH <u>9.7</u> Range 9.0-10.0 Time <u>11:15 PM</u>				
		15/48 (2 hrs) pH <u>9.7</u> Range 9.0-10.0 Time <u>12:15 AM</u>				
		16/49 (3 hrs) pH <u>9.7</u> Range 9.0-10.0 Time <u>1:15 AM</u>				
		17/50 (Final) pH <u>8.0</u> Range 7.5-8.5 Time <u>2:00 AM</u>				
		NOTE: If not as specified notify Supervisor & note in log				
		If final pH above 8.5 adj to 7.5-8.5				
		& Record: pH Assume 77%			27-D	
Drum	28	Weigh into 55 Gal Drum	Assume 50%	56	7-D	28
7	29	Fill with water & stir 2 min				
SV	30	SP Step 17/50 - After checking pH, Operator Step PB				
SP	31	Step 23/53 - Record: pH <u>3.6</u> (3.3-3.7)				
&	32	If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH			15-A	
CP	33	Sift in 3 bags		200 150	128-A	150
8	34	Siphon in N-7-D from S 29 in 10-12 min & stir 5 min				200
	35	Record: pH <u>4.0</u> (4.0-4.2) & if necessary adj to pH 4.0-4.2				
		& 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				
	36	Operator Step PB				
	37	SP Step 24/54 - Pour in & stir 15 min		22	978-A	22
	38	Operator Step PB				
	39	SP Step 60 - Batch complete				
		START	FINISH	OPTR		
		TIME SP STEP	TIME SP STEP			
		<u>3:00 PM</u>	<u>11:00 PM</u>	<u>144</u>		
		<u>11:00 P</u>	<u>2:40 AM</u>	<u>235 - 323</u>		

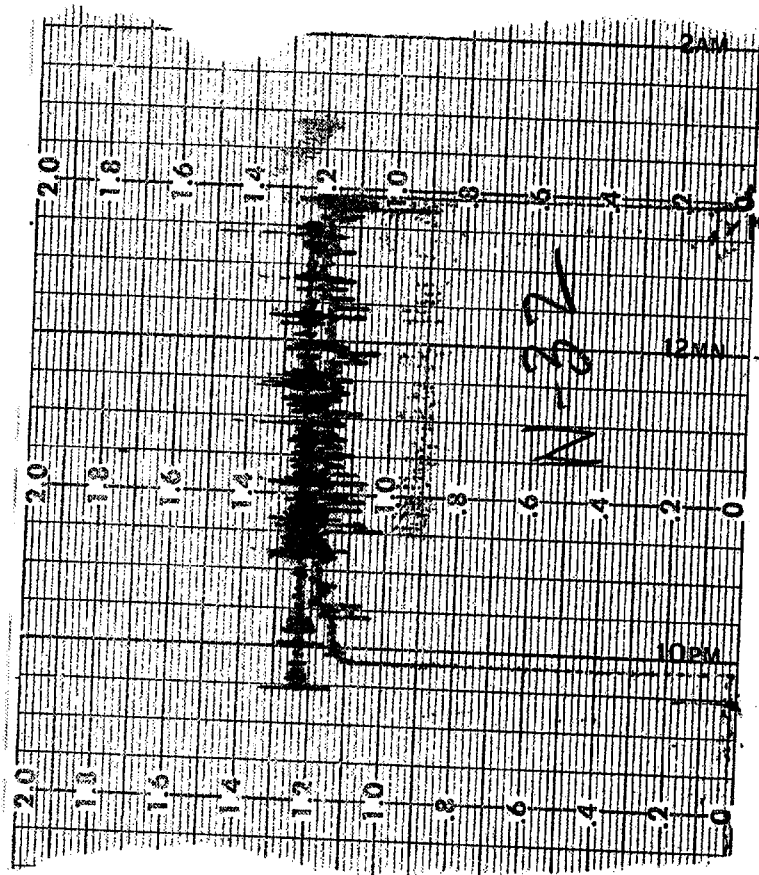
V-243







No. 215A166



No. 315A164

