

S.V. 243 (Automated) C.V. 244
 CG 03 CODE KY-907-D PKG.
 → DEC 26 33508
 EST. WGT. 1080 LBS.

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			

STD. HRS. TIME 7 A M
 14 YC-2-B 93 4 Lot 24069, 2000#
 14 YC-2-B 93 4 Lot 24170, 400#
 14 YC-2-B 93 4 Lot , #

Homog #4 - 125 Pass
 " #3 - 2 " "

Total Weight - 3480#

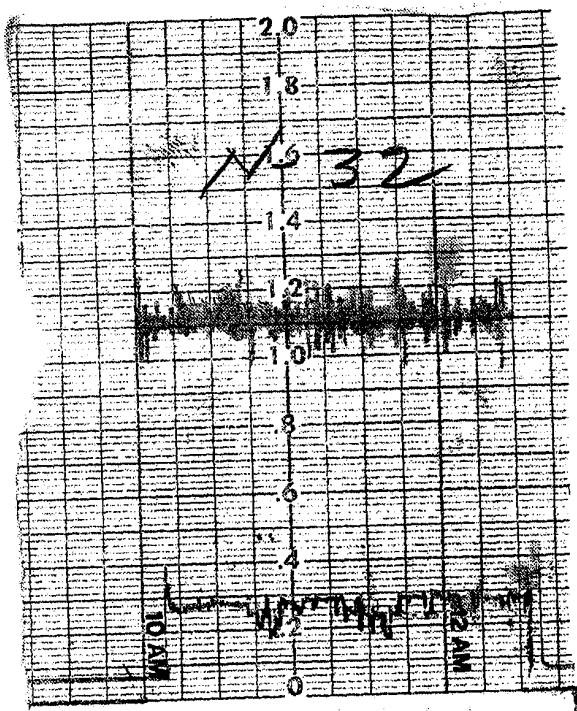
NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205	60" (990 G) KROLO® - YELLOW MEDIUM			
1	1 Run 33" (560 G) water into V-203			
	2 Pour in	320	32-D	320
	3 Dump in			
	Record: Start <u>2:30 A.M.</u> Lot <u>24069</u>	48 x 50	YC-2-B	2400
	Fin <u>3:30 A.M.</u> <u>24170</u>	<u>2000</u>		
75" (1256)	4 Adj to 70" (1200 G) <u>2400-2600</u>	<u>1100</u>		
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205	<u>2400</u>		
	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 SV & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into V- <u>244</u>			
	Record: Time Start <u>10:00</u> Total Min <u>130</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 #2 (V-243) or #7 (V-244)			
3	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 <u>43</u> % - 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	16 Operator Step PB			
4	17 Record Level 2 LG <u>64</u> %. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj to 48" (2470 G)			
	19 Record: pH <u>10.5</u>			
	20 Adj to 11.1-11.3 using N-7-D diluted to 5% Assume 50%	<u>30</u>	7-D	<u>15</u>
	(10 parts water to 1 part N-7-D)			
	Siphon into SV Record: pH <u>10.1</u>			
	21 Operator Step PB			

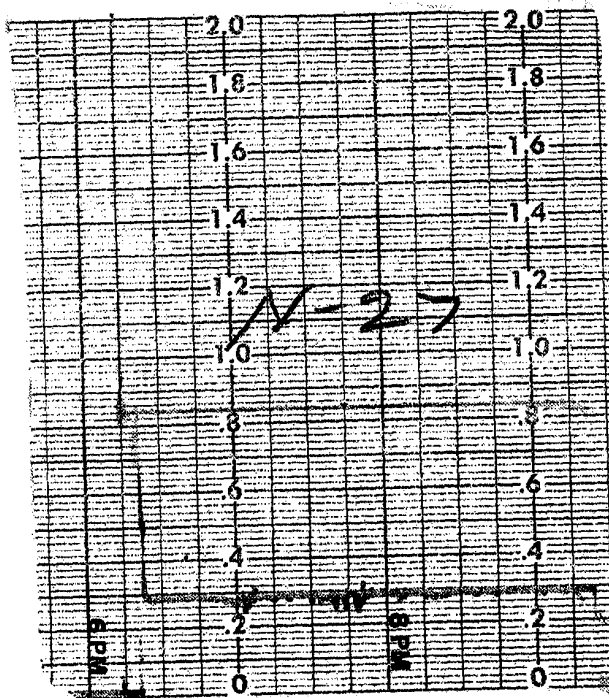
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EQUIPMENT		PAGE 2 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP Step 06/39 - After heat up Record: pH <u>10.0</u> (9.5-10.0)			
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto			
&	24	Operator Step PB			
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits			
5	25	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) <u>9.9</u> 9.0-10.0 <u>3:10</u>			
		14/47 (60 min) <u>9.9</u> 9.0-10.0 <u>3:46</u>			
		15/48 (2 hrs) <u>7.9</u> 9.0-10.0 <u>4:40</u>			
		16/49 (2 hrs 25 min) <u>9.9</u> 9.0-10.0 <u>5:05</u>			
		17/50 (3 hrs Final) <u>8.3</u> 7.5-8.5 <u>5:40</u>			
		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 Assume 78%			
	29	Sift in	✓ 50	27-D 128-A	50
302	30	Add 17" (208 G) water to V-302			
6	31	Add & stir 2 min for S58 Assume 50%	100	7-D	50
PT	32	During strike pump into PT	318	169-A	318
7	33	Pump in	36	155-A	36
	34	Pump in	36	160-A	36
	35	Stir 10 min with lightning mixer for S39			
356	36	During strike run ^{14"} 20" (244 G) water into V-356			
8	37	Turn on steam			
	38	Adj to 267" (317 G) at 178-182°F 81-82°C			
	39	Pump PT mixture from S35 thru undersurface distributor AFAP			
	40	Rinse PT with hot water from hot water mixer & pump in			
	41	Shut off pump 81-82°C			
	42	Stir 30 min at 178-182°F for S49			
	43	Do not shut off agitator			
SV	44	When S29 complete, heat SV to 198-200°F in 5-10 min			
&	45	Close water line & discharge valves at stearate pump			
SP	46	Open V-356 Discharge valves to stearate pump inlet			
9	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			

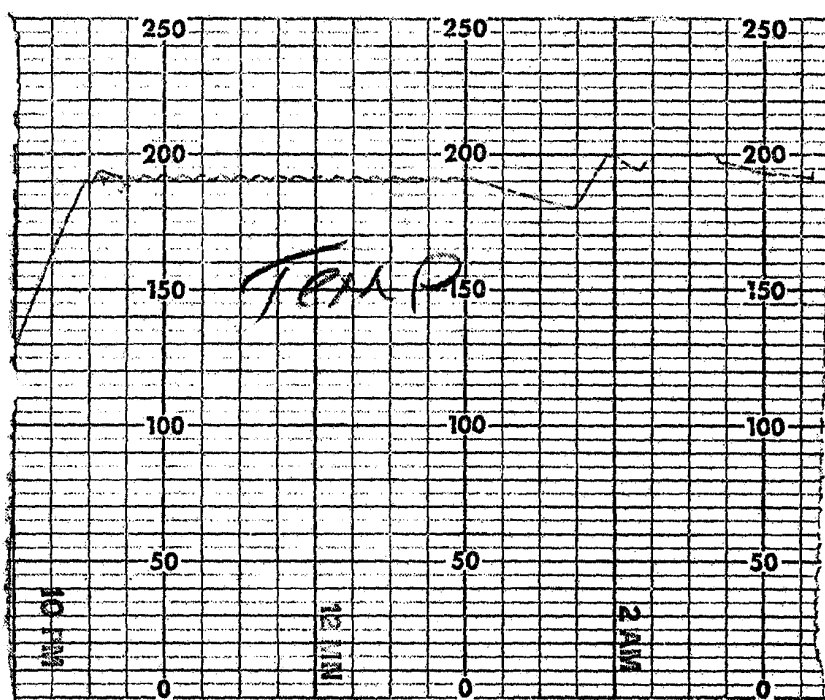
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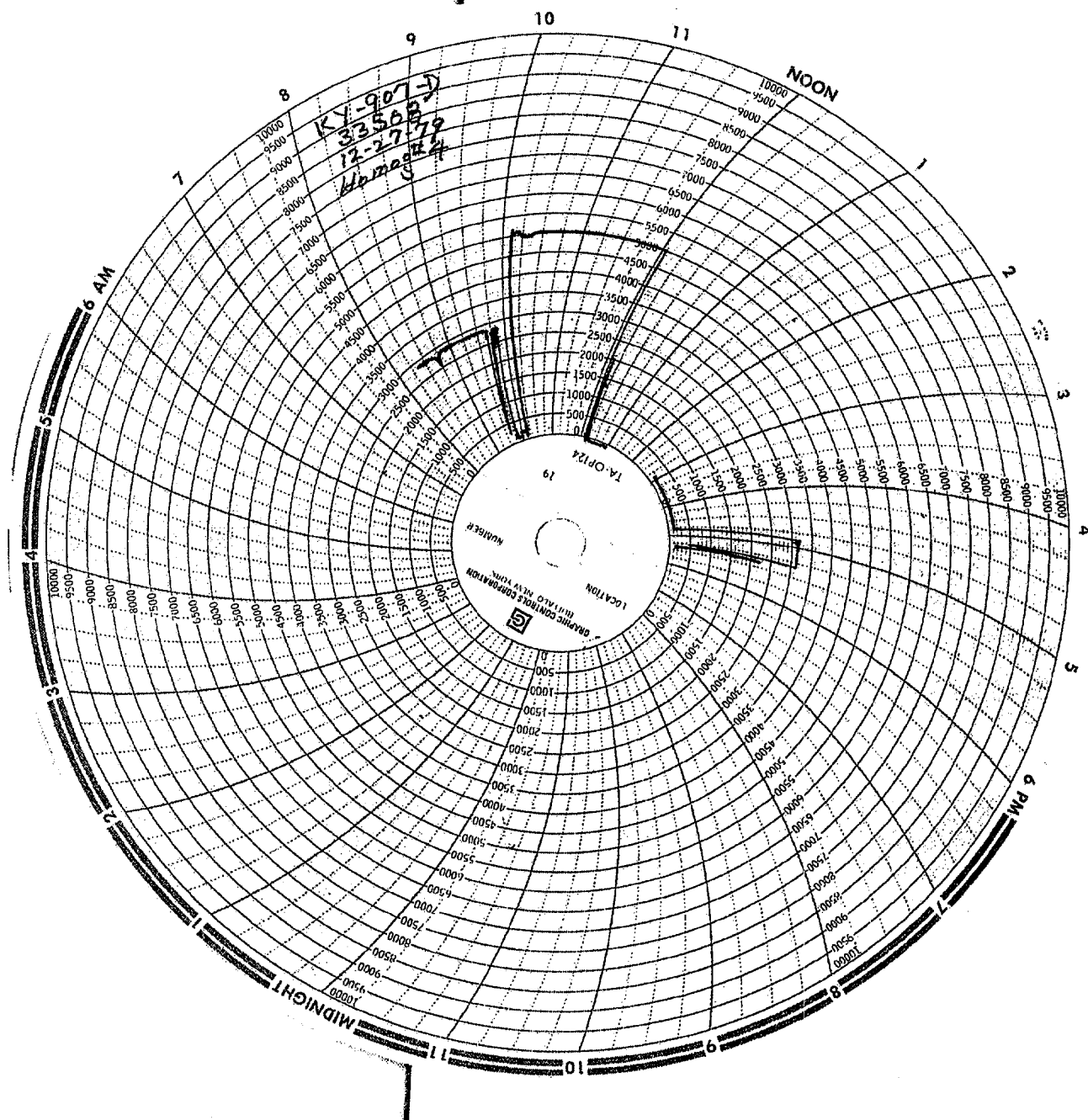
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