

243 210 (AUTOMATED)

CO. 203 CODE KY-787-D

PKG

PUNCHED & CHECKED

EST WGT

1090

LBS

STD HRS

8.9

TIME

35208

APR 10 1980

14 YC-2-B

93

4

LOT

24774, 2000

LOT

24773, 400

LOT

MAKING INSTRUCTIONS, BATCH UNIT

D.V.

PROCESSES	APPROVED BY
() KY-787-D	() CWK 9-22-76
()	() DCG 9-27-76
()	() MTW 9-30-76
()	()
RE-TYPED BY	
CJH 2-8-80	

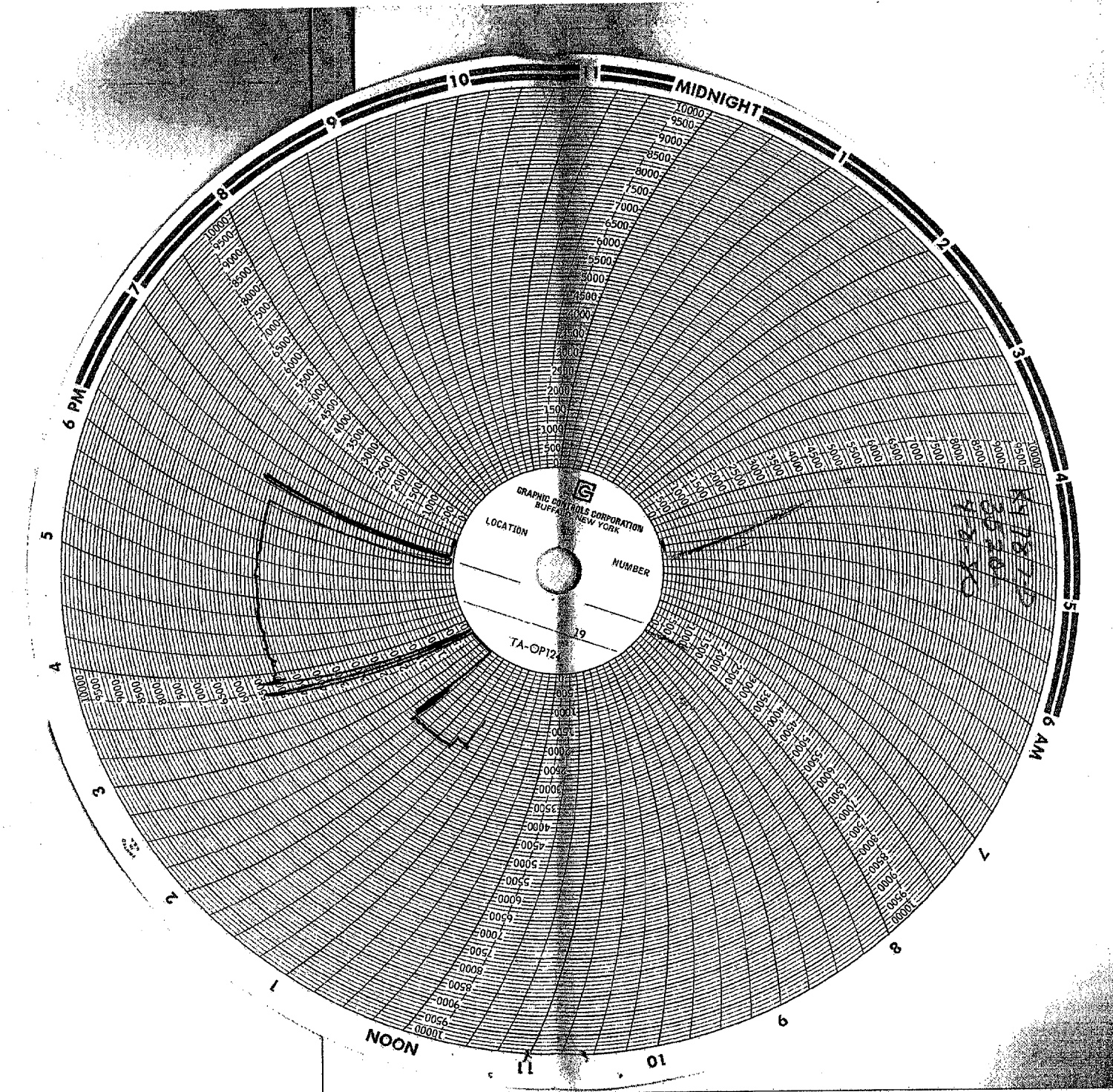
TOTAL WGT 3490#

NON-BLEEDING

ITEM	NAME	USE LBS	N CODE	ACCT LBS
203	1 RUN 60" (992 G) WATER INTO V-203, SET AGITATOR ON HIGH SPEED.			
205	2 WEIGH IN DRUM & POUR IN	320	32-D	320
1	3 DUMP IN AND STIR 5 MIN	118 X 50	YC-2-B	2400
	RECORD: START 2:20 PM	24774		
	FIN 3:40 PM	24773		
	25" (275 G)			
	4 ADJ TO 70" (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 1800-2000 PSI USING MINIMUM WATER			
	7 RECORD V-205 VOL			
	8 " & ADJ TO 60" (2100 G)			
	9 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	10 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
	11 RUN 10" (514 G) WATER INTO SV, START AGITATOR			
	12 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-243			
	RECORD TIME START 4:00 PM TOTAL MIN 1:00			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	13 WHEN V-205 MTY, RUN IN 5" (240 G) WATER AND PUMP THRU HOMOG AT 4800-5200 PSI			
SP & CP 3	14 SP STEP 01 - SET FORMULA SELECTOR TO POSITION #2 (V-243) OR #7 (V-244)			
	15 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
	16 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 10% - PRESET #1 80 GAL		15-A	160
	B. 13LG 20% - PRESET #6 135 GAL		20-A	135
	17 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	A. 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM		27	275
	B. 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	C. 3FR10 (N-27-D/WATER RATIO) 0.64			
	D. 5FC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM		32-D	1840
	E. 5FC20 (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	18 OPERATOR STEP PB			
	19 RECORD LEVEL 2 LG 42% IF BELOW 35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
	20 ADJ TO 45" (2470 G)			
	21 RECORD: pH 10.5			
	22 ADJ TO 11.1 - 11.3 USING N-7-D DILUTED TO 5% ASSUME 50% (10 PARTS WATER TO 1 PART N-7-D)	24	1-D	13
	SIPHON INTO SV. RECORD pH 11.1			
	23 OPERATOR STEP PB			

V-243

DEPARTMENT	PAGE 2	CG 03	CODE	KY-787-D	EST WGT	3490	LBS	USE LBS	N CODE	AGCT LBS
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: PH <u>9.8</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	26	SWITCH 3FC10 TO AUTO OPERATOR STEP PB								
	27	SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH 3FC20 TO REMOTE								
	28	OPERATOR STEP PB								
	29	DURING STRIKE, RECORD PH & TIME AS FOLLOWS:								
		SP STEP								
		V-243/V-244	PH	RANGE	TIME					
		13/46 (30 MIN)	<u>9.7</u>	9.0-10.0	<u>10:35 Am</u>					
		14/47 (60 MIN)	<u>9.7</u>	9.0-10.0	<u>11:05 Am</u>					
		15/48 (2 HRS)	<u>9.75</u>	9.0-10.0	<u>12:05 Am</u>					
		16/49 (2 HRS 25 MIN)	<u>9.85</u>	9.0-10.0	<u>12:30 Am</u>					
		17/50 (3 HRS FINAL)	<u>8.75</u>	7.5-8.5	<u>1:05 Am</u>					
		NOTE: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG								
		IF FINAL PH IS ABOVE 8.5, ADJ PH TO 7.5-8.5 &								
		RECORD: PH				ASSUME 77%			27-D	
339	29	WHILE STRIKING, RUN 30" (234 G) WATER INTO V-339								
6	30	ADD IN 7-8 MIN					350		530-A	350
	31	ADD TO 49" (382 G) AT 80 - 100°F								
	32	STIR 5 MIN & RECORD PH <u>10.2</u> (9.5-10.5)								
	33	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26								
	34	RECORD VOL <u>49</u> & CALCULATE <u>49</u> (VOL) X 0.78 = <u>38.22</u>								
	35	SET PRESET #8 TO <u>38.2</u> G FROM S 34								
302	36	ADD 30" (360 G) WATER TO V-302								
7	37	ADD & STIR 2 MIN FOR S 41					160		7-D	80
							ASSUME 50%			
243	38	SP STEP 17/50 - AFTER CHECKING PH, OPERATOR STEP PB								
	39	SIFT IN 2 BAGS					100		120-A	100
SP	40	SP STEP 23/53 - RECORD PH <u>3.55</u> (3.7-4.2)								
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
CP	42	RECORD: PH <u>10.0</u> (9.0-9.5) & IF NECESSARY ADJ PH 9.0-9.5								
8		& RECORD: PH <u>9.4</u>					ASSUME 77%		27-D	
		(DILUTE 10 PARTS WATER TO 1 PART N-7-D)					ASSUME 50%		7-D	
		SIPHON N-7 INTO SV								
	43	OPERATOR STEP PB								
	44	SP STEP 29/58 RECORD: PH <u>9.2</u> (9.0-10.0) TIME <u>2:25</u> <u>4:11</u>								
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE								
		START	FINISH							
		TIME	SP STEP	TIME	SP STEP	OPTR				
		<u>11:00 P</u>		<u>2:30 A</u>		<u>235-342</u>				



N32464.01

DUP050461362

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