

V. 243, (Automated)

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 03 CODE KY-907-D

PKG.

MAR 24

35045

EST. WGT. 1080

LBS.

STD. HRS.

TIME

7:AM

14 YC-2-B 93 4 Lot 24476 2400#

14 YC-2-B 93 4 Lot

14 YC-2-B 93 4 Lot

PUNCHED & CHECKED

MAR 26 1980

MAR 24 1980

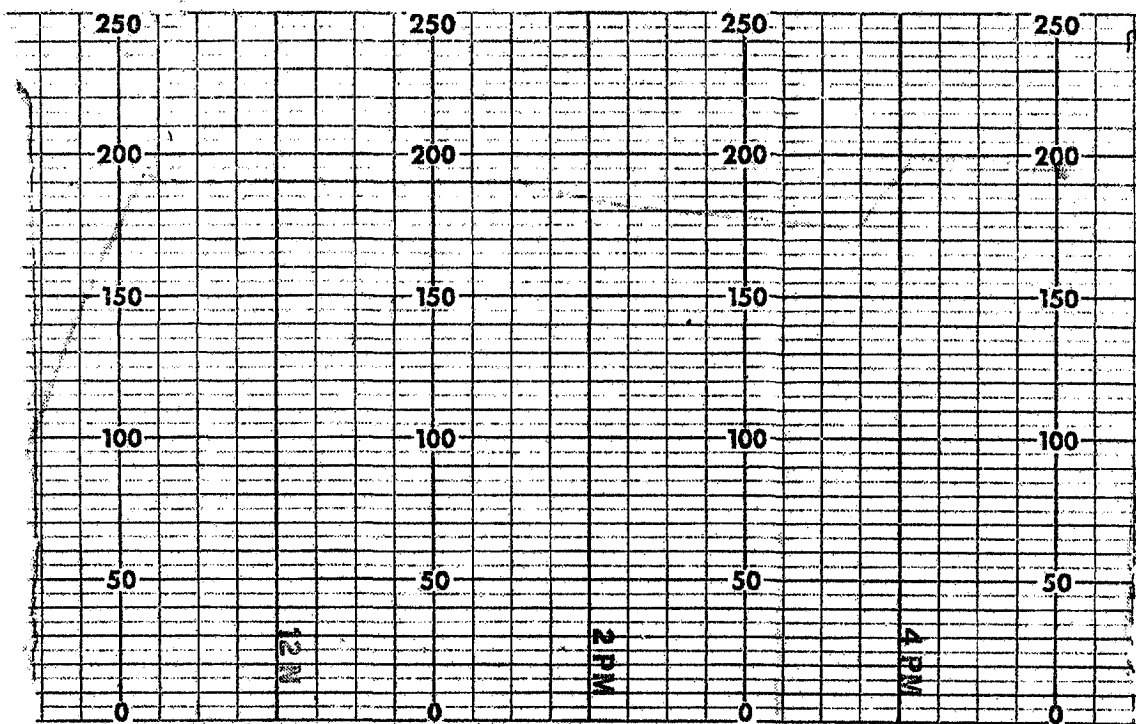
PROCESSES		APPROVED BY	
()	KY-907-D	()	EWK 12/12/77
()		()	DCG 12/13/77
()		()	MW 12/15/77
()		()	
()		()	
ED BY			
PJ 2/3/78			

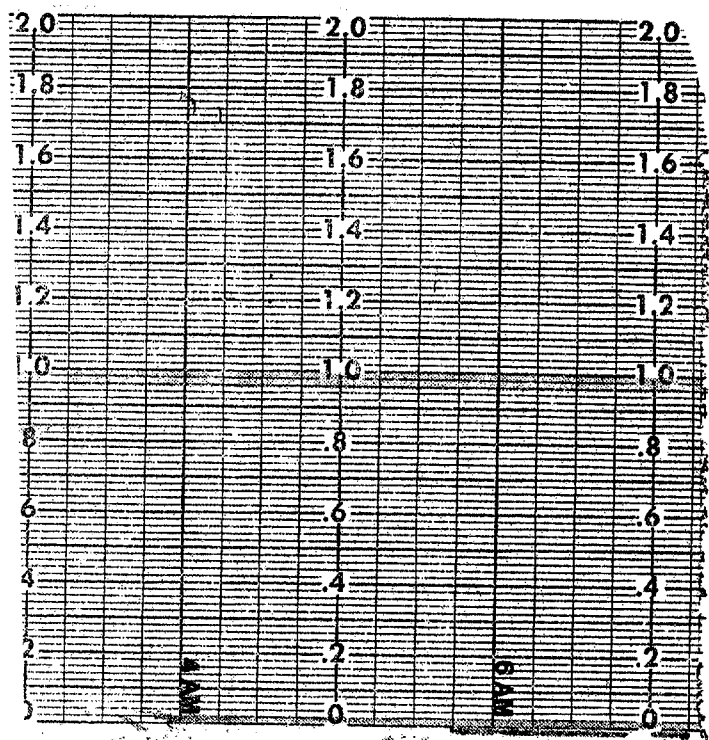
Total Weight - 3480#

NON-BLEEDING

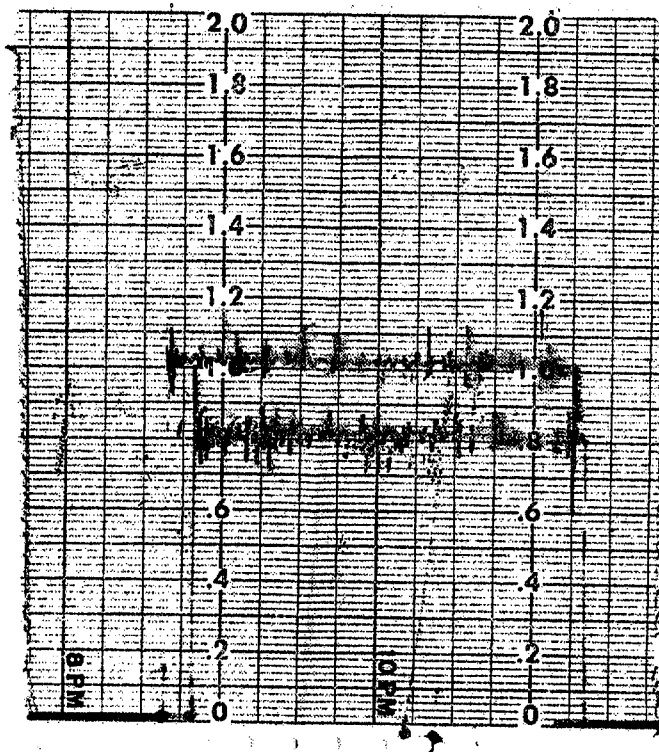
EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	KROLOR® YELLOW MEDIUM			
203 & 205	1 Run 33" (560 G) water into V-203. SET AGITATOR ON HIGH SPEED			
	2 Pour in	320	32-D	320
	3 Dump in	48 x 50	YC-2-B	2400
	Record: Start 8:00			
	Fin 9:41			
	75" (275 G)			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record V-205 Vol 50" & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
205	9 Run 10" (514 G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time Start 7:10 PM Total Min 9:10			
2	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
263	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 34% - 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. 3FC20 (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	16 Operator Step PB			
SP	17 Record Level 2 LG 90%. If below 35% follow solution			
	make-up procedure for N-27-D			
CP	18 Adj to 48" (2470 G)			
4	19 Record: pH 10.6			
	20 Adj to 11.1-11.3 using N-7-D diluted to 5% Assume 50%	40	7-D	20
	(10 parts water to 1 part N-7-D)			
	Siphon into SV Record: pH 11.2			
	21 Operator Step PB			

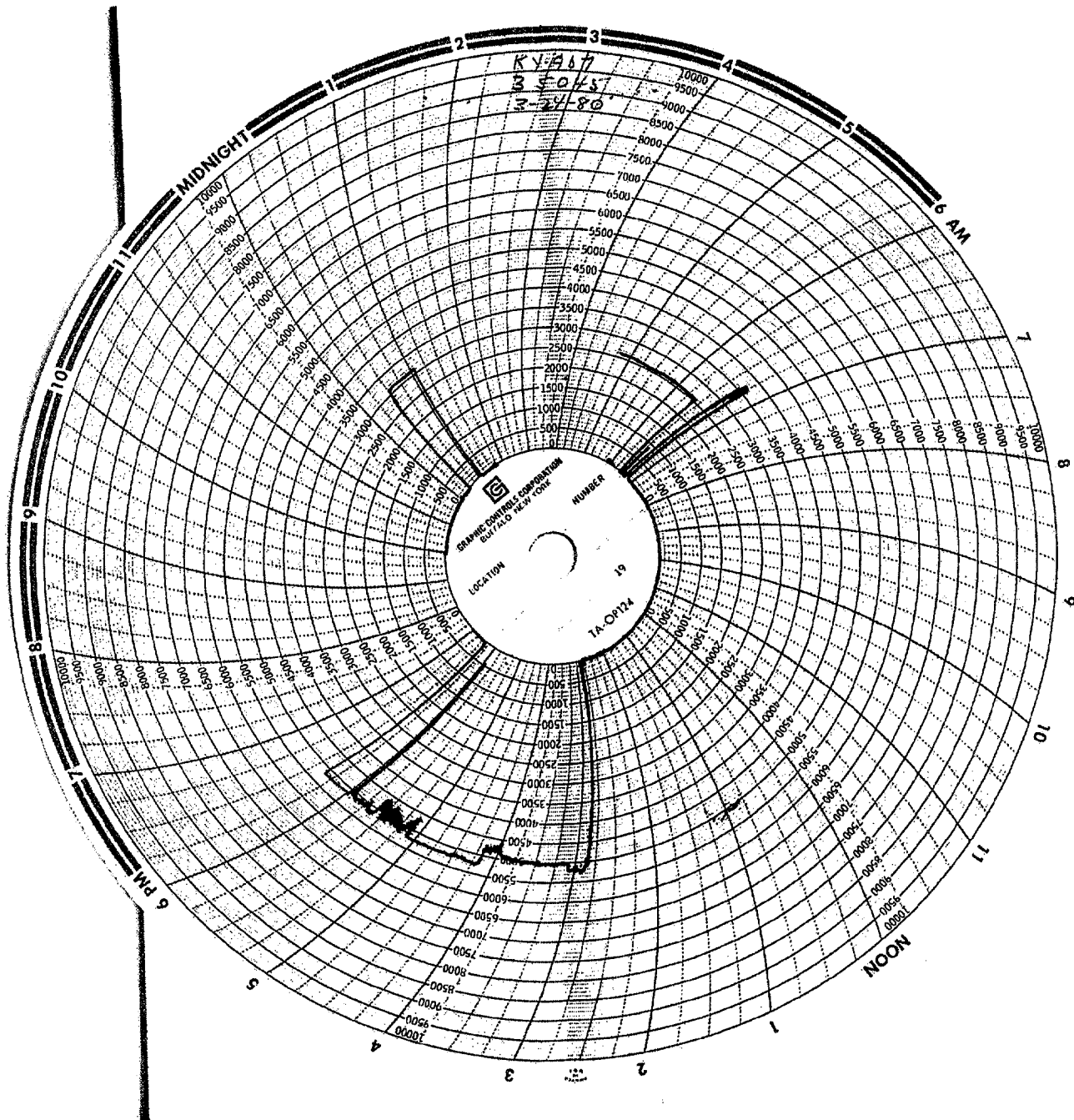
EQUIPMENT	PAGE 2 CG 03	CODE KY-907-D (D)	EST. WGT. 3480	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP Step 06/39 - After heat up Record: pH	10.0	(9.5-10.0)			
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto					
CP	24	Operator Step PB					
5	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits					
	26	Switch 3FC10 to Auto. Operator Step PB					
	27	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch					
	28	3FC20 to Remote	12.15				
	29	Operator Step PB					
	29	During strike, Record pH & time as follows:					
		SP Step					
		V-243/V-244	pH	Range	Time		
		13/46 (30 min)	9.8	9.0-10.0	12.45 A		
		14/47 (60 min)	9.8	9.0-10.0	11.15 A		
		15/48 (2 hrs)	9.8	9.0-10.0	11.13 A		
		16/49 (2 hrs 25 min)	9.8	9.0-10.0	11.40 A		
		17/50 (3 hrs Final)	8.0	7.5-8.5	11.15 A		
		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					
	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%	100.60	7-D 30-50	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 20" (244 G) water into V-356					
8	37	Turn on steam					
	38	Adj to 26" (317 G) at 178-182°F					
	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					
	42	Stir 30 min at 178-182°F for S49					
	43	Do not shut off agitator					
SV	44	When S20 complete, heat SV to 198-200°F in 5-10 min					
&	45	Close water line & discharge valves at stearate pump					
SV	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					





LO, NEW YORK





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