

244 (Automated)
CG 03 CODE KY-787-D PKG.
JAN 15 33825
EST. WGT. 1090 LBS.

STD. HRS. 8.9 TIME 11P M

14 - YC-2-B 98 4 Lot 24082, 600 #
Lot 24170, 1800 #
Lot , #

PROCESSES		APPROVED BY	
() KY-787-D	()	FWK	9/22/76
()	()	DCG	9/27/76
()	()	MTW	9/30/76
()	()		
TYPED BY			
N.E. 2/12/77			

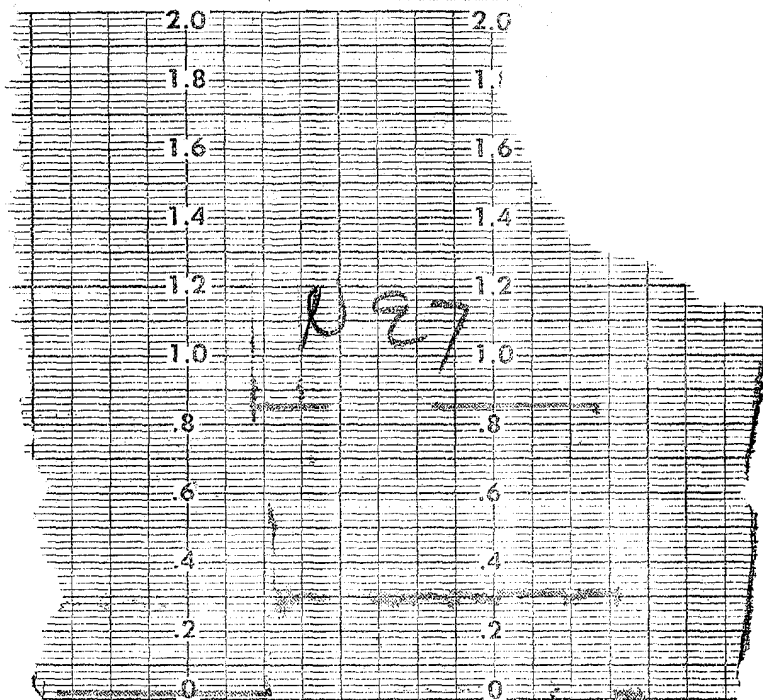
Homog #4 - 1st Pass
" " #4 - 2nd "

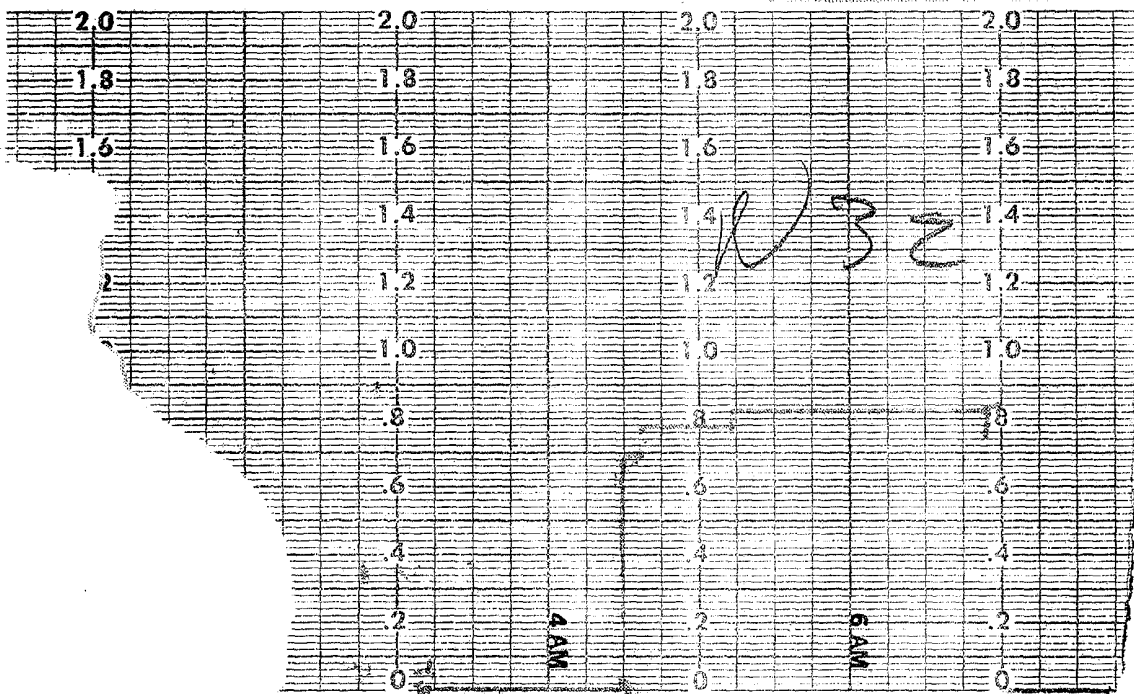
Total Wgt. - 3490#

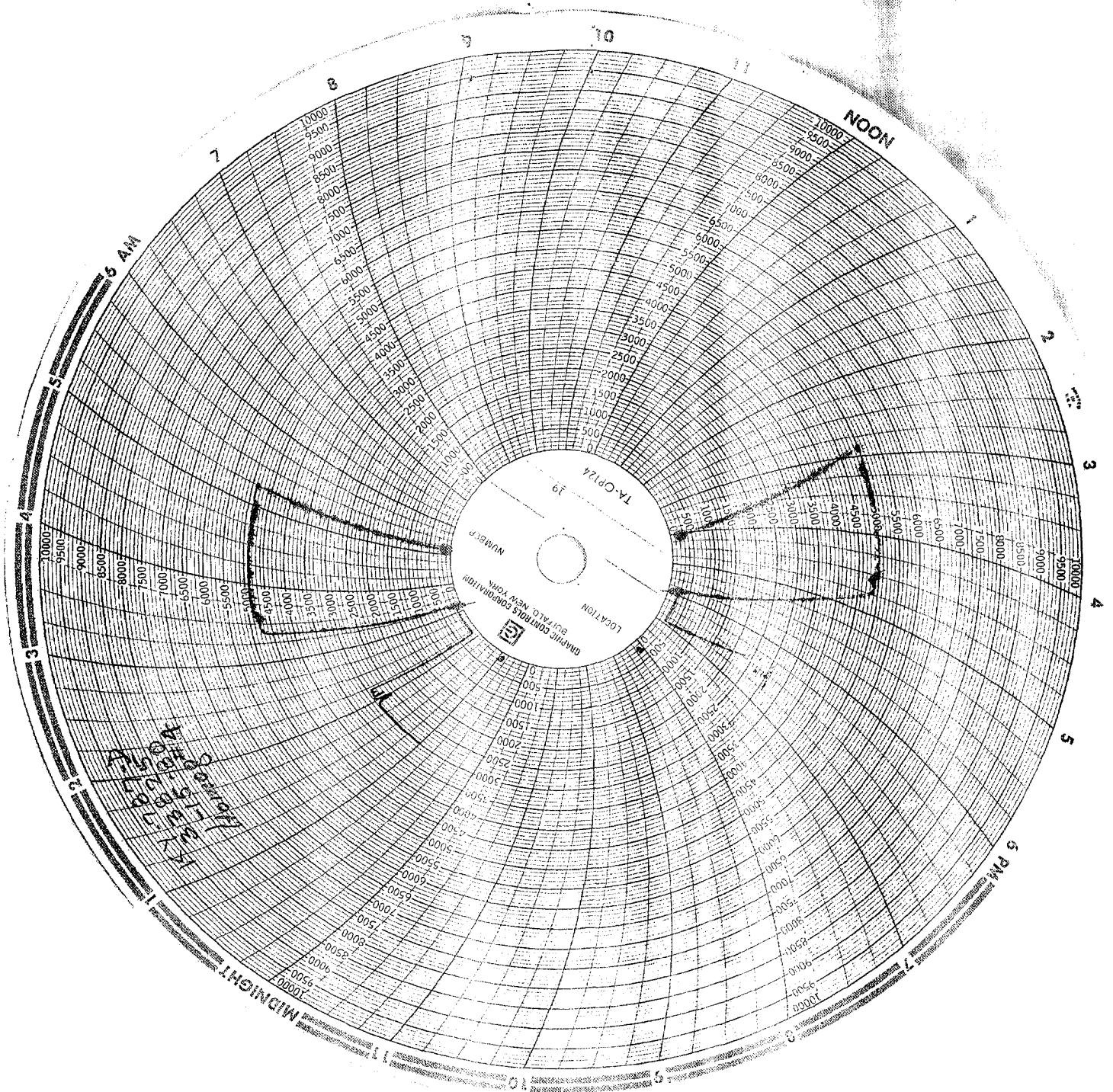
NON-BLEEDING

IPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	10" "KROLOR" - YELLOW MEDIUM			
205	1 Run 10" (922 G) water into V-203 AND ADD	30	7-D	15
1	2 Weigh in drum & pour in	320	32-D	320
	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 11:00 PM Lot 24082 600			
	Fin 12:00 AM 24170 1800			
	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 1800-2000 psi using minimum water			
	7 Record V-205 Vol 41 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514G) water into SV & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
2	Record: Time start 3:22 PM Total Min 110			
	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	12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)			
CP	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 90% - preset #1 80 Gal 15-A 160			
	b. 13LG 75% - preset #6 135 Gal 20-A 135			
	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	16 Operator Step PB			
SP	17 Record Level 2 LG 61 %. 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% (10 parts water to 1 part N-7-D)	22	7-D	11
	Siphon into SV. Record pH 11.1			
	21 Operator Step PB			

IPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT.	3490	LBS.	USE	N	ACCT.
							LBS.	CODE	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		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	7:25			
		13/46 (30 min)	<u>9.9</u>	9.0-10.0	<u>7:55 AM</u>				
		14/47 (60 min)	<u>9.9</u>	9.0-10.0	<u>8:25 AM</u>				
		15/48 (2 hrs)	<u>9.8</u>	9.0-10.0	<u>9:25 AM</u>				
		16/49 (2 hrs 25 min)	<u>9.8</u>	9.0-10.0	<u>10:50 AM</u>				
		17/50 (3 hrs Final)	<u>9.9</u>	7.5-8.5	<u>10:25 AM</u>				
		NOTE: If not as spec ^y 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>38.2G</u>							
	✓ 35	Set preset #8 to <u>38.2</u> G from S 34							
302	✓ 36	Add 30" (360 G) water to V-302							
✓	✓ 37	Add & stir 2 min For S 41				Assume 50%	160	7-D	80
243	✓ 38	SP Step 17/50 - After checking pH, Operator Step PB							
	✓ 39	SIFT in 2 Bags				✓	100	128-A	100
SP	✓ 40	SP Step 23/53 - Record: pH <u>9.0</u> (3.7-4.2)							
&	✓ 41	Run in N-7 in 10-12 min & stir 5 min							
CP	✓ 42	Record: <u>9.3</u> (2.0-9.5) & if necessary adj pH 9.0-9.5							
8		& Record				Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D)				Assume 50%		7-D	
		Siphon N-7-D into SV							
	✓ 43	Operator Step PB							
	✓ 44	SP Step 29/58 Record: pH <u>9.0</u> (9.0-10.0) Time							
	✓ 45	Operator Step PB							
	✓ 46	SP Step 60 - Batch complete							
		Start	Finish	Optr					
		Time	SP Step	Time	SP Step				
		<u>12:00 AM</u>		<u>12:00 AM</u>		<u>235-301</u>			
		<u>7 AM</u>		<u>12:00 AM</u>		<u>223-272</u>			







V-244