

MAKING INSTRUCTIONS: BATCH UNIT

S V (243) (244) (AUTOMATED) C V
CG 03 CODE KY-787-D PKG

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

→ JUN 10 36066
EST WGT 1090 LBS

STD HRS 8.9 TIME 11 P M

14 YC-2-B 93 4 LOT 24464, 2050 #
LOT 24477, 500 #
LOT 24771, 50 #

PUNCHED & CHECKED

Total 2400

TOTAL WGT 3490#

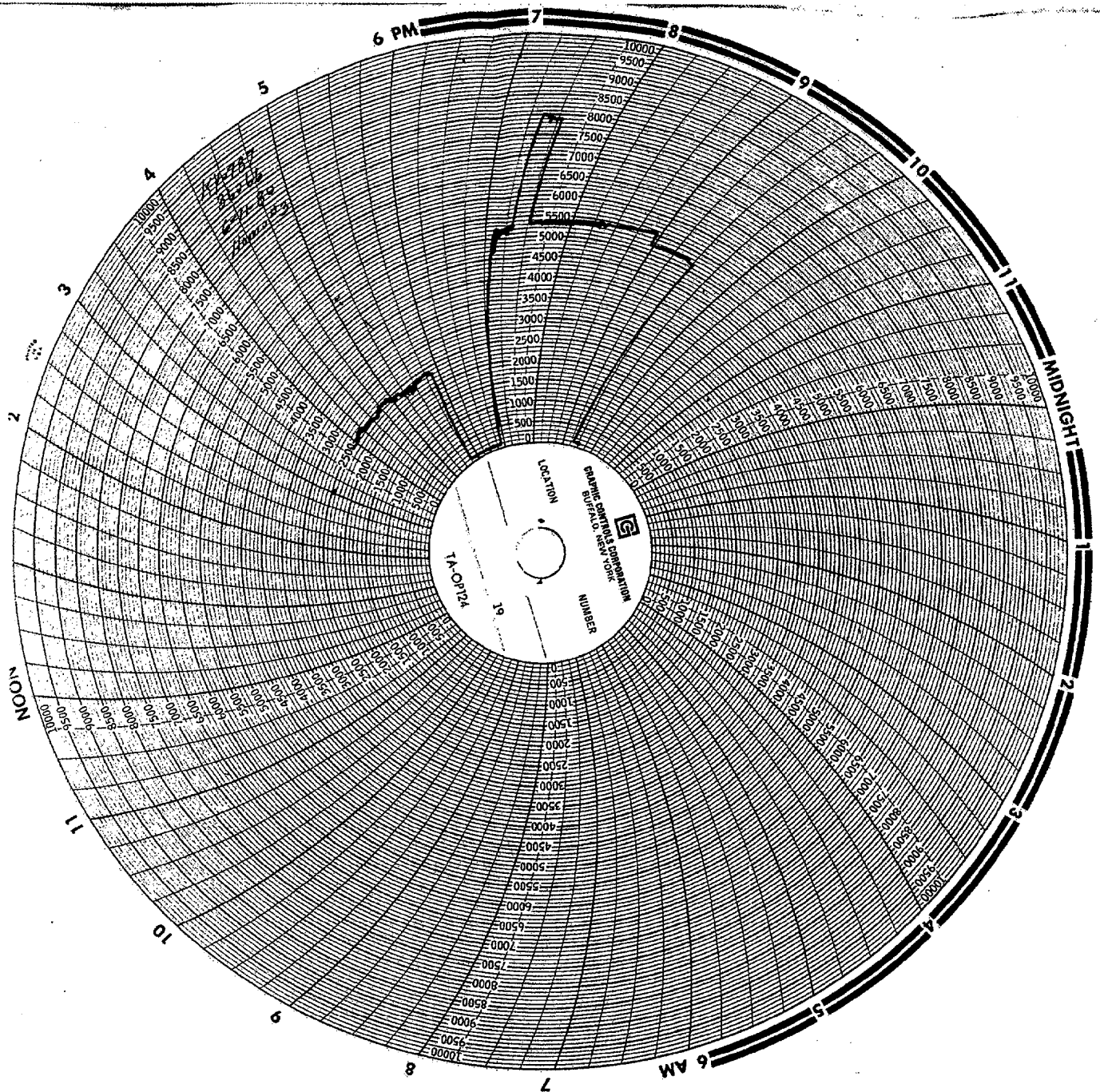
JUN 1 1967

NON-BLEEDING

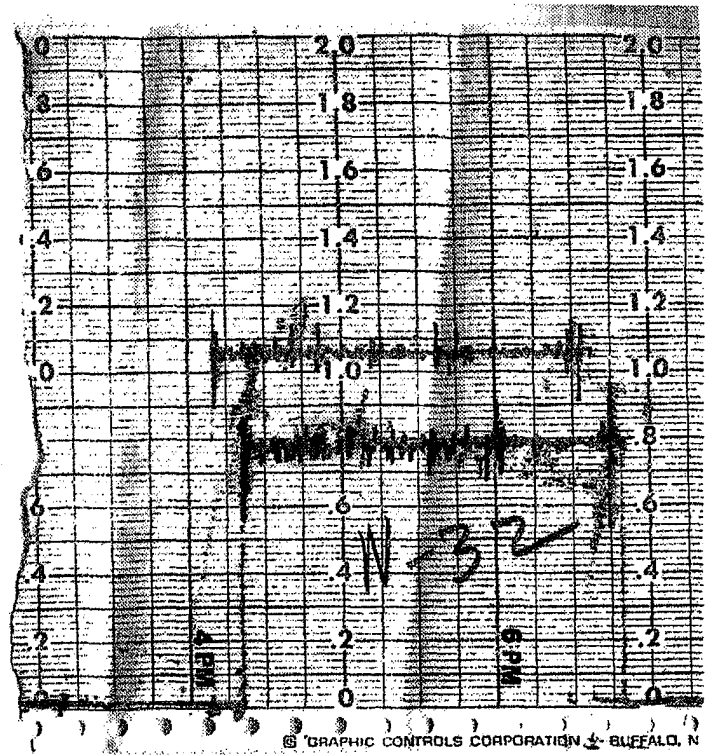
EQUIPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205 1	1 RUN 60" (992 G) WATER INTO V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN	320	32-D	320
	3 DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
	RECORD: START 12:30 P M	24464		
	FIN 2 P M	24477		
	75" (1275 G)	24771		
	4 ADD 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 " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	9 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
205 & SV 2	10 RUN 10" (514 G) WATER INTO SV START AGITATOR			
	11 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V- 274			
	RECORD: TIME START 7 P M. TOTAL MIN 150			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	12 WHEN V-205 MTY, RUN IN 5" (240 G) WATER AND PUMP THRU HOMOG AT 4800-5200 PSI			
SP & CP 3	13 SP STEP 01 - SET FORMULA SELECTOR TO POSITION #2 (V-243) OR #7 (V-244)			
	14 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
	15 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 52% - PRESET #1 80 GAL		15-A	160
	B. 13LG 58% - PRESET #6 135 GAL		20-A	135
	16 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. 8EC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM		32-D	1840
	E. 8EC20 (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	17 OPERATOR STEP PB			
	18 RECORD LEVEL 2 LG 62%. IF BELOW 35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
	19 ADD TO 48" (2470 G)			
	20 RECORD: pH 10.4			
	21 ADJ TO 11.1 - 11.3 USING N-7-D DILUTED TO 5% ASSUME 50% (10 PARTS WATER TO 1 PART N-7-D)	20	7-D	10
	22 SIPHON INTO SV. RECORD pH 11.2			
	23 OPERATOR STEP PB			

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EQUIPMENT	PAGE 2	CG 03	CODE	KY-787-D	EST. WGT.	3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH <u>9.9</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								
	28	3FC20 TO REMOTE								
	29	OPERATOR STEP PB								
	30	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>12:10</u>					
		14/47 (60 MIN)	<u>9.7</u>	9.0-10.0	<u>12:40</u>					
		15/48 (2 HRS)	<u>9.7</u>	9.0-10.0	<u>1:40</u>					
		16/49 (2 HRS 25 MIN)	<u>9.7</u>	9.0-10.0	<u>2:05</u>					
		17/50 (3 HRS FINAL)	<u>7.4</u>	7.5-8.5	<u>2:40</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	31	WHILE STRIKING, RUN 30" (234 G) WATER INTO V-339								
6	32	ADD IN 7-8 MIN					350	530-A	350	
	33	ADD TO 49" (382 G) AT 80 - 100°F								
	34	STIR 5 MIN & RECORD pH <u>10.0</u> (9.5-10.5)								
	35	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26								
	36	RECORD VOL <u>49</u> " & CALCULATE <u>49</u> "(VOL) X 0.78 = <u>38.2 G</u>								
	37	SET PRESET #0 TO <u>38.2 G</u> FROM S 34								
302	38	ADD 30" (360 G) WATER TO V-302								
7	39	ADD & STIR 2 MIN FOR S 41				ASSUME 50%	160	7-D	80	
243	40	SP STEP 17/50 - AFTER CHECKING pH, OPERATOR STEP PB								
SP	41	SIFT IN 2 BAGS					100	128-A	100	
&	42	SP STEP 23/53 - RECORD pH <u>8.4</u> (3.7-4.2)								
CP	43	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
8	44	RECORD: pH <u>8.6</u> (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5								
	45	& RECORD: pH <u>9.4</u>				ASSUME 77%		27-D		
	46	(DILUTE 10 PARTS WATER TO 1 PART N-7-D)				ASSUME 50%	<u>10</u>	7-D	<u>5</u>	
	47	SIPHON N-7 INTO SV								
	48	OPERATOR STEP PB								
	49	SP STEP 29/58 RECORD: pH <u>9.25</u> (9.0-10.0) TIME <u>3:25</u> AM								
	50	OPERATOR STEP PB								
	51	SP STEP 60 - BATCH COMPLETE								
		START		FINISH						
		TIME	SP STEP	TIME	SP STEP	OPTR				
		<u>3:PM</u>		<u>11:PM</u>		<u>54-259</u>				
		<u>11:00P</u>		<u>3:35A</u>		<u>235-323</u>				



V-243



DUP050456498

N32078.02

