

S.V.

(Automated)

C.V.

D.V.

CG 03 CODE KY-908-D PKG.

JAN 20 33929

EST. WGT. 949 LBS.

STD. HRS. TIME

7AM

PROCESSES		APPROVED BY	
() KY-908-D	(D)	EWK	12/12/77
()	()	DCG	12/14/77
()	()	MW	12/19/77
TYPED BY			
rj 1/31/78			

14 YC-3-B 93 4 Lot 2446, 2600#
14 YC-3-B 93 4 Lot
14 YC-3-B 93 4 Lot

Homog #4 - 1st Pass

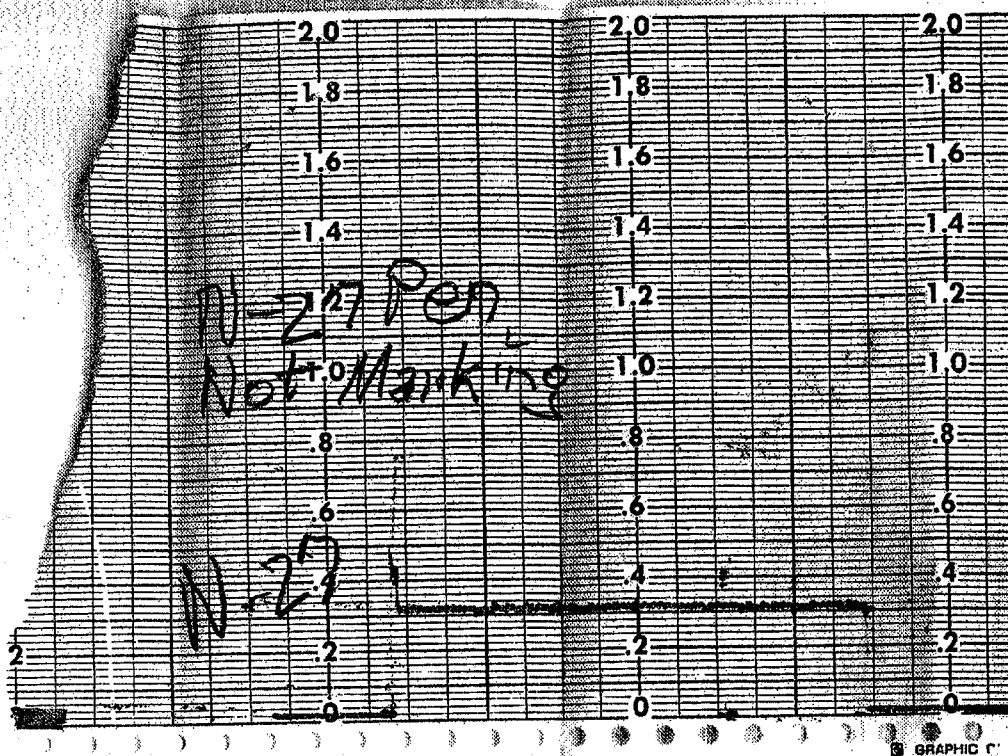
Total Wgt. 3549#

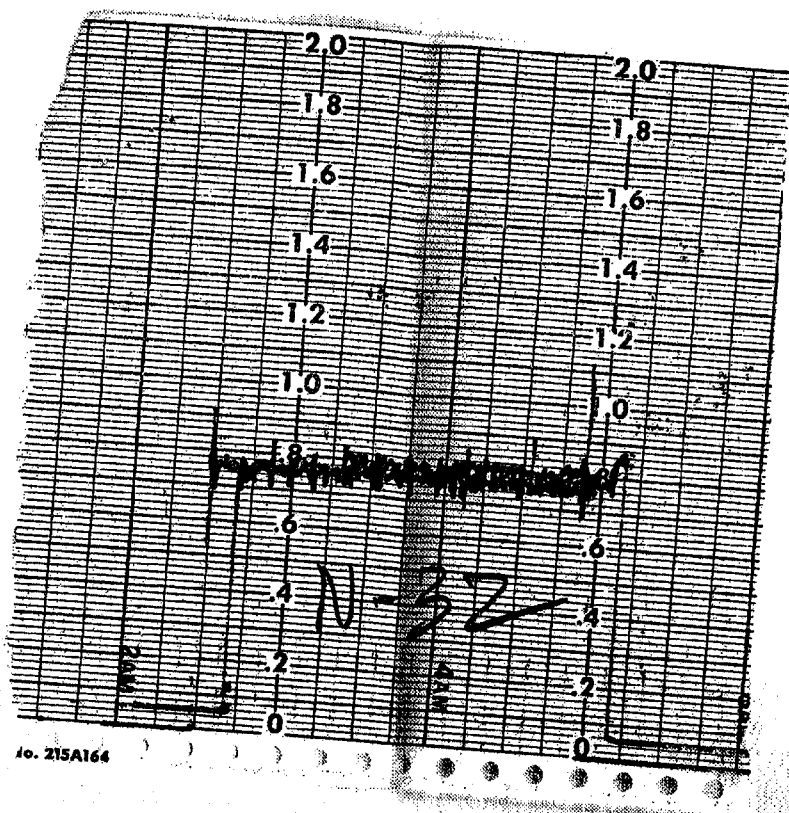
NON-BLEEDING

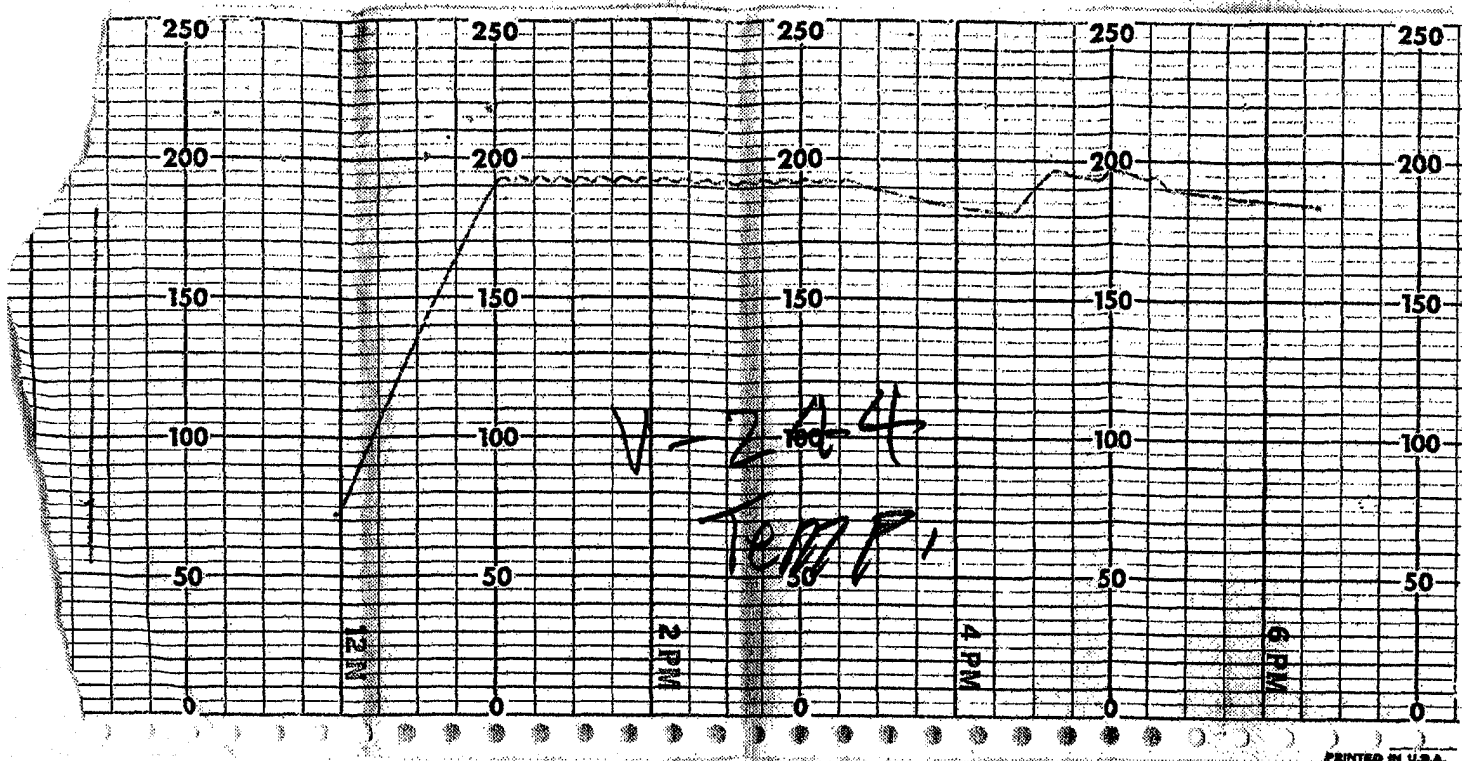
EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205 2631	80" (1290 G) KROLOR® YELLOW - LIGHT			
	1 Run 23" (360 G) water into V-203			
	2 Pour in	345	32-D	345
	3 Dump in	52 x 50	YC-3-B	2600
	Record: Start 5:45AM	2446		
	Fin 6:30AM	2600		
75" (1275 G)	80" (1360 G)			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 263			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using Minimum water 263			
	7 Record: V-205 Vol " & adj to 60" (2100-G)			
	8 Inspect Homog, strainer & clean if necessary			
205 263 SV 2	9 Run 10" (514 G) water into V-244 & start agitator			
	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
	Record: Time Start 10:30 Total Min 260			
	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 3	12 Sp Step 01 - Set Formula Selector to position #3 (V-243) or #8 (V-244)			
	13 Press SV Cam Reset PB - Set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
	14 Record levels and set Raw Material Counter #1 as follows 11LG 35% - preset #2 208 Gal		15-A	416
	15 Set strike flow controllers as follows			
	a. 3FC10 (N-27-D Controller) In Manual 0.54 GPM		27-D	180
	b. 3FC20 (N-27-D water) in Manual Local 4.4 GPM			
	c. 3FR10 (N-27-D/Water) Ratio 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1215
	e. 8FC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D/Water) Ratio 1.1			
SV SP & CP 4	16 Operator Step PB			
	17 Record Level 21G 50%. If below 35% follow solution make-up procedure for N-27-D			
	18 Adj SV to 47" (2400 G)			
	19 Record pH 10.0. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	50	7-D	25
	Siphon into SV & Record: pH 11.0			
	20 Operator Step PB			

V-244

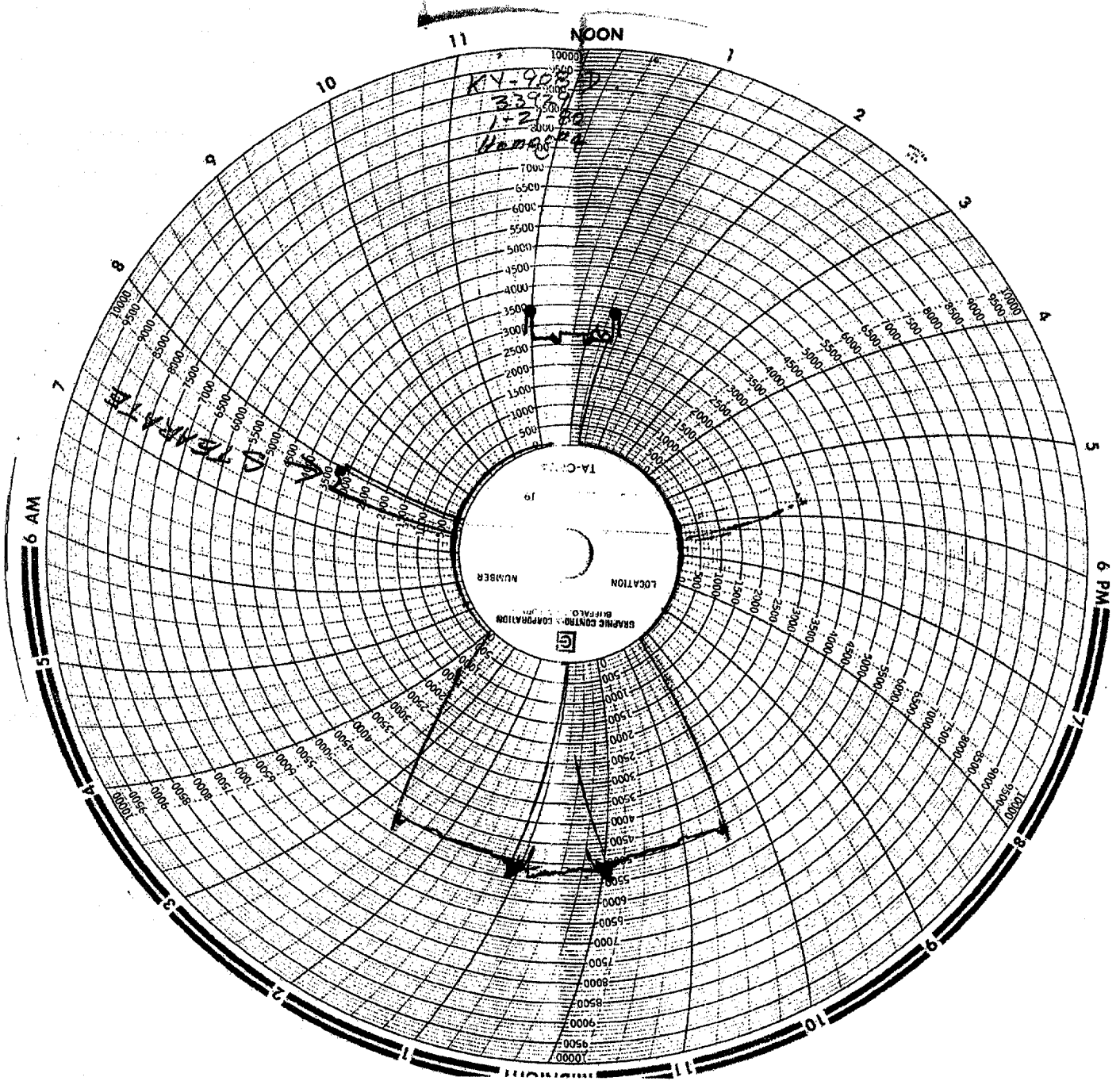
EQUIPMENT		PAGE 2 CG 03 CODE KY-908-D (D) EST. WGT. 3549	LB5.	USE LBS.	N CODE	ACCT. LBS.
SV	21	SP Step 06/39 - After heat up Record: pH 9.8 (9.5-10.0)				
SP	22	Switch 3FC20, 8FC10, 8FC20 to auto				
5	23	Operator Step PB				
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits Switch 3FC10 to Auto. Operator Step PB				
	25	SP Step 11/44 - When 3FC10, 3FC20, flows in limits switch 3FC20 to Remote				
	26	Operator Step PB				
	27	During Strike, Record pH & Time as follows:				
		SP Step				
		V-243/V-244				
		13/46 (30 min) pH 9.6 Range 9.3-10.0 Time 3:55 AM				
		14/47 (60 min) pH 9.6 Range 9.3-10.0 Time 4:25 AM				
		15/48 (2 hrs) pH 9.8 Range 9.3-10.0 Time 5:55 AM				
		16/49 (2 hrs 25 min) pH 9.8 Range 9.3-10.0 Time 6:20 AM				
		17/50 (Final 3 hrs) pH 9.1 Range 7.5- 8.5 Time 6:55 AM				
		Note: (1) If pH not as specified notify Supervisor & note in Log (2) If final pH is above 8.5 adj to 7.5-8.5				
		& Record: pH 8.3 Assume 78%				
	28	Sift in		16 50	27-D 128-A	50
	29	Add 17" (208G) water to V-302 314				
3146	30	Add & stir 2 min for S57 Assume 50%		100	7-D	50
PT	31	During Strike pump into PT		312	169-A	312
7	32	Pump in		36	155-A	36
	33	Pump in		36	160-A	36
	34	Stir 10 min with lightning mixer for S38				
356	35	During strike Run 20" (244G) water into V-356				
8	36	Turn on steam				
	37	Adj to 250" (317G) at 178-182°F 81-82°C				
	38	Pump PT mixture from S34 thru undersurface Distributor AFAP				
	39	Rinse PT with hot water from hot water mixer & pump in				
	40	Shutoff pump 81-82°C				
	41	Stir 30 min at 178-182°F for S48				
	42	Do not shut off Agitator				
SV	43	When S28 complete, heat SV to 198-200°F in 5-10 min				
&	44	Close water line & Discharge valves at stearate pump				
SP	45	Open V-356 Discharge valves to stearate pump inlet				
9	46	Open water valve at stearate pump & run water thru Homog at 2900-3100PSI to sewer				
	47	While Homog water at 2900-3100 PSI, open Homog Discharge valve to SV & close valve to sewer				
	48	Immediately open stearate pump Discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 PSI maintain SV at 198-200 F				
	49	While Homog V-356 to SV, shut off water valve at stearate pump ASAP				
	50	When Homog complete, Rinse in V-356 with hot water from hot water mixer				
	51	When S50 complete turn off Homog & stearate pump				
	52	Stir 5 min at 198-200°F				
	53	Shut off steam				





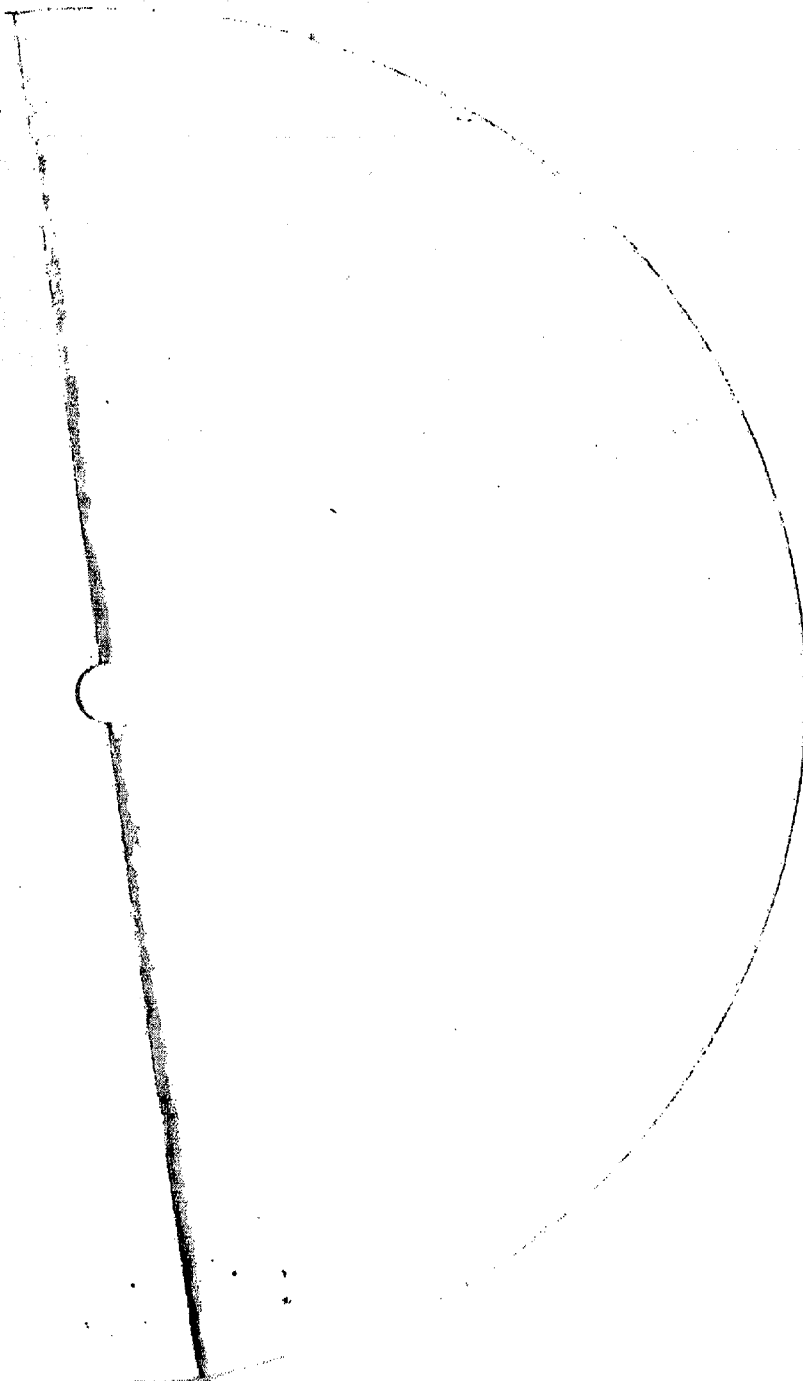


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