

243

MAY 22 1980

MAKING INSTRUCTIONS: BATCH UNIT

s.v. (243, 244, Automated

C.V.

D.V.

CG 03 CODE KY-781-D PKG.

EST. WGT. 1128 LBS.

STD. HRS.

TIME

11A M

MAY 30 1980

14 YC-3-B 93 4

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Total Wgt. 4428# (Req

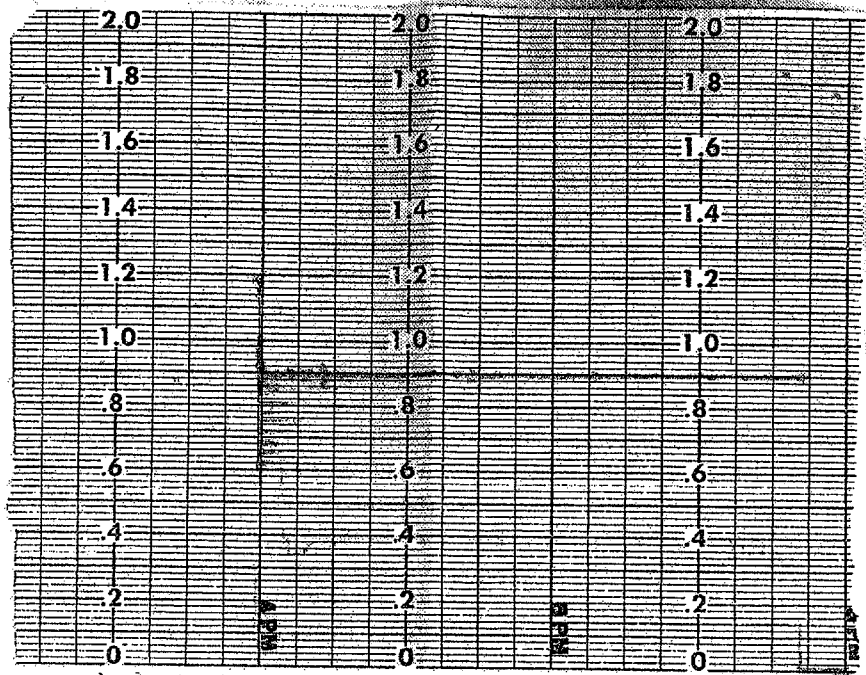
PUNCHED & CHECKED

PROCESSES	APPROVED BY
() KY-781-D (N)	FWP 101378
()	AMJ 101378
()	
()	
TYPED BY	
EMW101378	

Homog #4-127 Pass
11 #3-2nd
Homog #4-2nd
NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	1 Run 60" (992 G) water in V-203 & add	Assume 50%	36	7-D 18
&	2 Weigh in drum & pour in		442	32-D 442
205	3 Dump in & stir 5 min	Lot	66 x 50	YC-3-B 3300
1	Record: Start 8:15 AM	24415	40	
	Fin 9:30 AM	24414	26	
	75" (1225 G) 2400-2600			
	4 Adj to 80" (1360 G) & Record: pH 10.7 (10.5-11.5)			
	5 Pump V-203 thru Homog #4 at 4800-2200 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 42" & adj to 45" (1662 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
205	9 Run 12" (200 G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-	243		
SV	Record: Time Start 1:00 PM, Total Min 135			
2	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	12 SP Step 01 - Set Formula Selector to position #1 (V-243) or #6 (V-244)			
3	13 Press SV Cam Reset PB-Set 22TC in Auto Remote (Temperature is set at 190-194°F)			
X	14 Record levels and set Raw Material Counter #1 as follows:			
	a) 11L6 38% - preset #3 187 Gal		15-A	374
	15 Set strike flow controllers as follows:			
	a) 3FC10 (N-27-D Controller) in Manual 0.9 GPM		27-D	373
	b) 3FC20 (N-27-D Water) in Manual Local 6.3 GPM			
	c) 3FR10 (N-27-D / Water Ratio) 0.7			
	d) 8FC10 (N-32-D Controller) in Manual 1.20 GPM		32-D	2527
	e) 8FC20 (N-32-D Water) in Manual Local 5.4 GPM			
	f) 8FC20 (N-32-D Water) in Remote			
	g) 8FR10 (N-32-D / Water Ratio) 0.9			
SV	16 Operator Step PB			
SP	17 Record Level 2LG 67%. If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj SV to 54" (2800 G)			
4	19 Record: pH 11.4			
	20 Adj pH to 11.4-11.6 using Assume 50%		7-D	
	(Dilute to 5% (10 parts water to 1 part N-7-D)			
	Siphon into SV. Record: pH			
	21 Operator Step PB			

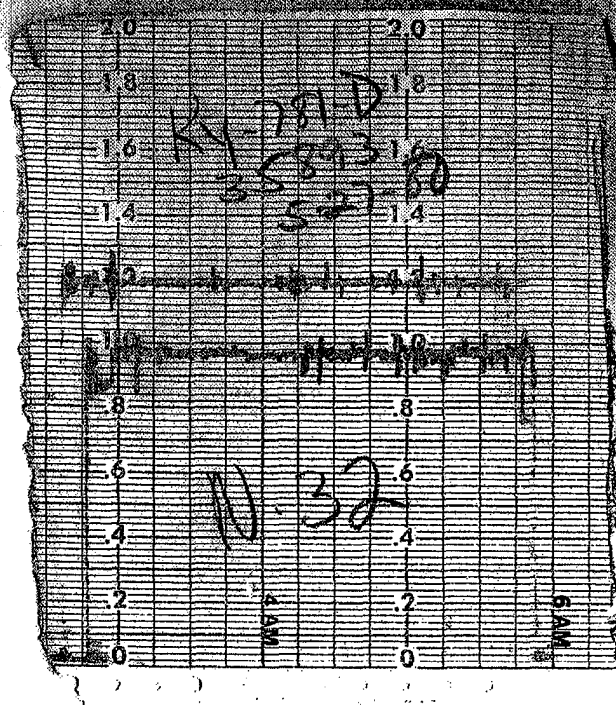
EQUIPMENT	PAGE	CG	03 CODE	KY-781-D N EST. WGT.	1128 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP Step	06/39.	After heat up Record:	pH 10.0 (9.6-10.2)			
SP	23	Switch	3FC20, 8FC10, 8FC20,	to Auto				
&	24	Operator Step	PB					
CP	25	SP Step	10.43 - When 3FC20, 8FC10, 8FC20 water flow in limits	switch 3FC10 to Auto. Operator Step PB				
5	26	SP Step	11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20	to Remote. Operator Step PB				
	27	During Strike,	Record pH & Time as follows:					
		SP Step	pH	Range	Time			
		13/41 (30 min)	9.9	9.3-10.0	7:15 PM			
		14/47 (60 min)	9.8	9.3-10.0	8:20 PM			
		(2 hrs)	9.8	9.3-10.0	9:20 PM			
		(3 hrs)	9.8	9.3-10.0	10:20 PM			
		17.50 (Final)	7.5	7.5- 8.5	11:05 PM			
		NOTE:	If pH not as specified notify Supervisor & note in log. If final pH is above (8.5) Adj to pH 7.5-8.5	M . %			27-D	
V-302	28	Add	31" (379 G) water to V-302					
6	29	Add & stir	5 min	Assume .50%	124	7-D	62	
SV	30	SP Step	17/50 after checking pH.	Operator PB				
SP	31	SP Step	23/53 Record:	pH 3.4 (3.3-3.7)				
&	32	If necessary adj	pH (DOWN ONLY) Record:	pH		15-A		
CP		NOTE:	Dissolve extra N-15-A in water at 110-120°F in drum					
7		Use ±30 Gal	of water to 50# N-15-A. Stir SV 5 min					
		after each addition						
	33	Sift in				150	128-A	150
	34	Run in	N-7-D from S 29 & stir 5 min					
	35	Record:	pH 4.2 (4.2-4.4)					
	36	If necessary adj	pH to (4.2-4.4) with dilute N-7-D (10 parts H ₂ O to 1 part N-7-D) or N-27					
				M . %			27-D	
				Assume 50%			7-D	
		Siphon (if N-7-D)	into SV. Record:	pH				
	37	Operator Step	PB					
	38	SP Step	24/54 - Add N-978-A & stir 15 min			20	978-A	20
	39	Operator Step	PB					
	40	SP Step	60 - Batch Complete + Pumped To V240					
		START	FIN	OPTR				
		TIME	SP STEP	TIME	SP STEP			
		7:30 AM		7:45 AM				
		10:00 AM		3:00 PM		235-322		
		3:00 PM	-	11:00 PM	-	282.33		
		11 PM		12:10 A		120-126		

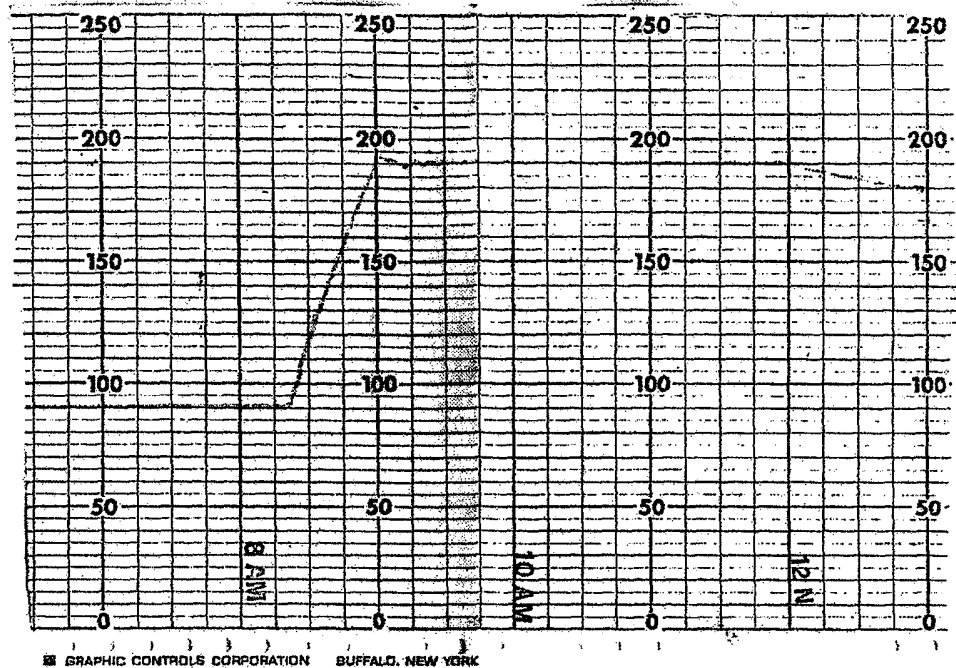


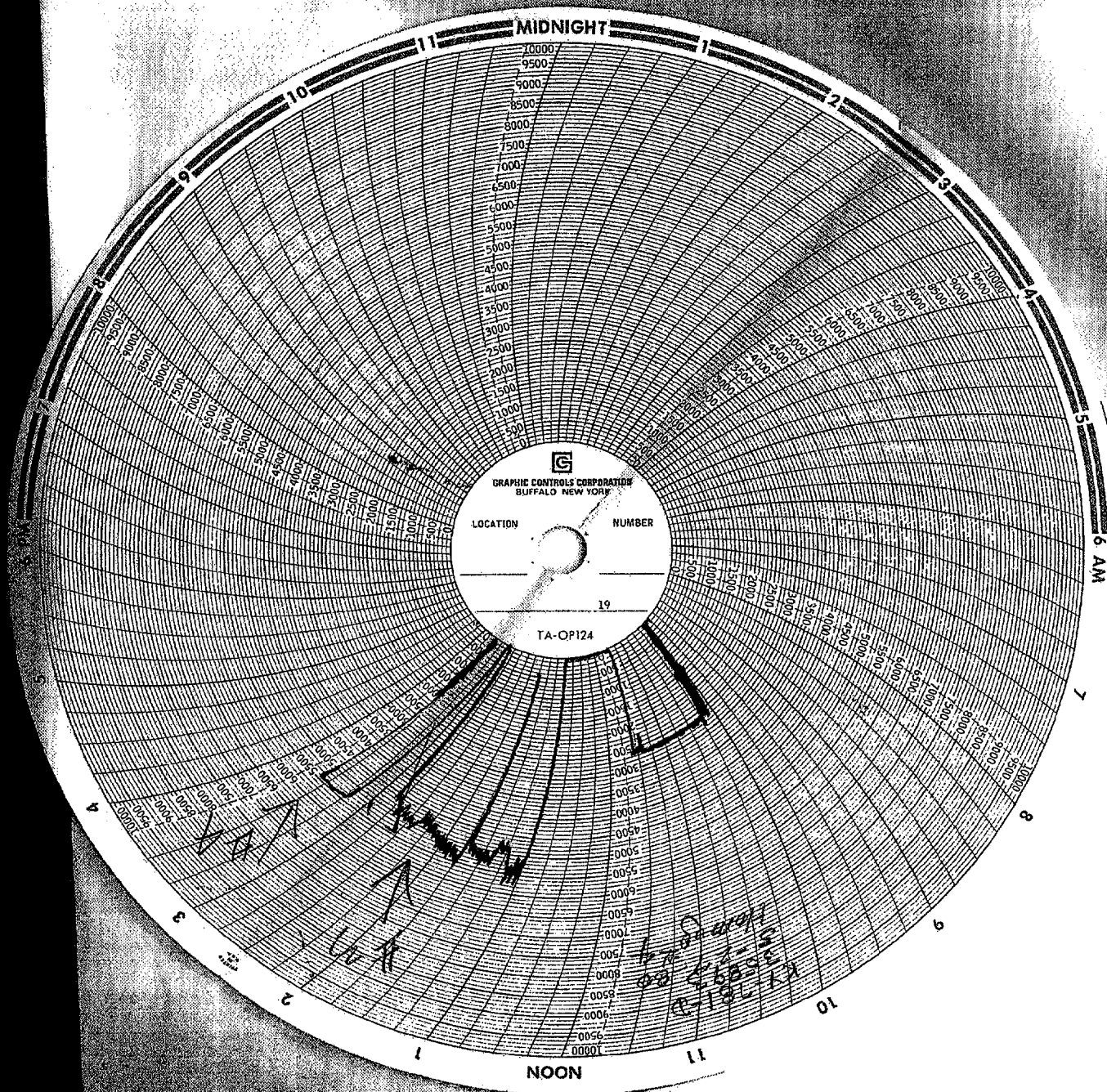
GRAPHIC CONTROLS CORP

N32212.01

DUP050457098







N32212.02

DUP050457101