

MAR 2 1980

MAKING INSTRUCTIONS: BATCH UNIT

243 (Automated)

C.V.

D.V.

CG 03 CODE KY-795-D PKG.

MAR 26 35082

1ST. WGT 1110 LBS

STD HRS 8.2 TIME

14 YC-2-B 93 4 Lot

14 YC-2-B 93 4 Lot 24462, 2000#

14 YC-2-B 93 4 Lot 24463, 1500#

Total Wgt. 4612#

APR - 8 1980

PROCESSES		APPROVED BY
()	KY-795-D (H)	EWK 10-05-76
()	()	DCG 10-07-76
()	()	MTW 10-11-76
()	()	FWP 12-22-78
TYPED BY		
emw122278		

NON-BLEEDING

INSTRUMENT	NAME: KROLOR® YELLOW MEDIUM	USE LBS.	N CODE	ACCT LBS.
203	1 Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED			
8	2 Weigh in drum & pour in	475	32-D	475
1	3 Dump in & stir 5 min	Lot 70 x 50	YC-2-B	3500
	Record: Start	24462		
	Fin	24463		
	75" (1275 G)			
	4 Adj to 78" (1328 G)			
	5 Pump V-203 thru Homog at 2400-2600 psi into V-205			
	When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	6 Record: V-205 Vol 263" & adj to 51" (1874 G)			
	7 Inspect Homog strainer & clean if necessary			
	8 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
	9 Run 10" (514 G) water into V-243 & start agitator			
	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time Start 9:35P Total Min 180			
	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. Rinse in using Hot Water			
SP & CP	12 SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (V-244)			
3	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:			
	a. 11 LG 66 % - preset #1	104 Gal	15-A	208
	15 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual	0.95 GPM	27-D	394
	b. 3FC20 (N-27-D Water) in Manual Local	7.7 GPM		
	c. 3FR10 (N-27-D / Water Ratio)	0.8		
	d. 8FC10 (N-32-D Controller) in Manual	1.27 GPM	32-D	2675
	e. 8FC20 (N-32-D Water) in Manual Local	6.2 GPM		
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D / Water) Ratio	1.0		
SV	16 Operator Step PB			
SP & CP	17 Record Level 2LG 89 % if below 35% follow solution make-up procedure for N-27-D			
4	18 Adj SV to 68" (3495 G)			
	19 Record: pH 10.6 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D) Assume 50%	40	7-D	20
	Siphon N-7-D into SV & Record: pH 11.2			
	20 Operator Step PB			

N32468

V-243

EQUIPMENT		PAGE 2 CG 03 CODE KY-795-D (H) EST. WGT. 4612 LBS.				USE LBS.	N CODE	ACC LBS.
SV SP & CP 5	21	SP Step 06/39 - After heat up Record: pH <u>9.9</u> (9.5-10.0)						
	22	Switch 3FC20, 8FC10, 8FC20, to Auto						
	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	pH	Range	Time	2:55		
		13/46 (30 min)	9.7	9.0-10.0	3:25			
		14/47 (60 min)	9.7	9.0-10.0	3:55			
		15/48 (2 hrs)	9.7	9.0-10.0	4:55			
		16/49 (3 hrs)	9.7	9.0-10.0	5:55			
		17/50 (Final)	7.5	7.5-8.5	6:40			
		NOTE: If not as specified notify Supervisor & note in log						
		If final pH above 8.5 adj to 7.5-8.5						
		& Record: pH				Assume 77%	27-D	
Drum 7	28	Weigh into 55 Gal Drum				Assume 50%	56	7-D 28
	29	Fill with water & stir 2 min						
SV SP & CP 8	30	SP Step 17/50 - After checking pH, Operator Step PB						
	31	Step 23/53 - Record: pH <u>3.7</u> (3.3-3.7)						
	32	If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH					15-A	
	33	Sift in 3 bags				150	128-A	150
	34	Siphon in N-7-D from S 29 in 10-12 min & stir 5 min						
	35	Record: pH <u>4.0</u> (4.0-4.2) & if necessary adj to pH 4.0-4.2						
		& Record: pH				Assume 77%	27-D	
		(Dilute 10 parts water to 1 part N-7-D)				Assume 50%	7-D	
		Siphon N-7-D into SV						
	36	Operator Step PB						
	37	SP Step 24/54 - Pour in & stir 15 min				22	978-A	22
	38	Operator Step PB						
	39	SP Step 60 - Batch complete						
		START FINISH OPTR						
		TIME SP STEP	TIME SP STEP					
		3:00 P	11:00 P	2:55-2:59				
		11 PM	7 AM	4:38-2:52				
		7:00 am	9:40 AM	101				

