MAKING INSTRUCTIONS: BATCH UNIT

V. (243) ~~244~~ (Automated) C.V. C.V.

CG 03 CODE KY-907-D PKG. _____

→ JAN 18 33723

EST. WGT. 1080 LBS.

STD. HRS. _____ TIME 7:A M

PROCESSES		APPROVED BY
( ) KY-907-D	(D)	EWK 12/12/77
( )	( )	DCG 12/13/77
( )	( )	MW 12/15/77
( )	( )	
TYPED BY		
rj 2/3/78		

14 YC-2-B 93 4 Lot 24076. 2000#
14 YC-2-B 93 4 Lot _____ #
14 YC-2-B 93 4 Lot 24171. 400#

Homog #3 - 2nd Pass

Total Weight - 3480#

NON-BLEEDING

EQUIPMENT		NAME: ~~60" (990 G)~~ KROLOR® - YELLOW MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & ~~205~~ 1 ~~-263~~	1	~~Run 33" (560 G)~~ water into V-203 AND ADD	30	70	15
	2	Pour in	320	32-D	320
	3	Dump in Lot	48 x 50	YC-2-B	2400
		Record: Start 3:20 P/M 24076	2000		
		Fin 4:30 P/M			
		~~780" (1360 G)~~ 24171	400		
~~75"(1275 G)~~	4	~~Adj to 70" (1200 G)~~ 2400-2600			
	5	~~Pump V-203 thru Homog #3 at 1800-2200 psi into V-205~~ V-263			
	6	~~When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water~~			
	7	~~Record V-205 Vol~~ 40 " & adj to 60" (2100 G)			
	8	~~Inspect Homog strainer & clean if necessary~~			
~~205~~ & SV 2 V-263	9	~~Run 10" (514 G) water into SV & start agitator~~			
	10	~~Pump V-205 thru Homog at 4800-5200 psi into V-~~			
		Record: Time Start 12:35 Total Min 1-25			
		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~~ #2 (V-243) or #7 (V-244)			
	13	~~Press SV Cam Reset PB-set 22TC in~~ Auto Remote (Temperature is set at 190-194°F)			
	14	~~Record levels and set Raw Materials Counter #1 as follows:~~			
		11LG 50 % - preset #1 80 Gal		15-A	160
	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 SP & CP 4	16	~~Operator Step PB~~			
	17	~~Record Level 2 LG~~ 44 %. If below 35% follow solution make-up procedure for N-27-D			
	18	~~Adj to 48" (2470 G)~~			
	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)	26	7-D	13
		Siphon into SV Record: pH 11.2			
	21	Operator Step PB			

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EQUIPMENT		PAGE 2 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV SP & CP 5	22	SP Step 06/39 - After heat up Record: pH 10.0 (9.5-10.0)			
	23	Switch 3FC20, 8FC10, 8FC20 to Auto			
	24	Operator Step PB			
	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits 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	4:40/AM		
	28	During strike, Record pH & time as follows:			
		SP Step V-243/V-244 pH Range Time 13/46 (30 min) 9.8 9.0-10.0 5:10 14/47 (60 min) 9.8 9.0-10.0 5:40 15/48 (2 hrs) 9.8 9.0-10.0 6:40 16/49 (2 hrs 25 min) 9.6 9.0-10.0 7:05 17/50 (3 hrs Final) 8.3 7.5- 8.5 7:40			
		NOTE:(1) If pH not as specified notify Supervisor & note in log (2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH			
	29	Sift in Assume 78%	50	27-D 128-A	50
302 6	30	Add 17" (208 G) water to V-302			
	31	Add & stir 2 min for S58 Assume 50%	100	7-D	50
PT 7	32	During strike pump into PT	318	169-A	318
	33	Pump in	36	155-A	36
	34	Pump in	36	160-A	36
	35	Stir 10 min with lightning mixer for S39			
356 8	36	During strike run ~~28~~ 24" (244 G) water into V-356			
	37	Turn on steam			
	38	Adj to ~~26 7/8~~"(317 G) at ~~178-182°F~~ 81-82°C			
	39	Pump PT mixture from S35 thru undersurface Distributor AFAP			
	40	Rinse PT with hot water from hot water mixer & pump in			
	41	Shut off pump 81-82°C			
	42	Stir 30 min at ~~178-182°F~~ for S49			
	43	Do not shut off agitator			
SV & SP 9	44	When S29 complete, heat SV to 198-200°F in 5-10 min			
	45	Close water line & discharge valves at stearate pump			
	46	Open V-356 Discharge valves to stearate pump inlet			
	47	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer			
	48	While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & close valve to sewer			
	49	Immediately open stearate pump discharge valve, Turn on pump & Homog V-356 to SV at 2900-3100 psi Maintain SV at 198-200°F			
	50	While Homog V-356 to SV, shut off water valve at Stearate pump ASAP			
	51	When Homog complete, rinse in V-356 with hot water From hot water mixer			

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EQUIPMENT		PAGE 3 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV & SP 9 Con'T	52	When S51 complete turn off Homog & stearate pump			
	53	Stir 5 min at 198-200°F			
	54	Shut off steam			
	55	When S54 complete, Operator PB			
	56	SP Step 23/53 Record pH 3.6 (3.3-3.7)			
	57	If necessary adj pH to (3.3-3.7) (DOWN ONLY) Record: pH ____	____	15-A	____
		NOTE: Dissolve extra N-15-A in water at 110-120°F in drum			
		Use ± 30 gal of water to 50# N-15-A. Stir SV 5 min			
		after each addition			
	58	Run in N-7-D from S31 in 10-12 min & stir 5 min			
	59	Record: pH 8.6 (4.2-4.4) & if necessary adj pH 4.2-4.4			
		& Record: pH 4.2 Assume 50%	____	7-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 78%	60	27-D	60
		Siphon N-7-D into SV			
	60	Operator Step PB			
	61	Operator Step PB			
	62	SP Step 60 - Batch complete			

START Time	START SP Step	FINISH Time	FINISH SP Step	OPTR
11100P		7:00AM		235-323
7Am		9Am		282-381

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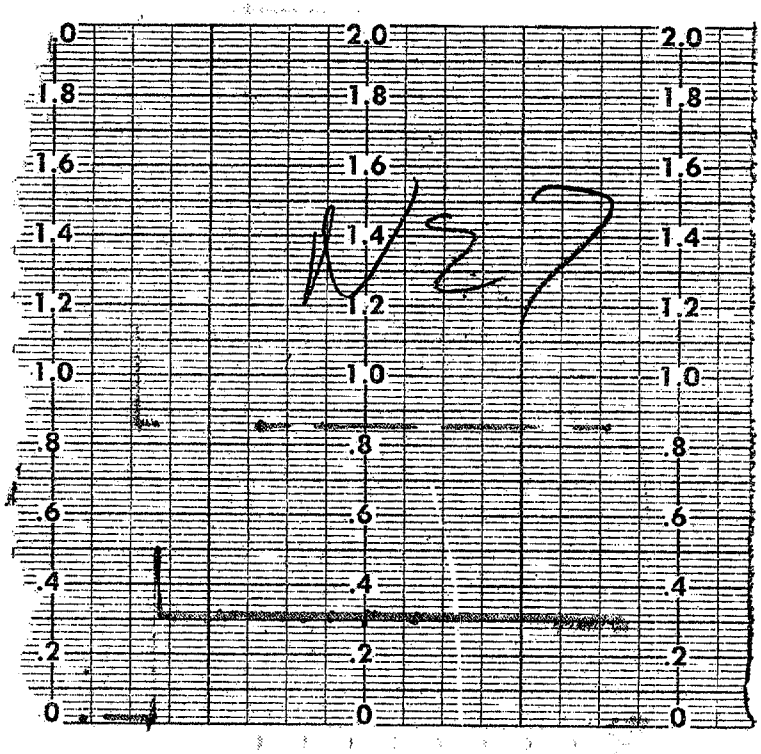

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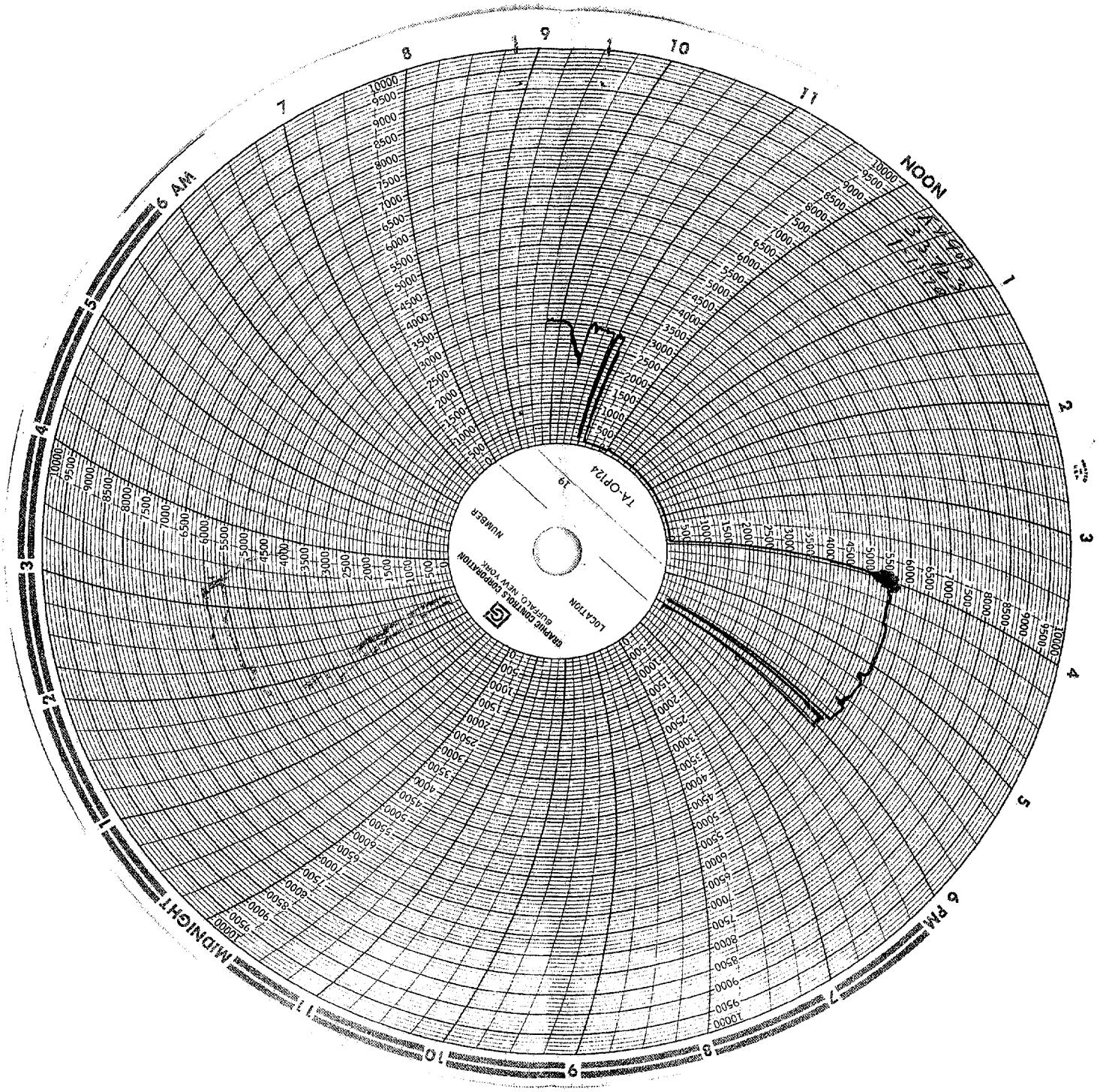

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