

S.V.

243,244

(Automatic)

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

CG 03 CODE KY-908-D PKG.

EST. WGT. JAN 30 34105
949 LBS.

STD. HRS. TIME M

14 YC-3-B 93 4 Lot 24423 3000
 14 YC-3-B 93 4 Lot 2563 600
 14 YC-3-B 93 4 Lot _____

Total Wgt. 3549#

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

V-244 MIT 10:20 PM

Homog #2 - 2nd Pass

NON-BLEEDING

EQUIPMENT	NAME:	USE	N	ACCT.
		LBS.	CODE	LBS.
203	60" (3906) KROLOR® YELLOW - LIGHT			
205	1 Run 23" (360 G) water into V-203			
205	2 Pour in	345	32-D	345
205	3 Dump in			
205	Record: Start 8:AM. Lot 24423 3000	52 x 50	YC-3-B	2600
205	Fin 9:AM. 2563 600			
205	7" (12756)			
205	8" (1360 G)			
205	4 Adj to 70" (1200 G) 2400-2600			
205	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 263			
205	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using Minimum water > 6.3			
205	7 Record: V-205 Vol " & adj to 60" (2100-G)			
205	8 Inspect Homog, strainer & clean if necessary			
205	9 Run 10" (514 G) water into V-244 & start agitator			
205	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
205	Record: Time Start 10:25 P Total Min 130			
205	Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
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 #3 (V-243) or #8 (V-244)			
SP & CP	13 Press SV Cam Reset PB - Set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
SP & CP	14 Record levels and set Raw Material Counter #1 as follows 21LG 0.4 % - preset #2 208 Gal			
SP & CP	15 Set stroke flow controllers as follows			
SP & CP	a. 3FC10 (N-27-D Controller) in Manual 0.54 GPM			
SP & CP	b. 3FC20 (N-27-D water) in Manual Local 4.4 GPM			
SP & CP	c. 2FR10 (N-27-D/Water) Ratio 0.8			
SP & CP	d. 3FC10 (N-32-D Controller) in Manual 0.72 GPM			
SP & CP	e. 3FC20 (N-32-D Water) in Manual Local 3.9 GPM			
SP & CP	f. 3FC20 (N-32-D Water) in Remote			
SP & CP	g. 2FR10 (N-32-D/Water) Ratio 1.1			
SV	16 Operator Step PB			
SV	17 Record Level 21LG 0.2 % If below 35% follow solution make-up procedure for N-27-D			
SV	18 Adj SV to 47" (2400 G)			
SV	19 Record pH 10.2. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
SV	Siphon into SV & Record: pH 11.1			
SV	20 Operator Step PB			

N 27585

V-244

EQUIPMENT		PAGE 2 CG 03 CODE KY-908-D (D) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT LBS.
SV	21	SP Step 06/39 - After heat up Record: pH <u>9.9</u> (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: <u>5:35 Am</u>			
		SP Step			
		V-243/V-244			
		13/46 (30 min) pH <u>9.1</u> Range 9.3-10.0 Time <u>6:05 Am</u>			
		14/47 (60 min) <u>9.7</u> 9.3-10.0 <u>6:35 Am</u>			
		15/48 (2 hrs) <u>9.7</u> 9.3-10.0 <u>7:35 Am</u>			
		16/49 (2 hrs 25 min) <u>9.6</u> 9.3-10.0 <u>8:00 Am</u>			
		17/50 (Final 3 hrs) <u>8.8</u> 7.5- 8.5 <u>8:35 Am</u>			
		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 <u>8.1</u> Assume 78%			
	28	Sift in <u>31" (3796)</u>	<u>10</u>	27-D	<u>5</u>
			50	128-A	50
302	29	Add <u>17" (2086)</u> water to V-302 <u>314</u>			
314	30	Add & stir 2 min for S57 Assume 50%	<u>100/60</u>	7-D	<u>50.8</u>
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 <u>20" (244G)</u> water into V-356			
8	36	Turn on steam			
	37	Adj to <u>261" (317G)</u> at <u>178-182°F</u> <u>81-82°C</u>			
	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 <u>81-82°C</u>			
	41	Stir 30 min at <u>178-182°F</u> 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			





