

JUN 27 1980

MAKING INSTRUCTIONS: BATCH UNIT

SV 243,244 (AUTOMATED)

CV

DV

CG 03 CODE KY-787-D

PKG

PUNCHED & CHECKED

EST WGT 1090

LBS

JUN 10 1980

STD HRS 8.9

TIME

3P M

14 YC-2-B 93 4

LOT 24165, 2400 #

LOT #

LOT #

PROCESSES		APPROVED BY	
() KY-787-D	Q	EWK	9-22-76
()	()	DCG	9-27-76
()	()	MTW	9-30-76
()	()		
RE TYPED BY			
CJH 2-8-80			

Homog #4 - 1st Pass

TOTAL WGT 3490#

NON-BLEEDING

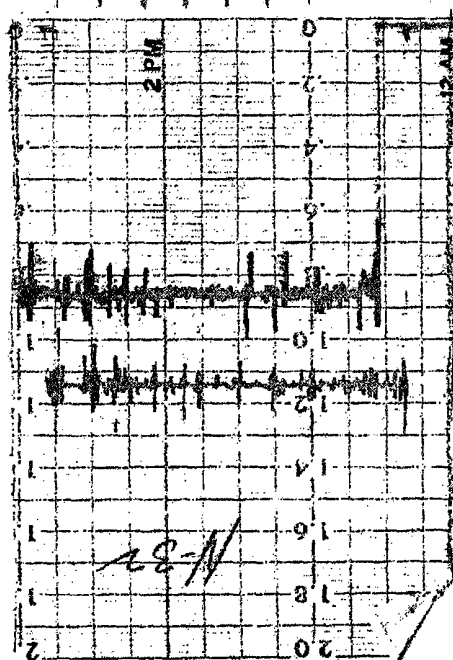
QUIPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205 1	1 RUN 60" (992 G) WATER INTO V-203 <i>Set agitator at high speed</i>			
	2 WEIGH IN DRUM & POUR IN	320	32-D	320
	3 DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
	RECORD: START LOT 24165	2400		
	FIN			
	4 ADJ TO 70" (1200 G) <i>2400-2600</i>			
	5 PUMP V-203 THRU HOMOG #4 AT 1800-2200 PSI INTO V-205			
	6 WHEN V-203 MTY, WASH COLOR THRU HOMOG AT 1800-2000 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	9 RUN 10" (514 G) WATER INTO SV START AGITATOR			
	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-244			
	RECORD: TIME START 12:30 AM TOTAL MIN 130			
	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 190-194F)			
	14 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 40 % - PRESET #1 80 GAL		15-A	160
	B. 13LG 60 % - PRESET #6 135 GAL		20-A	135
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	A. 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM		27	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 85 % 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)	30	7-D	15
	SIPHON INTO SV. RECORD pH 11.3			
	21 OPERATOR STEP PB			

R/W

V-244

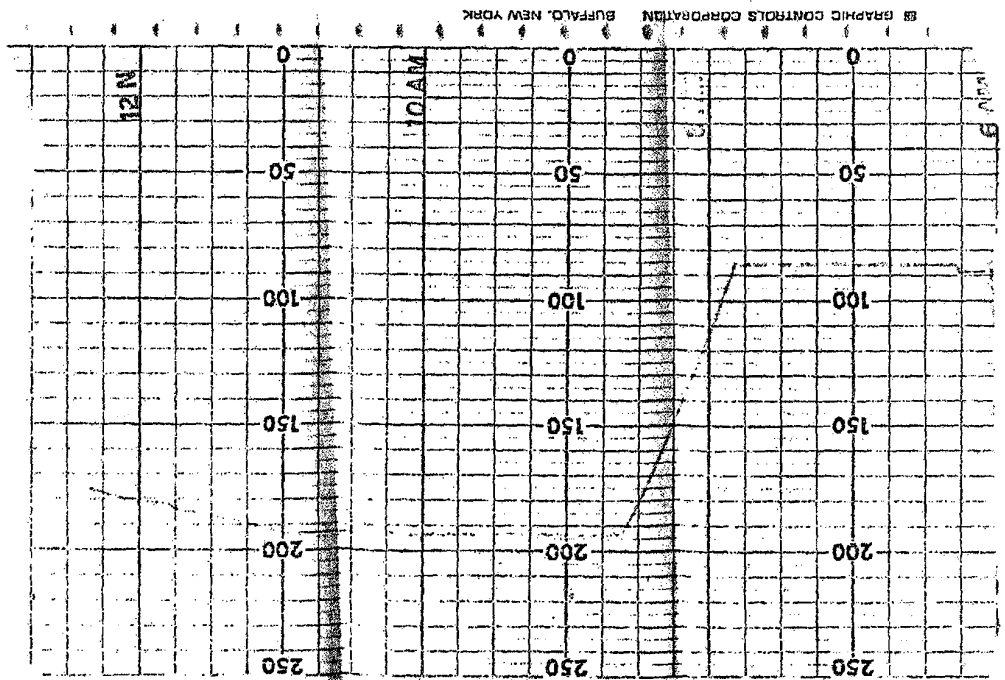
EQUIPMENT	PAGE 2	CG 03	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH	9.9	(9.5-10.0)				
SP	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO						
&	24	OPERATOR STEP PB						
CP	25	SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS						
5	26	SWITCH 3FC10 TO AUTO OPERATOR STEP PB						
	27	SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH 3FC20 TO REMOTE						
	28	OPERATOR STEP PB						
	28	DURING STRIKE, RECORD pH & TIME AS FOLLOWS:						
		SP STEP						
		V-243/V-244						
		13/46 (30 MIN)	9.8	9.0-10.0	6:00 AM			
		14/47 (60 MIN)	9.8	9.0-10.0	6:30 AM			
		15/48 (2 HRS)	9.8	9.0-10.0	7:30 AM			
		16/49 (2 HRS 25 MIN)	9.8	9.0-10.0	7:55 AM			
		17/50 (3 HRS FINAL)	7.2	7.5-8.5	8:30 AM			
		NOTE: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG						
		IF FINAL pH IS ABOVE 8.5, ADJ. pH TO 7.5-8.5 &						
		RECORD: pH				ASSUME 77%	27-D	
339	29	WHILE STRIKING, RUN 30" (234 G) WATER INTO V-339						
6	30	ADD IN 7-8 MIN				350	530-A	350
	31	ADJ TO 49" (382 G) AT 80 - 100°F						
	32	STIR 5 MIN & RECORD pH	10.1	(9.5-10.5)				
	33	STIR 15 MIN OR LONGER TO DISSOLVE FOR SP STEP 26						
	34	RECORD VOL. 49" & CALCULATE 49" (VOL) X 0.78 = 38.2 G						
	35	SET PRESET #8 TO 38.2 G FROM S 34						
302	36	ADD 30" (360 G) WATER TO V-302						
7	37	ADD & STIR 2 MIN FOR S 41				ASSUME 50%	160	7-D 80
243	38	SP STEP 17/50 - AFTER CHECKING pH, OPERATOR STEP PB						
	39	SLET IN 2 BAGS				100	128-A	100
SP	40	SP STEP 23/53 - RECORD pH	3.3	(3.7-4.2)				
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN						
CP	42	RECORD: pH 9.2 (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5						
8	43	& RECORD: pH				ASSUME 77%	27-D	
		(DILUTE 10 PARTS WATER TO 1 PART N-7-D)				ASSUME 50%	7-D	
		SIPHON N-7 INTO SV						
	43	OPERATOR STEP PB						
	44	SP STEP 29/58 RECORD: pH 9.2 (9.0-10.0) TIME 9:15 AM						
	45	OPERATOR STEP PB						
	46	SP STEP 60 - BATCH COMPLETE						
		START		FINISH				
		TIME	SP STEP	TIME	SP STEP	OPTR		
		7:30 PM		11:00 PM		223-144		
		11:00 PM		7:00 AM		223-201		
		7:00 PM		9:15 AM		259-126		

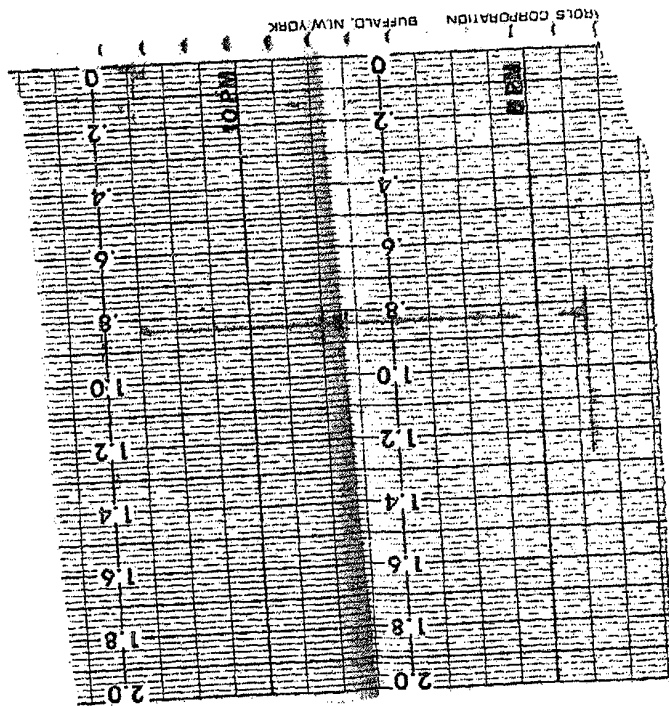
EXT. 228 → Call Kungulow before sending to Pinner

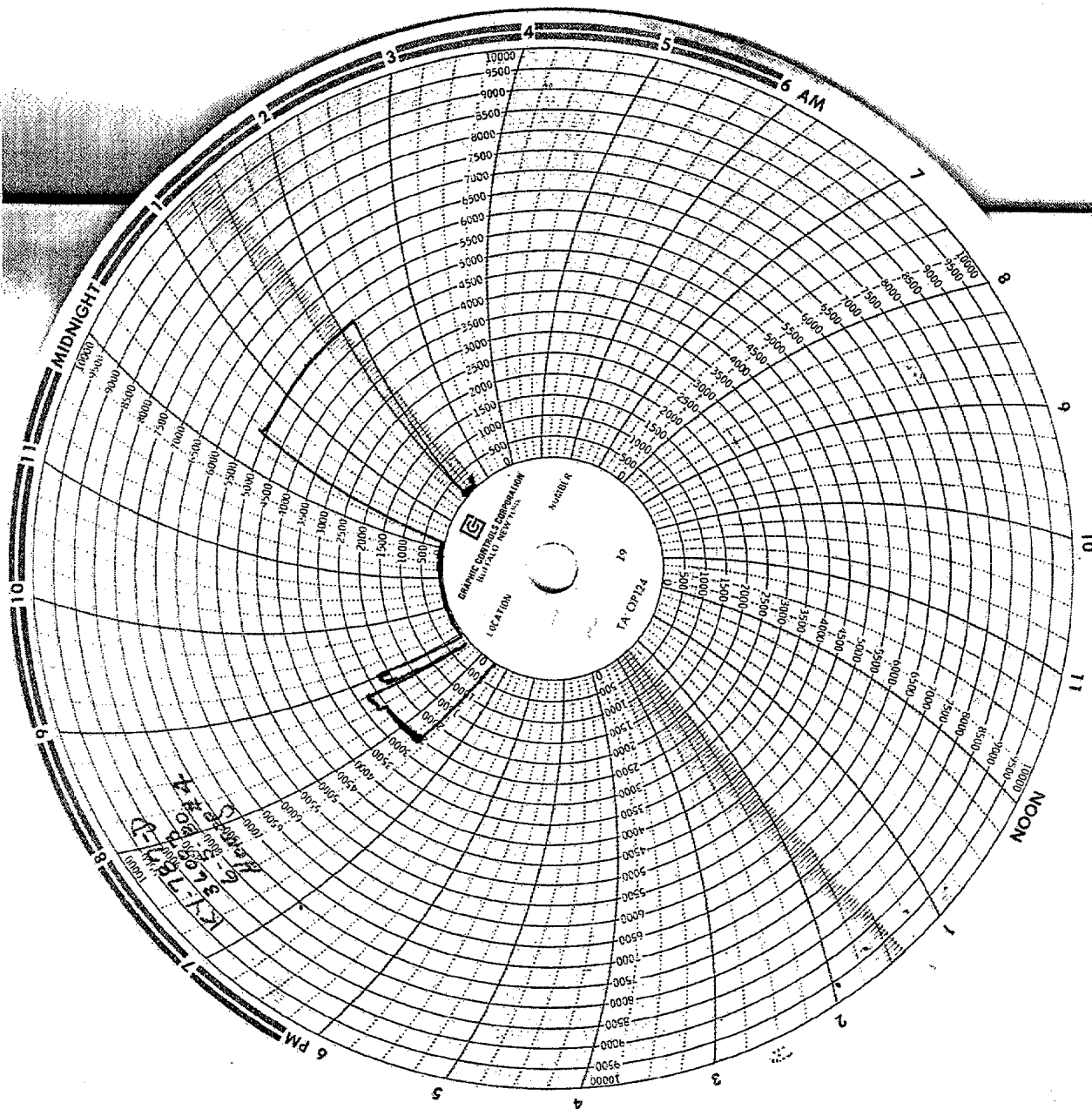


N32431.01

DUP050461198







N32431.02

DUP050461201