MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244 (Automated C.V. D.V.

CG 03 CODE KY-907-D PKG. _____

→ JAN-2 33574

EST. WGT. 1080 LBS.

STD. HRS. _____ TIME 7 AM

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		

OK / LP

14 YC-2-B 93 4 Lot 24083, 2400 #
14 YC-2-B 93 4 Lot _____, _____ #
14 YC-2-B 93 4 Lot _____, _____ #

JW Homog # 3 - 1ST Pass

Total Weight - 3480#

NON-BLEEDING

EQUIPMENT		NAME: 60" (990 G) KROLOR® - YELLOW MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1	Run ~~33" (560 G)~~ water into V-203 AND ADD	20	7-D	10
	2	Pour in	320	32-D	320
	3	Dump in Lot	48 x 50	YC-2-B	2400
		Record: Start 24083	2400		
		Fin			
		75" (1275 G) ~~80" (1360 G)~~			
	4	Adj to ~~70" (1200 G)~~ 2400-2600			
	5	Pump V-203 thru Homog #3 at ~~1800-2200~~ 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 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-243			
		Record: Time Start 5:05 Am Total Min 175			
		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 62 % - 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. 3[illegible] (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 88 %. If below 35% follow solution make-up procedure for N-27-D			
	18	Adj to 48" (2470 G)			
	19	Record: pH 10.3			
	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)	50	7-D	25
		Siphon into SV Record: pH 11.2			
	21	Operator Step PB			

JW

[illegible] REV.

PAGE 2 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.

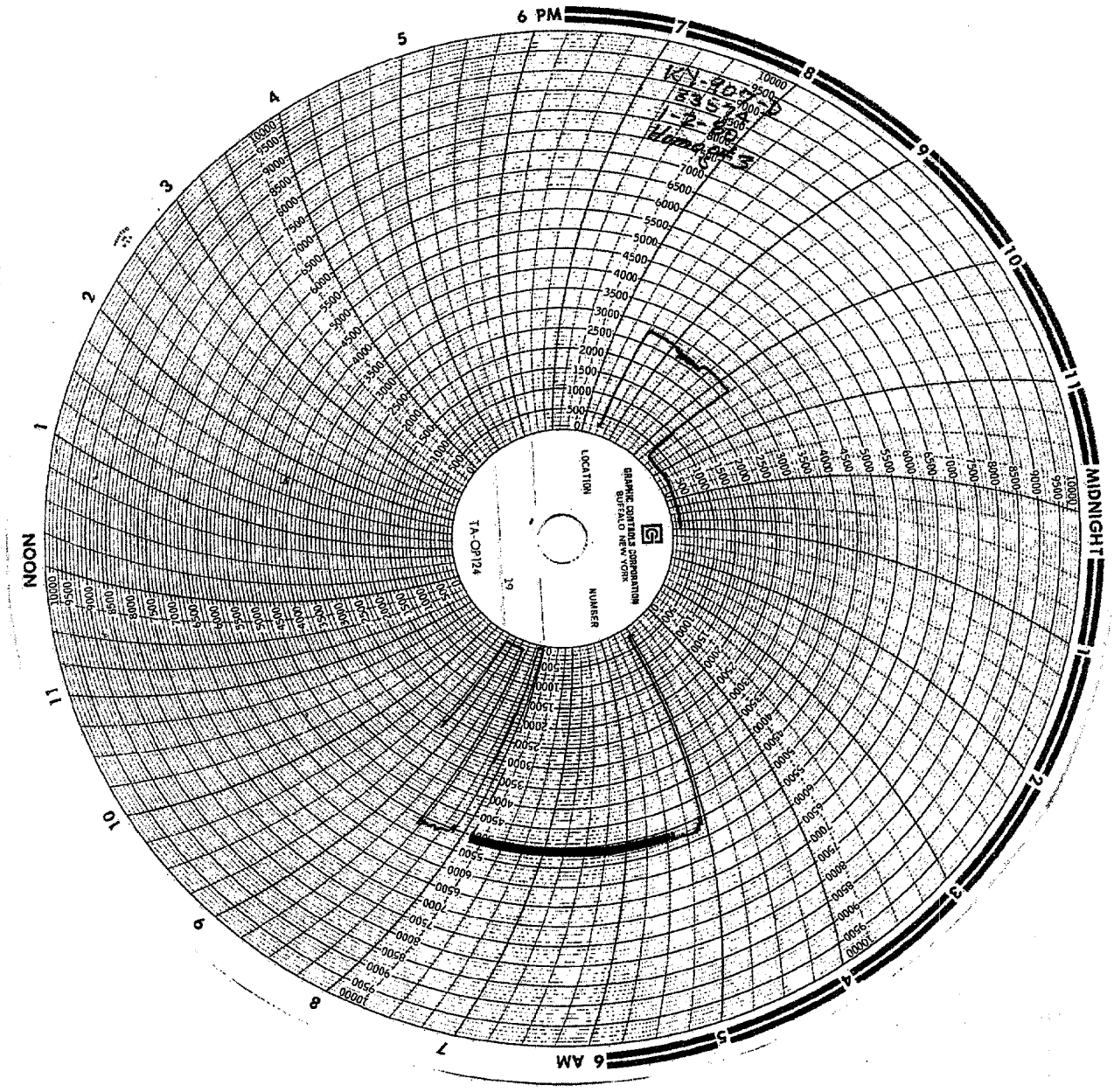
QUIPMENT			USE LBS.	N CODE	ACCT. LBS.
SV SP & CP 5	22	SP Step 06/39 - After heat up Record: pH 10.0 (9.5-10.0)			
	23	Switch 3FC20, 8FC10, 8FC20 to Auto			
	24	Operator Step PB			
	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits Switch 3FC10 to Auto. Operator Step PB			
	26	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote			
	27	Operator Step PB			
	28	During strike, Record pH & time as follows:			
		SP Step V-243/V-244 pH Range Time 10:55AM			
		13/46 (30 min) 9.8 9.0-10.0 11:25 AM			
		14/47 (60 min) 9.8 9.0-10.0 11:55 AM			
		15/48 (2 hrs) 9.8 9.0-10.0 12:55 PM			
		16/49 (2 hrs 25 min) 9.8 9.0-10.0 1:20 "			
		17/50 (3 hrs Final) 8.8 7.5-8.5 1:55 PM			
		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 7.7 Assume 78%	14	27-D	11
	29	Sift in	50	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 ~~20#~~ 14# (244 G) water into V-356			
	37	Turn on steam			
	38	Adj to ~~20#~~ 18# (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			

V-243

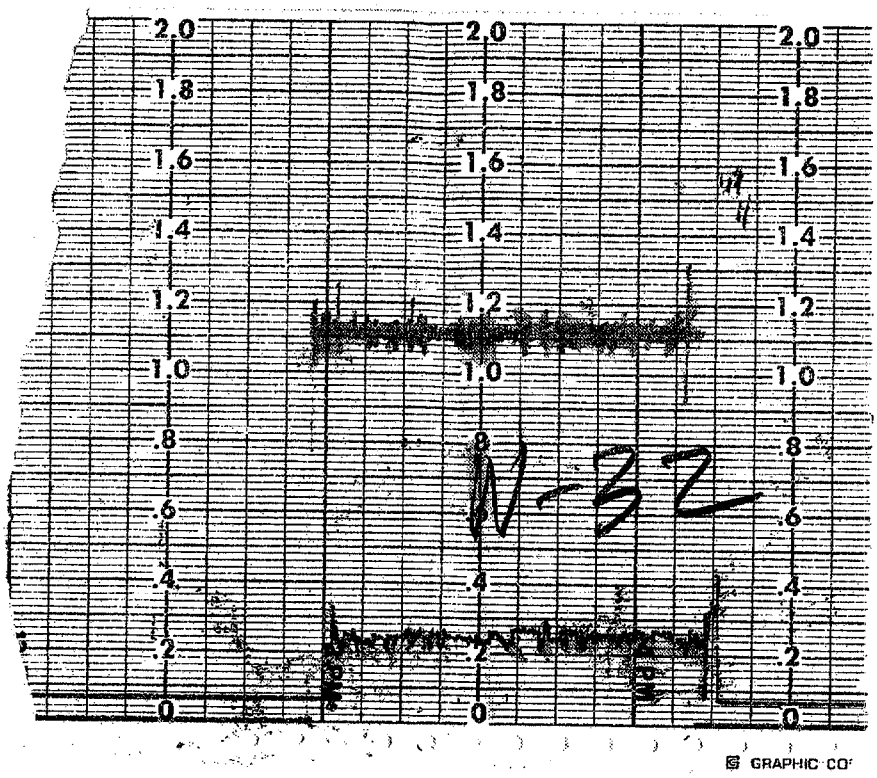
EQUIPMENT		PAGE 3 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV & SP 9 Con'T	52	When S51 complete turn off Homog & stearate pump			
	53	Stir 5 min at 198-200°F			
	54	Shut off steam			
	55	When S54 complete, Operator PB			
	56	SP Step 23/53 Record pH 3.3 (3.3-3.7)			
	57	If 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 8.1 (4.2-4.4) & if necessary adj pH 4.2-4.4			
		& Record: pH 4.3 Assume 50%		7-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 78%	60	27-D	45
		Siphon N-7-D into SV			
	60	Operator Step PB			
	61	Operator Step PB			
	62	SP Step 60 - Batch complete			

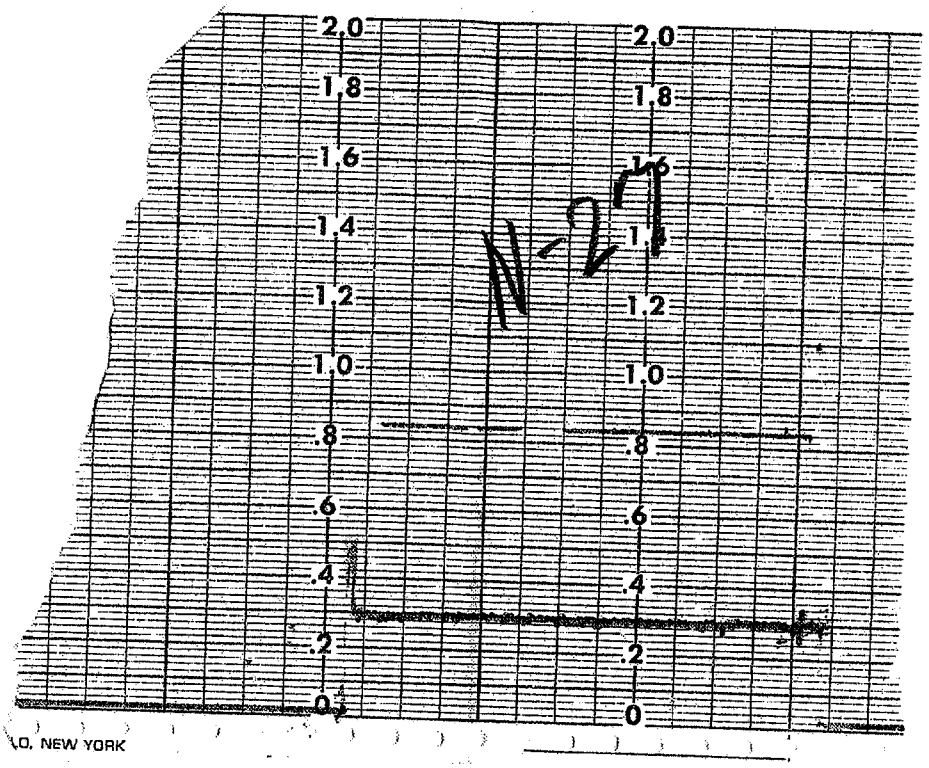
START Time	START SP Step	FINISH Time	FINISH SP Step	OPTR
3:00 PM		11:00 P		235-301
11:00 P		7:00 A		201-27
7:00 AM		3:00 PM		320-145
300 P		340 P		209

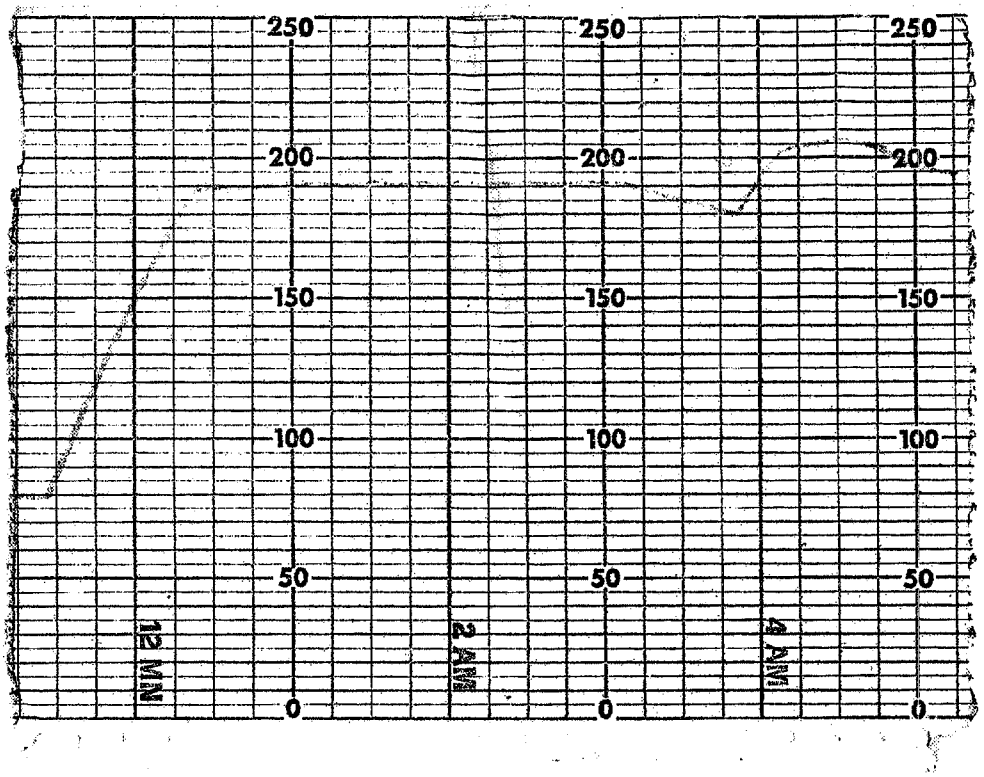
DUP050092900



DUP050092901


2.0
1.8
1.6
1.4
1.2
1.0
.8
.6
.4
.2
0
GRAPHIC CO


2.0
1.8
1.6
1.4
1.2
1.0
.8
.6
.4
.2
0
LO. NEW YORK


250
200
150
100
50
0
12 MN
2 AM
4 AM