

243 (Automated)

CO 03 CODE KY-787-D PKG.

JAN 30 34103

EST. WGT. 1090 LBS.

STD. HRS. 8.9 TIME M

14 - YC-2-B 98 4 Lot 24467, 2400 #
Lot
Lot

D.V.

PROCESSES		APPROVED BY
() KY-787-D	()	FWK 9/22/76
()	()	DCG 9/27/76
()	()	MTW 9/30/76
()	()	
TYPED BY		
N.E. 2/12/77		

Homog #3 - 1st Pass

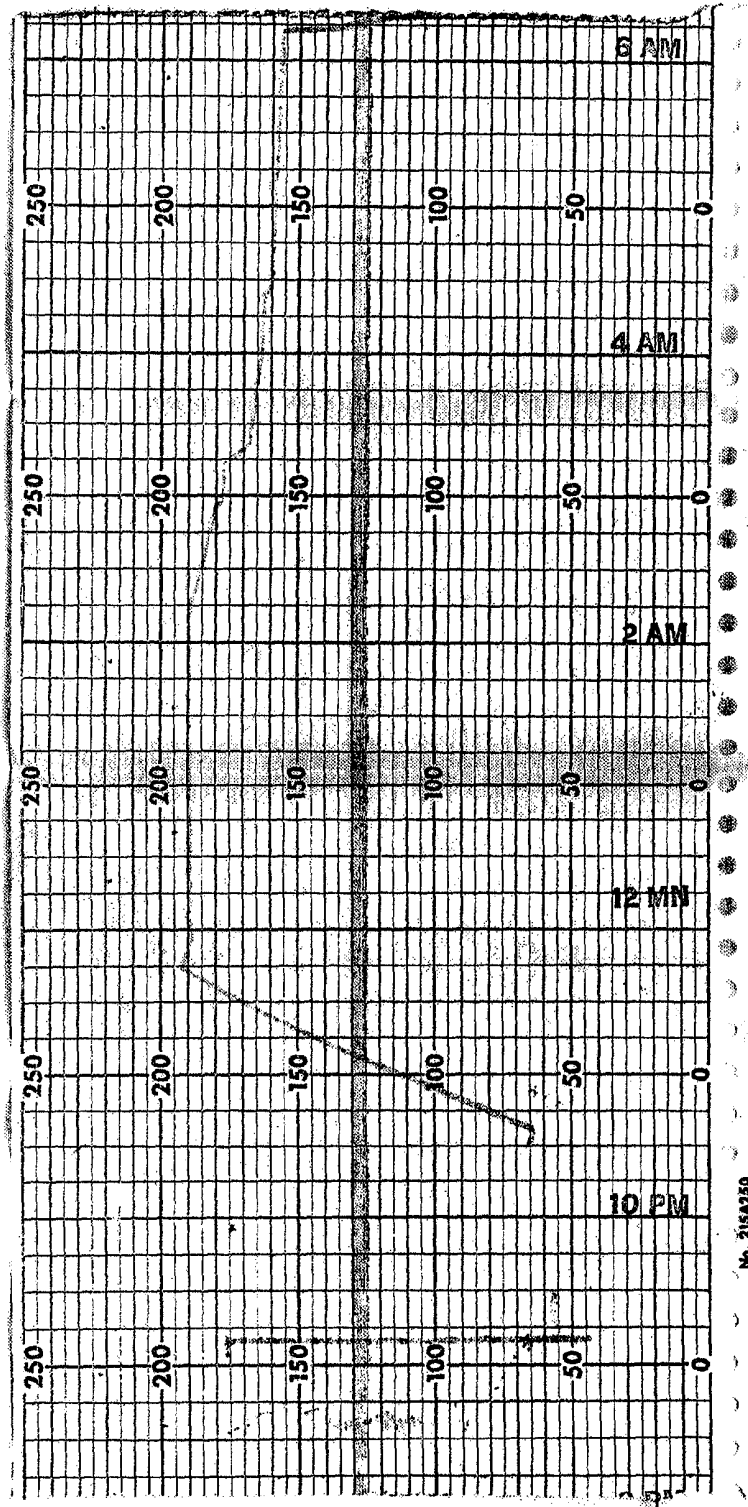
Total Wgt. - 3490# (REQ 0600)

NON-BLEEDING

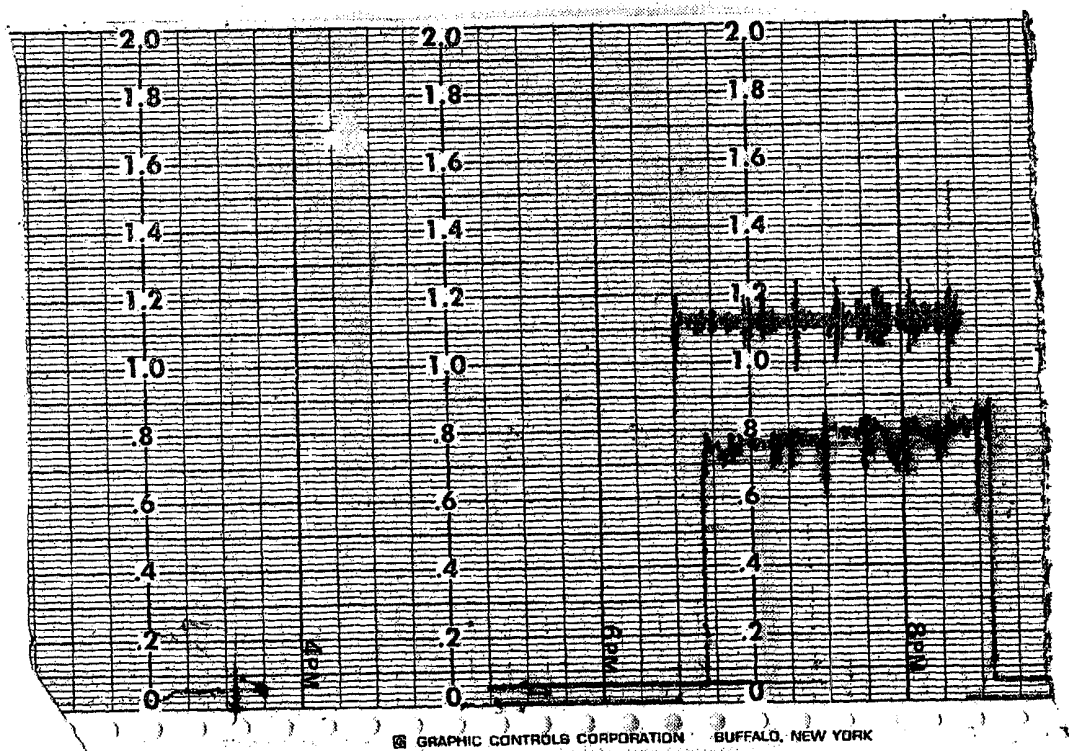
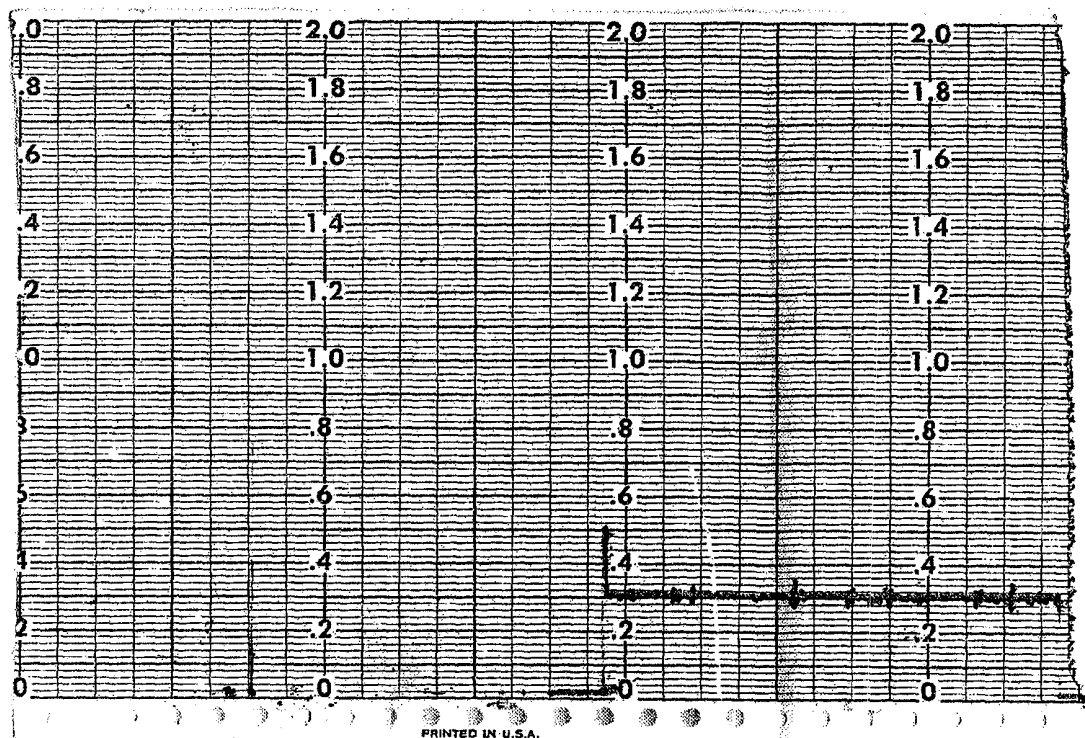
MENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	"KROLOR" - YELLOW MEDIUM			
203	1 Run 60" (992 G) water into V-203			
&	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in and stir 5 min			
1	Record: Start 5:15 PM Lot 24467	48 x 50	YC-2-B	2400
	Fin 6:20 PM	2400		
	4 Add to 70" (1200 G) 2400 2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water			
	7 Record V-205 Vol 54 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time start 3 AM Total Min 70			
2	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	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			
CP	(Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 21G 21 % - preset #1 80 Gal 15-A 160			
	b. 13.6 56 % - 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-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	16 Operator Step PB			
SP	17 Record Level 2 LG 41 %. If below 35% follow solution			
&	make-up procedure for N-27-D			
CP	18 Adj to 48" (2470 G)			
4	19 Record pH 10.5			
	20 Adj to 11.1 - 11.3 using N-7-D diluted to 5%. Assume 50% 20 1-D 10			
	(10 parts water to 1 part N-7-D)			
	Siphon into SV. Record pH 11.1			
	21 Operator Step PB			

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ENT	PAGE	CG	CODE	KEY	EST. WGT.	LBS.	USE	N	ACC
	2	03		7-17-D	3490		LBS.	CODE	LBS.
22	SP Step 06/40			After heat up Record: pH <u>9.1</u> (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			
	13/46 (30 min)			<u>9.6</u>	9.0-10.0	<u>6:50</u>			
	14/47 (60 min)			<u>9.6</u>	9.0-10.0	<u>7:20</u>			
	15/48 (2 hrs)			<u>9.6</u>	9.0-10.0	<u>8:20</u>			
	16/49 (2 hrs 25 min)			<u>9.6</u>	9.0-10.0	<u>8:45</u>			
	17/50 (3 hrs Final)			<u>8.3</u>	7.5-8.5	<u>9:20</u>			
	NOTE: If not as specified notify Supervisor & note in log								
	If final pH is above 8.5, add pH to 7.5-8.5 &								
	Record: pH			Assume 77%				27-D	
29	While striking, run 30" (234 G) water into V-339								
30	Add in 7-8 min						350	530-A	350
31	Add to 49" (382 G) at 80 - 100°F								
32	Stir 5 min & record pH <u>10.2</u> (9.5-10.5)								
33	Stir 15 min or longer to dissolve for SP Step 26								
34	Record Vol <u>49</u> " & calculate <u>49</u> (Vol) x 0.78 = <u>382G</u>								
35	Set preset #8 to <u>382</u> G from S 34								
36	Add 30" (360 G) water to V-302								
37	Add & stir 2 min For S 41				Assume 50%		160	7-D	80
38	SP Step 17/50 - After checking pH, Operator Step PB								
39	SIFT in 2 Bags						100	128-A	100
40	SP Step 23/53 - Record: pH <u>3.7</u> (3.7-4.2)								
41	Run in N-7-D from S 37 in 10-12 min & stir 5 min								
42	Record: pH <u>10.1</u> (9.0-9.5) & if necessary add pH 9.0-9.5								
	& Record: pH <u>9.2</u>				Assume 77%		18	27-D	14
	(Dilute 10 parts water to 1 part N-7-D)				Assume 50%			7-D	
	Siphon N-7-D into SV								
43	Operator Step PB								
44	SP Step 29/58 Record: pH <u>9.4</u> (9.0-10.0) Time <u>10:50 AM</u>								
45	Operator Step PB								
46	SP Step 60 - Batch complete								
	Start			Finish			Optr		
	Time	SP Step		Time	SP Step				
	<u>6:20 P</u>			<u>11:00 P</u>			<u>235-323</u>		
	<u>7:00 AM</u>			<u>10:50 AM</u>			<u>101-127</u>		



No. 215A150



MD-3-A

PACKAGE TICKET

(DRY AND PASTE ONLY)

CODE Py 787 LOT 34103

NET WT/PKG	NO. PKG	PACK. WGT	LOCATION	PQ
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<u>50</u>	<u>83</u>	<u>4150</u>		
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STUMP

TOTAL NET WT. 4150 PKG. N-CODE 1129

PROD. SPVR. WK DATE 2151 WHSE. OPER.