

CO 03 CODE KY-787-D

PKG.

DEC 15

33332

EST. WGT.

1090 990

LBS.

STD. MRS.

8.9

TIME

7 A M

14 - YC-2-B 98 4

Lot 24197

1950#

Lot 24197

HW 10#

Lot

#

3332400

Total Wgt. - 3490#

NON-BLEEDING

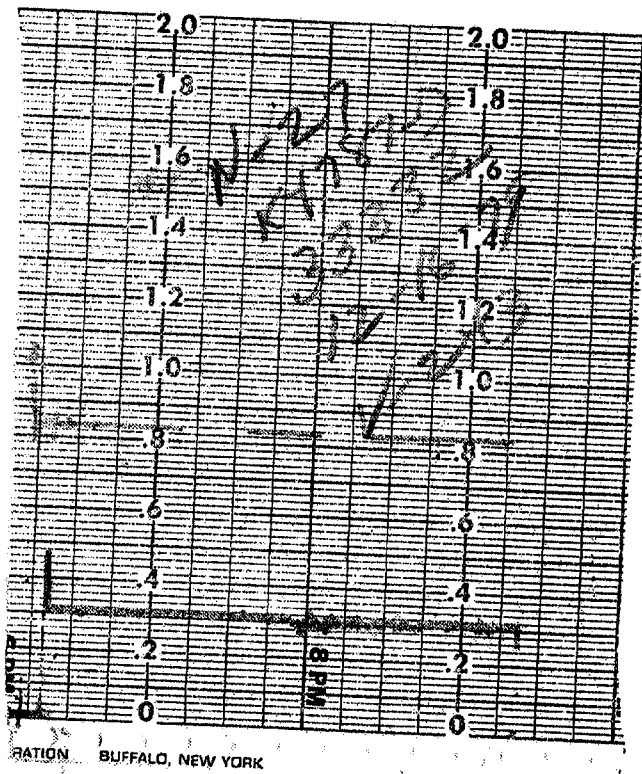
| PROCESSES    | APPROVED BY     |
|--------------|-----------------|
| ( ) KY-787-D | ( ) FWK 9/22/76 |
| ( )          | ( ) DCG 9/27/76 |
| ( )          | ( ) MTW 9/30/76 |
| ( )          | ( )             |
| TYPED BY     |                 |
| N.E. 2/12/77 |                 |

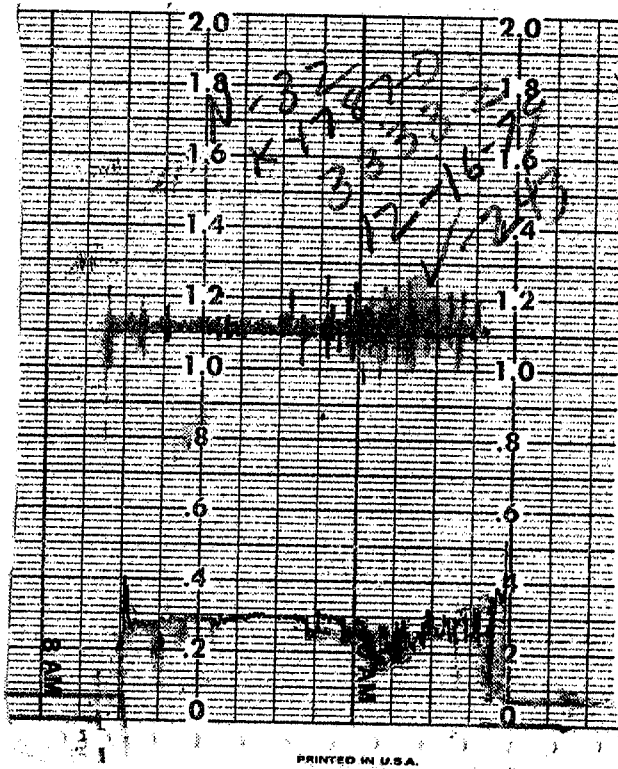
Homog #4-1<sup>ST</sup> Pass  
" #4-2 "

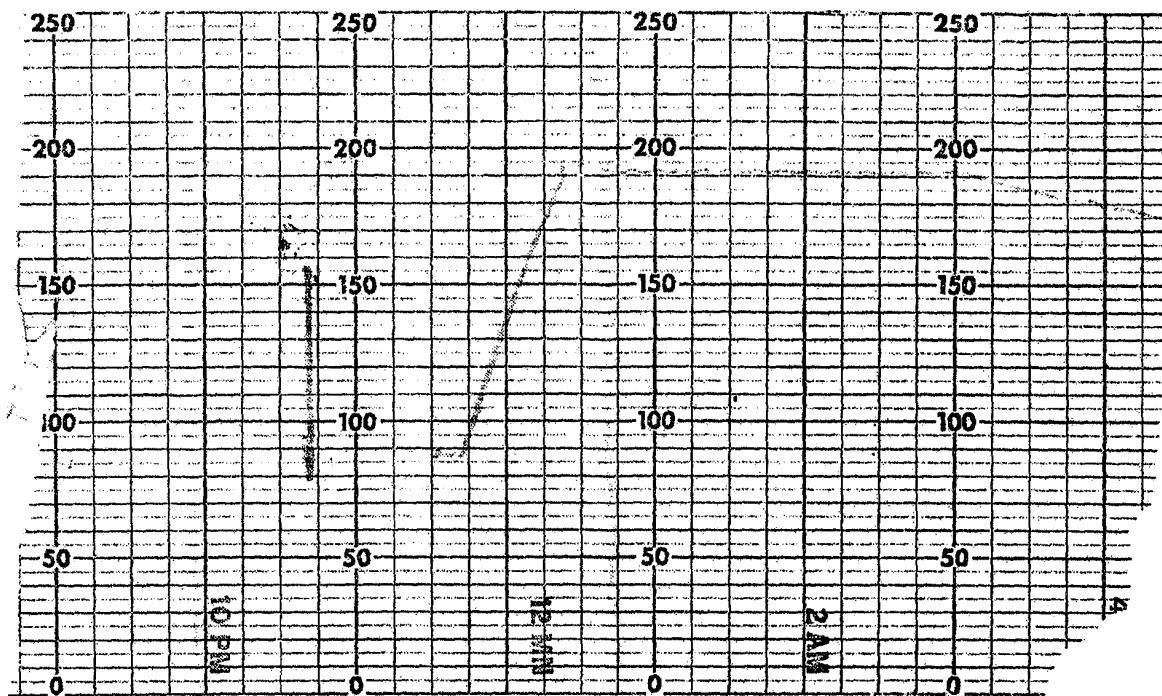
| INSTRUMENT | NAME:                                                                                       | USE LBS. | N CODE | ACCT. LBS. |
|------------|---------------------------------------------------------------------------------------------|----------|--------|------------|
| 203        | 6" "KROLOR" - YELLOW MEDIUM                                                                 |          |        |            |
| &          | 1 Run (992 G) water into V-203                                                              |          |        |            |
| 205        | 2 Weigh in drum & pour in                                                                   | 320      | 32-D   | 320        |
| 1          | 3 Dump in and stir 5 min                                                                    | 48 x 50  | YC-2-B | 2400       |
|            | Record: Start 12:00 PM                                                                      |          |        |            |
|            | Fin 1:15 AM                                                                                 |          |        |            |
|            | 4 Add to 70" (1200 G)                                                                       |          |        |            |
|            | 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 43 " & 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 6:45 AM Total Min 10                                                     |          |        |            |
| 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 (Temperature is set at 190-194F)           |          |        |            |
| CP         | 14 Record levels and set Raw Materials Counter #1 as follows:                               |          |        |            |
| 3          | a. 11.6% - preset #1 80 Gal 15-A 160                                                        |          |        |            |
|            | b. 13.6% - 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. 8EC10 (N-32-D Controller) in Manual 1.08 GPM 32-D 1840                                   |          |        |            |
|            | e. 8EC20 (N-32-D Water) in Manual Local 4.47 GPM                                            |          |        |            |
|            | f. 8EC20 (N-32-D Water) in Remote 0.83                                                      |          |        |            |
|            | g. 8FR10 (N-32-D/Water Ratio) 0.83                                                          |          |        |            |
| SV         | 16 Operator Step PB                                                                         |          |        |            |
| SP         | 17 Record Level 2 LG 70 %. If below 35% follow solution make-up procedure for N-27-D        |          |        |            |
| &          | 18 Add to 48" (2470 G)                                                                      |          |        |            |
| CP         | 19 Record pH 10.8                                                                           |          |        |            |
| 4          | 20 Add 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    | 10         |
|            | Siphon into SV, Record pH 10.2                                                              |          |        |            |
|            | 21 Operator Step PB                                                                         |          |        |            |

V-243

| JIPMENT | PAGE 2 CG 03 CODE KY-787-D                                                    | EST. WGT. 3490 | LBS. | USE LBS. | N CODE | ACCT LBS. |
|---------|-------------------------------------------------------------------------------|----------------|------|----------|--------|-----------|
| SV      | 22 SP Step 06/39 - After heat up Record: pH <u>10.2</u> (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       | 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>10.2</u> 9.0-10.0 <u>11:40</u>                              |                |      |          |        |           |
|         | 14/47 (60 min) <u>9.2</u> 9.0-10.0 <u>12:10</u>                               |                |      |          |        |           |
|         | 15/48 (2 hrs) <u>9.2</u> 9.0-10.0 <u>1:10</u>                                 |                |      |          |        |           |
|         | 16/49 (2 hrs 25 min) <u>9.2</u> 9.0-10.0 <u>1:35</u>                          |                |      |          |        |           |
|         | 17/50 (3 hrs Final) <u>9.0</u> 7.5-8.5 <u>2:10</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 <u>9.2</u> Assume 77% <u>12</u> 27-D <u>9</u>                      |                |      |          |        |           |
| 339     | 29 While striking, run 30" (234 G) water into V-339                           |                |      |          |        |           |
| 6       | 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>50</u> & calculate <u>50</u> (Vol) x 0.78 = <u>39.06</u>     |                |      |          |        |           |
|         | 35 Set preset #8 to <u>39.0</u> 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% <u>160</u> 7-D <u>80</u>              |                |      |          |        |           |
| 243     | 38 SP Step 17/50 - After checking pH, Operator Step PB                        |                |      |          |        |           |
|         | 39 Add in 2 Bags <u>100</u> 128-A <u>100</u>                                  |                |      |          |        |           |
| SP      | 40 SP Step 23/53 - Record: pH <u>9.2</u> (3.7-4.2)                            |                |      |          |        |           |
| &       | 41 Run in N-7-D from S 37 in 10-12 min & stir 5 min                           |                |      |          |        |           |
| CP      | 42 Record: pH <u>10.2</u> (9.0-9.5) & if necessary add pH 9.0-9.5             |                |      |          |        |           |
| 8       | & Record: pH <u>9.1</u> Assume 77% <u>6</u> 27-D <u>4</u>                     |                |      |          |        |           |
|         | (Dilute 10 parts water to 1 part N-7-D) Assume 50% <u>7-D</u>                 |                |      |          |        |           |
|         | Siphon N-7-D into SV                                                          |                |      |          |        |           |
|         | 43 Operator Step PB                                                           |                |      |          |        |           |
|         | 44 SP Step 29/58 Record: pH <u>9.0</u> (9.0-10.0) Time <u>4:00 PM</u>         |                |      |          |        |           |
|         | 45 Operator Step PB                                                           |                |      |          |        |           |
|         | 46 SP Step 60 - Batch complete                                                |                |      |          |        |           |
|         | Start Finish Optr                                                             |                |      |          |        |           |
|         | Time SP Step Time SP Step                                                     |                |      |          |        |           |
|         | <u>1:25 AM</u> <u>7:00 AM</u>                                                 |                |      |          |        |           |
|         | <u>2:00 AM</u> <u>3:00 PM</u> <u>409-282</u>                                  |                |      |          |        |           |
|         | <u>3:00 P</u> <u>244</u>                                                      |                |      |          |        |           |







No. 213A250

