V. (243) 244 (Automated) C.V. B.V.

CG 03 CODE KY-788-D PKG.

→ MAR 21 34991 PUNCHED & CHECKED OK

EST. WGT. ~~960~~ 860 LBS. MAR 25 1980 FP

STD. HRS. 8.8 TIME 11 P M

14	YC-3-B	98	4	Lot	24443	2000
14	YC-3-B	98	4	Lot	24404	600
14	YC-3-B	98	4	Lot		

PROCESSES		APPROVED BY
( )KY-788-D	(J)	EWK 9/28/76
( )	( )	MTW 9/30/76
( )	( )	DCG 9/30/76
( )	( )	
TYPED BY		
NE 2-18-77		

Total Wgt. ~~3560#~~ 3460 NON-BLEEDING

EQUIPMENT		NAME: "KROLOR" YELLOW - LIGHT	USE LBS.	N CODE	ACCT. LBS.
203	V	~~60" (990 G)~~ Run ~~25" (360 G)~~ water into V-203. SET AGITATOR ON HIGH SPEED			
&	2	Weigh in drum & pour in	345	32-D	345
205	3	Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
1		Record: Start 12:50 24443	2000		
		Fin 2:45 24404	600		
		~~75" (1275 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 washcolor thru Homog at 1800-2200 psi using minimun water			
	7	Record: V-205 Vol 60 "& adj to 60" (2100 G)			
	8	Inspect homog. strainer & clean if necessary			
		DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205	9	Run 10" (514 G) water into V- 244 & startagitator			
&	10	Pump V-205 thru Homog at 4800-5200 psi into V- 244			
SV		Record: Time Start 9.13 Am Total min 95			
2		Note: If Homog pressure falls below 4800 ps., 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 #3 (V-243) or ~~#8 (V-244)~~			
&	13	Press SV Cam Reset PB- set 22 TC in Auto Remote			
CP		(Temperature is set at 190-194 F)			
3	14	Record levels and set Raw Material Counter #1 as follows			
		a. 11LG 42 % - preset #2 208 Gal		15-A	416
		b. 13LG 43 % - preset #6 135 Gal		20-A	135
	15	Set strike flow controllers as follows:			
		a. 3EC10 (N-27-D Controller) in Manual 0.54 GPM		27-D	180
		b. 3EC20 (N-27-D Water) in Manual Local 4.4 GPM			
		c. 3ER10 (N-27-D/Water) Ratio 0.8			
		d. 8EC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1215
		e. 8FC20 (N-32-D Water) in Manual Local 3.9 GPM			
		f. 8FC20 (N-32-D Water) in Remote			
		g. 8FR10 (N-32-D/Water) Ratio 1.1			
320	16	Operator Step PB			
243	17	Record Level 21G 42 %. If below 35% follow solution make-up procedure for N-27-D			
SP	18	Adj SV to 47" (2400 G)			
&	19	Record pH 10.3 . Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.1	56	7-D	18
CP 4	20	Operator Step PB			

29 REV.

N 26538

V-244

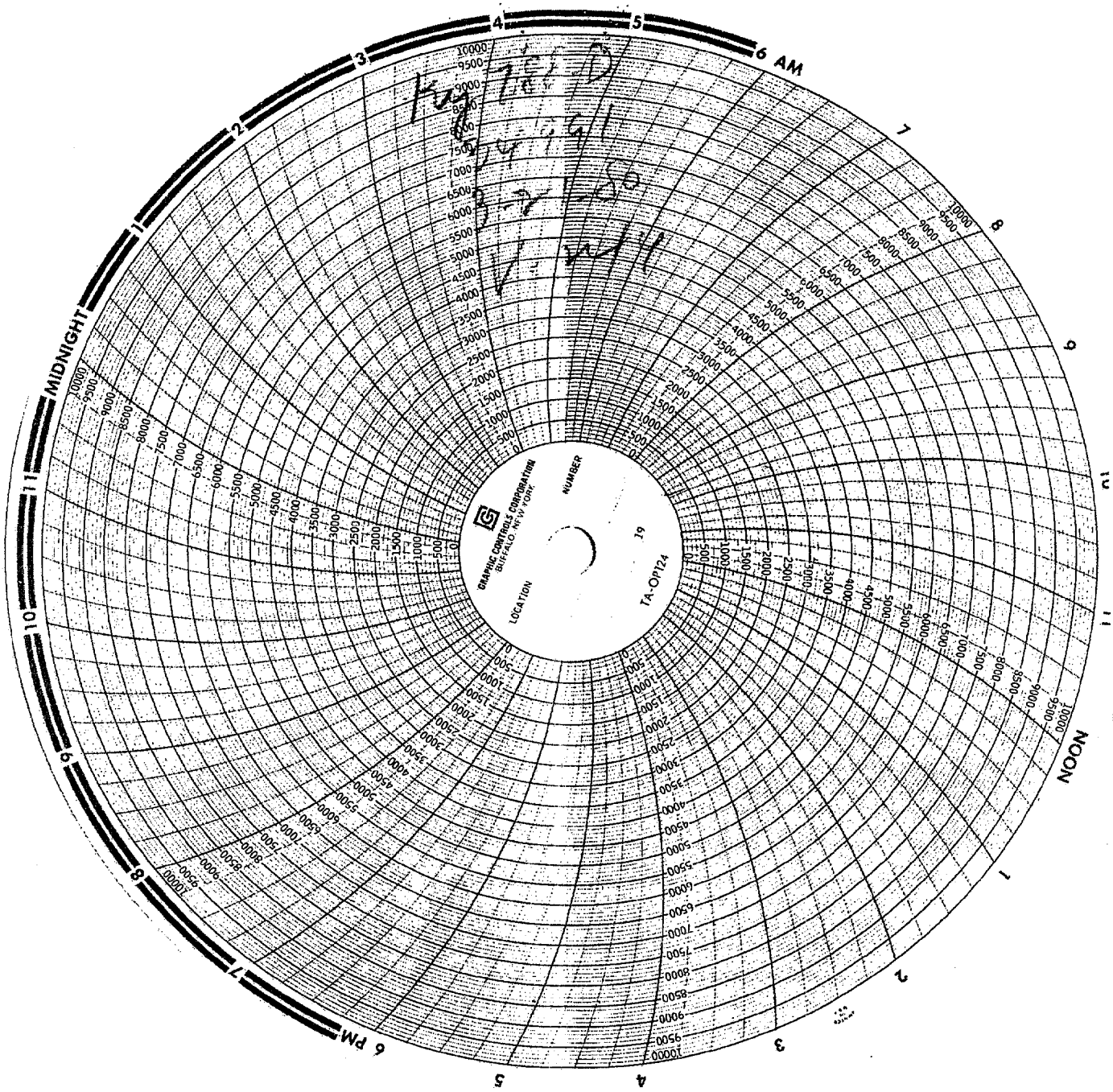
UIPMENT		PAGE 2 CG 03 CODE KY-788-D EST. WGT. 3560 LBS.	USE LBS.	N CODE	ACC LBS
SV	21	SP Step 06/39 - After heat up Record: pH 9.8 9.5-10.0)			
SP	22	Switch 3EC20, 8EC10, 3FC20 to Auto			
	23	Operator Step PB			
	24	SP Step 10/43 - When 3EC20, 8EC10, 8FC20 water flows is limits:			
5		Swich 3FC10 to 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:			
		SP Step			
		V-243/V-244 pH Range Time			
		13/45 (30 min) 9.7 9.3-10.0 2.30 PM			
		14/47 (60 min) 9.7 9.3-10.0 3.00 PM			
		15/48 (2 hrs) 9.7 9.3-10.0 4.00 PM			
		16/49 (2 hrs 25 min) 9.7 9.3-10.0 4.25 PM			
		18/50 (Final 3 hrs) 8.6 7.5-8.5 5.00 PM			
		Note: If not as specified notify Supervisor & Note in log			
		If final pH is above 8.5, adj 7.5-8.5			
		& Record: pH 8.2 Assume 77%	5	27-D	1
339	28	While striking run 30" (234 G) water into V-339			
6	29	Add in 7-8 min	350	530-A	350
	30	Adj to 49" (382 G) at 80-100 °F			
	31	Stir 5 min & record pH 10.1 (9.5-10.5)			
	32	Stir 15 min or longer to dissolve for SP Step 26/56			
	33	Record Vol 50 " & Calculate 50 " (Vol X 0.78= 39.0 G)			
	34	Set preset #8 to 39.0 G from S 33			
302	35	Run 40" (440 G) water into V-302			
7	36	Add & stir 2 min for S 40 Assume 50%	360	7-D	180
SV	37	SP Step 17/50 After checking pH. Operator Step PB			
SP	38	Sift in 2 bags	100	128-A	100
	39	SP Step 23/53 Record: pH 3.6 (3.7-4.2			
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min			
	41	Record: pH 9.6 (9.0-9.5) & if necessary adj to pH 9.0-9.5			
		& Record: pH Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV			
	42	Operator Step PB			
	43	SP Step 29 - Record: pH 9.4 (9.0-10.0) Time 6:10 PM			
	44	Operator Step PB			
	45	SP Step 60 - Batch complete			

Start		Finish		Optr
Time	SP Step	Time	SP Step	
7 AM		7 AM		120
9:15 AM		3:00 PM		144
3:00 PM		6:10 PM		404

DUP050094474

DUP050094475

DUP050094476


MIDNIGHT
6 AM
NOON
6 PM
GRAPHIC CONTROLS CORPORATION
BUFFALO NEW YORK
NUMBER
LOCATION
TA-OP124