

D.V. 243 244, 245, 246, 247, 248, 249, 250, 251, 252, 253, 254, 255, 256, 257, 258, 259, 260, 261, 262, 263, 264, 265, 266, 267, 268, 269, 270, 271, 272, 273, 274, 275, 276, 277, 278, 279, 280, 281, 282, 283, 284, 285, 286, 287, 288, 289, 290, 291, 292, 293, 294, 295, 296, 297, 298, 299, 300, 301, 302, 303, 304, 305, 306, 307, 308, 309, 310, 311, 312, 313, 314, 315, 316, 317, 318, 319, 320, 321, 322, 323, 324, 325, 326, 327, 328, 329, 330, 331, 332, 333, 334, 335, 336, 337, 338, 339, 340, 341, 342, 343, 344, 345, 346, 347, 348, 349, 350, 351, 352, 353, 354, 355, 356, 357, 358, 359, 360, 361, 362, 363, 364, 365, 366, 367, 368, 369, 370, 371, 372, 373, 374, 375, 376, 377, 378, 379, 380, 381, 382, 383, 384, 385, 386, 387, 388, 389, 390, 391, 392, 393, 394, 395, 396, 397, 398, 399, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 411, 412, 413, 414, 415, 416, 417, 418, 419, 420, 421, 422, 423, 424, 425, 426, 427, 428, 429, 430, 431, 432, 433, 434, 435, 436, 437, 438, 439, 440, 441, 442, 443, 444, 445, 446, 447, 448, 449, 450, 451, 452, 453, 454, 455, 456, 457, 458, 459, 460, 461, 462, 463, 464, 465, 466, 467, 468, 469, 470, 471, 472, 473, 474, 475, 476, 477, 478, 479, 480, 481, 482, 483, 484, 485, 486, 487, 488, 489, 490, 491, 492, 493, 494, 495, 496, 497, 498, 499, 500, 501, 502, 503, 504, 505, 506, 507, 508, 509, 510, 511, 512, 513, 514, 515, 516, 517, 518, 519, 520, 521, 522, 523, 524, 525, 526, 527, 528, 529, 530, 531, 532, 533, 534, 535, 536, 537, 538, 539, 540, 541, 542, 543, 544, 545, 546, 547, 548, 549, 550, 551, 552, 553, 554, 555, 556, 557, 558, 559, 560, 561, 562, 563, 564, 565, 566, 567, 568, 569, 570, 571, 572, 573, 574, 575, 576, 577, 578, 579, 580, 581, 582, 583, 584, 585, 586, 587, 588, 589, 590, 591, 592, 593, 594, 595, 596, 597, 598, 599, 600, 601, 602, 603, 604, 605, 606, 607, 608, 609, 610, 611, 612, 613, 614, 615, 616, 617, 618, 619, 620, 621, 622, 623, 624, 625, 626, 627, 628, 629, 630, 631, 632, 633, 634, 635, 636, 637, 638, 639, 640, 641, 642, 643, 644, 645, 646, 647, 648, 649, 650, 651, 652, 653, 654, 655, 656, 657, 658, 659, 660, 661, 662, 663, 664, 665, 666, 667, 668, 669, 670, 671, 672, 673, 674, 675, 676, 677, 678, 679, 680, 681, 682, 683, 684, 685, 686, 687, 688, 689, 690, 691, 692, 693, 694, 695, 696, 697, 698, 699, 700, 701, 702, 703, 704, 705, 706, 707, 708, 709, 710, 711, 712, 713, 714, 715, 716, 717, 718, 719, 720, 721, 722, 723, 724, 725, 726, 727, 728, 729, 730, 731, 732, 733, 734, 735, 736, 737, 738, 739, 740, 741, 742, 743, 744, 745, 746, 747, 748, 749, 750, 751, 752, 753, 754, 755, 756, 757, 758, 759, 760, 761, 762, 763, 764, 765, 766, 767, 768, 769, 770, 771, 772, 773, 774, 775, 776, 777, 778, 779, 780, 781, 782, 783, 784, 785, 786, 787, 788, 789, 790, 791, 792, 793, 794, 795, 796, 797, 798, 799, 800, 801, 802, 803, 804, 805, 806, 807, 808, 809, 810, 811, 812, 813, 814, 815, 816, 817, 818, 819, 820, 821, 822, 823, 824, 825, 826, 827, 828, 829, 830, 831, 832, 833, 834, 835, 836, 837, 838, 839, 840, 841, 842, 843, 844, 845, 846, 847, 848, 849, 850, 851, 852, 853, 854, 855, 856, 857, 858, 859, 860, 861, 862, 863, 864, 865, 866, 867, 868, 869, 870, 871, 872, 873, 874, 875, 876, 877, 878, 879, 880, 881, 882, 883, 884, 885, 886, 887, 888, 889, 890, 891, 892, 893, 894, 895, 896, 897, 898, 899, 900, 901, 902, 903, 904, 905, 906, 907, 908, 909, 910, 911, 912, 913, 914, 915, 916, 917, 918, 919, 920, 921, 922, 923, 924, 925, 926, 927, 928, 929, 930, 931, 932, 933, 934, 935, 936, 937, 938, 939, 940, 941, 942, 943, 944, 945, 946, 947, 948, 949, 950, 951, 952, 953, 954, 955, 956, 957, 958, 959, 960, 961, 962, 963, 964, 965, 966, 967, 968, 969, 970, 971, 972, 973, 974, 975, 976, 977, 978, 979, 980, 981, 982, 983, 984, 985, 986, 987, 988, 989, 990, 991, 992, 993, 994, 995, 996, 997, 998, 999, 1000

C.V.

D.V.

CO 03 CODE KY-907-D PKG.

EST. WGT. 1080 LBS.

STD. HRS. TIME 11 PM

14 YC-2-B 93 4 Lot 24162, 2000 #  
14 YC-2-B 93 4 Lot 24477, 400 #  
14 YC-2-B 93 4 Lot , #

PUNCHED &amp; CHECKED 3.1st PASS

JUN 1 1977

| PROCESSES     |     | APPROVED BY |          |
|---------------|-----|-------------|----------|
| ( ) KY-907-D  | (E) | EWK         | 12/12/77 |
| ( ) Alternate | ( ) | DCG         | 12/14/77 |
| ( )           | ( ) |             |          |
| ( )           | ( ) |             |          |
| TYPED BY      |     |             |          |
| 3/1/78        |     |             |          |

Total Wgt. 3480# (Req. )

NON-BLEEDING

| EQUIPMENT | NAME                                                                                        | USE LBS.    | N CODE | ACCT. LBS. |
|-----------|---------------------------------------------------------------------------------------------|-------------|--------|------------|
| 203 & 205 | KROLOR <sup>®</sup> YELLOW - MEDIUM                                                         |             |        |            |
| 1         | Run 33" (560 G) water into V-203                                                            | 320         | 32-D   | 320        |
|           | Pump in                                                                                     | 48 x 50     | YC-2-B | 2400       |
|           | Record: Start 3:30 AM                                                                       | 40 - 24162  |        |            |
|           | Fin 3:30 AM                                                                                 | 8 - 24477   |        |            |
|           | Adj to 70" (1200 G)                                                                         | 2400 - 2600 |        |            |
|           | Pump V-203 thru Homog #3 at 1800-2200 psi into V-205                                        |             |        |            |
|           | When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water                  |             |        |            |
|           | Record: V-205 Vol 40 " & adj to 60" (2100 G)                                                |             |        |            |
|           | Inspect Homog strainer & clean if necessary                                                 |             |        |            |
| SV & 205  | Run 10" (514 G) water into V-                                                               |             |        |            |
|           | Install Temp chart & start agitator                                                         |             |        |            |
|           | Pump V-205 thru Homog at 4800-5200 psi into SV                                              |             |        |            |
|           | Record: Time Start 5:25 Total Min 100                                                       |             |        |            |
|           | Note: If Homog pressure falls below 4800 psi 3-way valve will recirculate slurry to V-205   |             |        |            |
|           | When V-205 MTY, run in 5" (240 G) water & 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 1% - preset #1 80 Gal                                                               |             | 15-A   | 160        |
|           | b. 13LG 1% - preset #6 125 Gal                                                              |             | 20-A   | 125        |
|           | 15 Set strike flow controllers as follows:                                                  |             |        |            |
|           | a. 3EC10 (N-27-D Controller) in Manual 0.83 GPM                                             |             | 27-D   | 275        |
|           | b. 3EC20 (N-27-D Water) in Manual Local 5.28 GPM                                            |             |        |            |
|           | c. 3PR10 (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                                                           |             |        |            |
|           | g. 8PR10 (N-32-D/Water Ratio) 0.83                                                          |             |        |            |
| SV & CP 4 | 16 Operator Step PB                                                                         |             |        |            |
|           | 17 Record Level 2 LG % . If below 35% follow solution make-up procedure for N-27-D          |             |        |            |
|           | 18 Adj to 48" (2470 G)                                                                      |             |        |            |
|           | 19 Record pH 10.7                                                                           |             |        |            |
|           | 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 11.2                                                              |             |        |            |
|           | 21 Operator Step PB                                                                         |             |        |            |

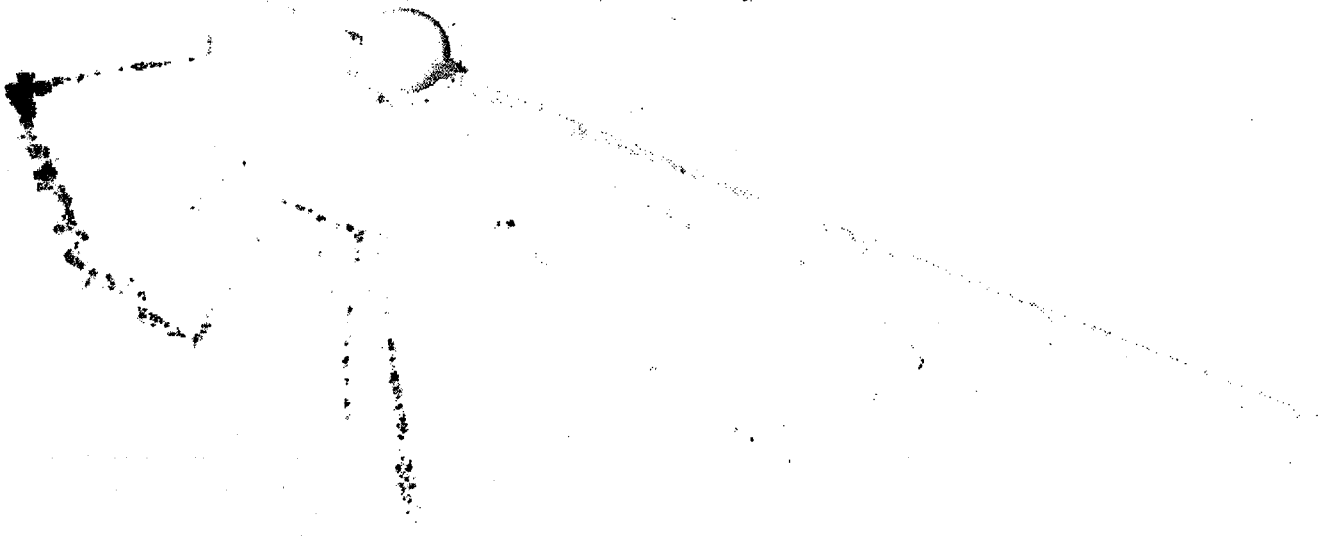
*recp*

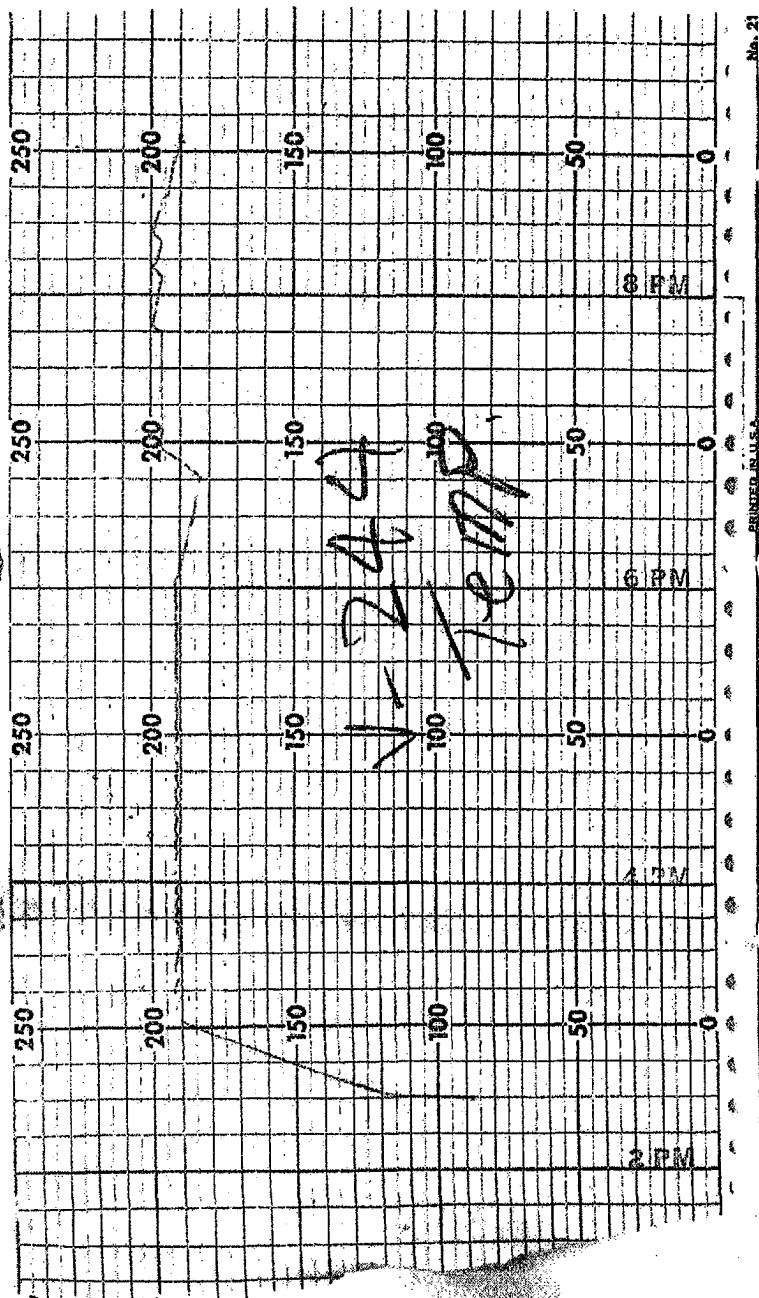
| EQUIPMENT | PAGE 2 CG 03 CODE KY-787-D                                                                                                   | EST. WGT. 2090 | LBS.       | USE LBS. | N CODE | ACCT. LBS. |
|-----------|------------------------------------------------------------------------------------------------------------------------------|----------------|------------|----------|--------|------------|
| SV        | 22 SP Step 06/39 - After heat up Record: pH                                                                                  | 9.7            | (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      |          |        |            |
|           | 13/46 (30 min)                                                                                                               | 9.8            | 9.0-10.0   |          |        |            |
|           | 14/47 (60 min)                                                                                                               | 9.8            | 9.0-10.0   |          |        |            |
|           | 15/48 ( 2 hrs)                                                                                                               | 9.8            | 9.0-10.0   |          |        |            |
|           | 16/49 ( 2 hrs 25 min)                                                                                                        | 7.75           | 9.0-10.0   |          |        |            |
|           | 17/50 ( 3 hrs Final )                                                                                                        | 7.3            | 7.5-8.5    |          |        |            |
|           | 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   |            |
|           | 30 Sift in                                                                                                                   |                |            | 50       | 128-A  | 50         |
| 385       | 31 Run 11" (80 G) water into V-302 & heat to 135-140°F                                                                       |                |            |          |        |            |
| 302       | 32 Dump in & stir to dissolve for S 60                                                                                       |                |            | 100      | 15-A   | 160        |
| 8         | 33 Run 17" (208 G) water into V-302                                                                                          |                |            |          |        |            |
|           | 34 Add & stir 2 min for S 62                                                                                                 |                | Assume 50% | 100      | 7-D    | 50         |
| PT        | 35 During strike pump into PT                                                                                                |                |            | 318      | 169-A  | 318        |
| 9         | 36 Pump in                                                                                                                   |                |            | 36       | 155-A  | 36         |
|           | 37 Pump in                                                                                                                   |                |            | 36       | 160-A  | 36         |
|           | 38 Stir 10 min with lightning mixer for S 42                                                                                 |                |            |          |        |            |
| 356       | 39 During Strike, Run 20" (244G) water into V-356                                                                            |                |            |          |        |            |
| 10        | 40 Turn on steam                                                                                                             |                |            |          |        |            |
|           | 41 Adj to 26" (317G) at 178-182°F                                                                                            |                |            |          |        |            |
|           | 42 Pump PT mixture from S38 thru undersurface Distributor AFAP                                                               |                |            |          |        |            |
|           | 43 Rinse PT with hot water from hot water mixer & pump in                                                                    |                |            |          |        |            |
|           | 44 Shut off pump                                                                                                             |                |            |          |        |            |
|           | 45 Stir 30 min at 178-182°F for S 54                                                                                         |                |            |          |        |            |
|           | 46 Do not shut off agitator                                                                                                  |                |            |          |        |            |
| SV        | 47 When V-340 MTV, rinse in with minimum water then set pump to zero setting                                                 |                |            |          |        |            |
| 11        | 48 When V-343 MTV, rinse in with minimum water then turn off pump motor                                                      |                |            |          |        |            |
|           | 49 Heat to 198-200 °F in 5-10 min                                                                                            |                |            |          |        |            |
|           | 50 Close water line & discharge valves at stearate pump                                                                      |                |            |          |        |            |
|           | 51 Open V-356 discharge valves to stearate pump inlet                                                                        |                |            |          |        |            |
|           | 52 Open water valve at stearate pump & run water thru Homog at 2900-3100 PSI to sewer                                        |                |            |          |        |            |
|           | 53 While Homog water at 2900-3100PSI, open Homog Discharge valve to SV & close valve to sewer                                |                |            |          |        |            |
|           | 54 Immediately open stearate pump discharge valve turn on pump & Homog V-356 to SV at 2800-3100 PSI Maintain SV at 198-200°F |                |            |          |        |            |
|           | 55 While Homog V-356 to SV, shut off water valve at stearate pump ASAP                                                       |                |            |          |        |            |

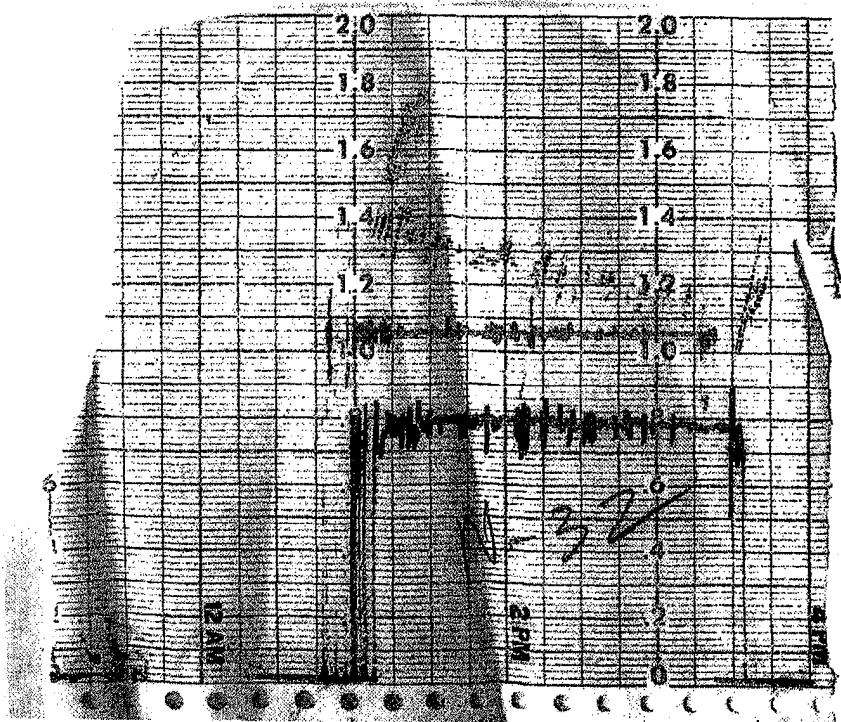
| EQUIPMENT | PAGE | CG    | 03 | CODE                                                                                                                                                                      | KY-907-D (E) | EST. WGT.  | 3480 | LBS. | USE<br>LBS. | N<br>CODE | ACCT.<br>LBS. |
|-----------|------|-------|----|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|------------|------|------|-------------|-----------|---------------|
| SV        | 11   | Con't | 56 | When Homog complete, Rinse in V356 with hot water From hot water mixer                                                                                                    |              |            |      |      |             |           |               |
|           |      |       | 57 | When S56 complete, turn off Homog & stearate pump                                                                                                                         |              |            |      |      |             |           |               |
|           |      |       | 58 | Stir 5 min at 198-200°F                                                                                                                                                   |              |            |      |      |             |           |               |
|           |      |       | 59 | Shut-off steam                                                                                                                                                            |              |            |      |      |             |           |               |
|           |      |       | 60 | Run in V-356 from S32 and stir 5 min<br>Record: pH 3.2 (3.3-3.7)                                                                                                          |              |            |      |      |             |           |               |
|           |      |       | 61 | If necessary, adj pH to 3.3-3.7 (Downward only) and<br>Record: pH                                                                                                         |              |            |      |      |             | 15-A      |               |
|           |      |       | 62 | Run in N-7-D from S34 in 4-6 min and stir 5 min                                                                                                                           |              |            |      |      |             |           |               |
|           |      |       | 63 | Record: pH 4.2 (4.2-4.4) and if necessary, adj to<br>pH 4.2-4.4 & Record: pH 4.3 Assume 78%<br>(Dilute 10 parts water to 1 part N-7-D Assume 50%)<br>Siphon N-7-D into SV |              |            |      | 18   | 27-D<br>7-D | 15        |               |
|           |      |       | 64 | Do not stop agitator                                                                                                                                                      |              |            |      |      |             |           |               |
|           |      |       |    | START                                                                                                                                                                     | FIN          | OPTR       |      |      |             |           |               |
|           |      |       |    | 11:00 PM                                                                                                                                                                  | 2:35 AM      | 235-37-323 |      |      |             |           |               |



214







DUP050456507

