

S.V. 243. (244) Automated C.V.  
CG Q3 CODE KY-907-D PKG. \_\_\_\_\_  
→ FEEL-2 34179  
EST. WGT. 1080 LBS.

STD. HRS. \_\_\_\_\_ TIME 11P M  
14 YC-2-B 93 4 Lot 24478 2400#  
14 YC-2-B 93 4 Lot \_\_\_\_\_#  
14 YC-2-B 93 4 Lot \_\_\_\_\_#

| PROCESSES |          | APPROVED BY |              |
|-----------|----------|-------------|--------------|
| ( )       | KY-907-D | (D)         | EWK 12/12/77 |
| ( )       |          | ( )         | DCG 12/13/77 |
| ( )       |          | ( )         | MW 12/15/77  |
| ( )       |          | ( )         |              |
| TYPED BY  |          |             |              |
| PJ 2/3/78 |          |             |              |

Water & color only

Total Weight - 3480#

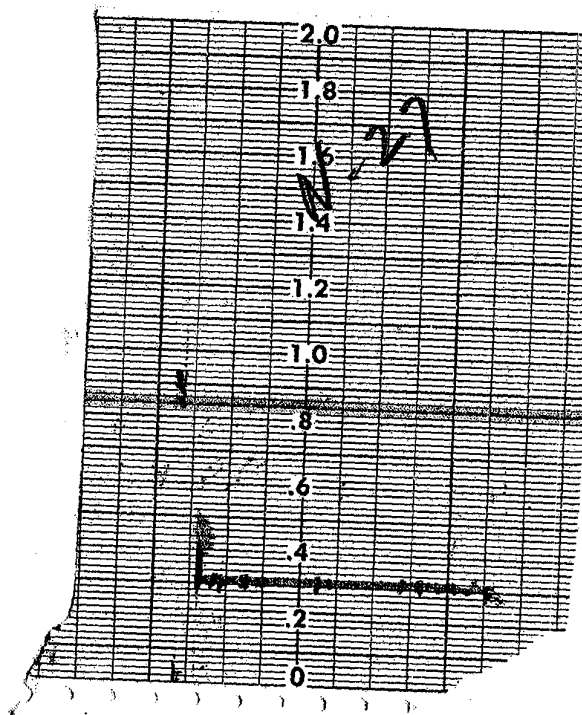
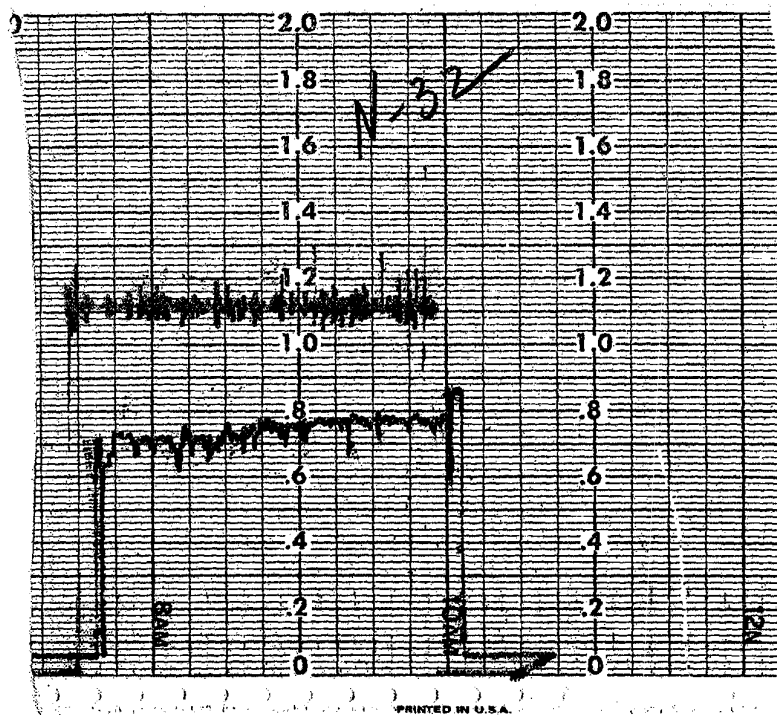
NON-BLEEDING

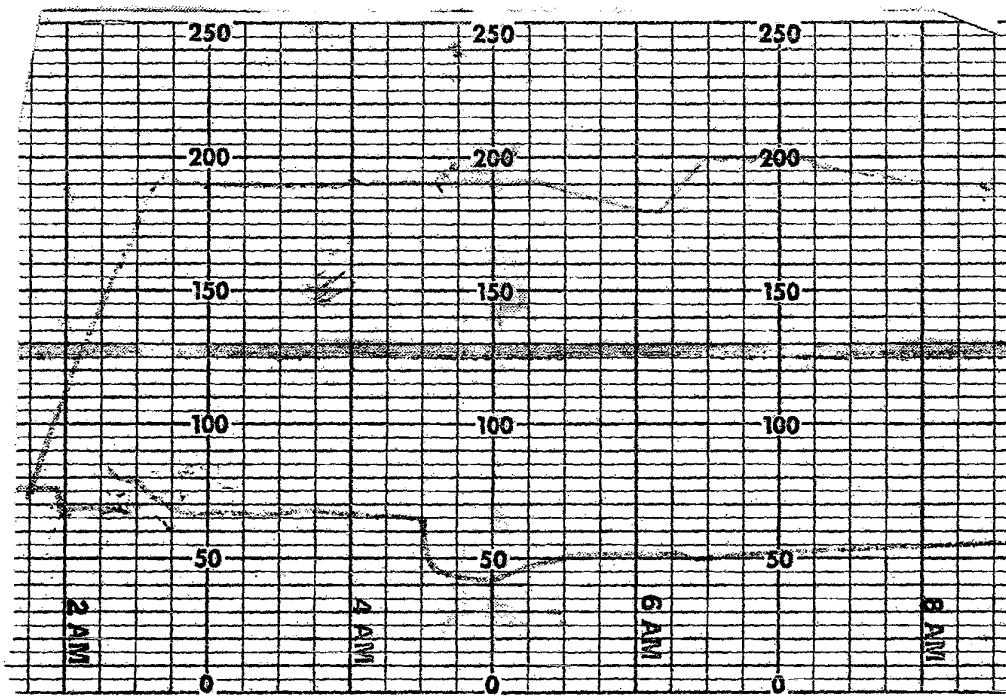
| EQUIPMENT    | NAME                                                                                       | USE LBS. | N CODE | ACCT. LBS. |
|--------------|--------------------------------------------------------------------------------------------|----------|--------|------------|
| 203          | 60" (990 G) KROLOR® - YELLOW MEDIUM                                                        |          |        |            |
| 8            | 1 Run 33" (560 G) water into V-203                                                         |          |        |            |
| 205          | 2 Pour in                                                                                  | 320      | 32-D   | 320        |
| 1            | 3 Dump in                                                                                  | 48 x 50  | YC-2-B | 2400       |
|              | Record: Start 6:20 PM                                                                      | 24478    | 2400   |            |
|              | Fin 7:30 PM                                                                                |          |        |            |
| 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, wash color thru Homog at 1800-2200 psi using minimum water               |          |        |            |
|              | 7 Record V-205 Vol 50" & adj to 60" (2100 G)                                               |          |        |            |
|              | 8 Inspect Homog strainer & clean if necessary                                              |          |        |            |
| 205 & SV     | 9 Run 10" (514 G) water into SV & start agitator                                           |          |        |            |
| 2            | 10 Pump V-205 thru Homog at 4800-5200 psi into V- 243                                      |          |        |            |
|              | Record: Time Start 4:45 PM Total Min 125                                                   |          |        |            |
|              | 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      | 12 SP Step 01 - Set Formula Selector to position #2 (V-243) or #7 (V-244)                  |          |        |            |
| 3            | 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:                              |          |        |            |
|              | 11 LG 28 % - 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. 3FC20 (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 & CP      | 16 Operator Step PB                                                                        |          |        |            |
| 4            | 17 Record Level 2 LG 66 %. If below 35% follow solution make-up procedure for N-27-D       |          |        |            |
|              | 18 Adj to 48" (2470 G)                                                                     |          |        |            |
|              | 19 Record: pH 10.5                                                                         |          |        |            |
|              | 20 Adj to 11.1-11.3 using N-7-D diluted to 5% Assume 50%                                   | 22       | 7-D    | 11         |
|              | (10 parts water to 1 part N-7-D)                                                           |          |        |            |
|              | Siphon into SV Record: pH 11.3                                                             |          |        |            |
|              | 21 Operator Step PB                                                                        |          |        |            |

V243

| EQUIPMENT | PAGE | CG | 03 | CODE | KY-907-D (D)                                                    | EST. WGT. | 3480     | LBS.       | USE   | N             | ACCT. |
|-----------|------|----|----|------|-----------------------------------------------------------------|-----------|----------|------------|-------|---------------|-------|
|           |      |    |    |      |                                                                 |           |          |            | LBS.  | CODE          | 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         | 26   |    |    |      | 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)                                                  | 9.9       | 9.0-10.0 | 9:15 P.M.  |       |               |       |
|           |      |    |    |      | 14/47 (60 min)                                                  | 9.9       | 9.0-10.0 | 9:45 P.M.  |       |               |       |
|           |      |    |    |      | 15/48 (2 hrs)                                                   | 9.8       | 9.0-10.0 | 10:45 P.M. |       |               |       |
|           |      |    |    |      | 16/49 (2 hrs 25 min)                                            | 9.8       | 9.0-10.0 | 11:10 P.M. |       |               |       |
|           |      |    |    |      | 17/50 (3 hrs Final)                                             | 7.5       | 7.5-8.5  | 11:45 P.M. |       |               |       |
|           |      |    |    |      | 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                                                      |           |          | Assume 78% |       |               |       |
|           | 29   |    |    |      | Sift in                                                         |           |          |            | ✓ 50  | 27-D<br>128-A | 50    |
| 302       | 30   |    |    |      | Add 17" (208 G) water to V-302                                  |           |          |            |       |               |       |
| 6         | 31   |    |    |      | Add & stir 2 min for S58                                        |           |          | Assume 50% | ✓ 100 | 7-D           | 50    |
| PT        | 32   |    |    |      | During strike pump into PT                                      |           |          |            | 318   | 169-A         | 318   |
| 7         | 33   |    |    |      | Pump in                                                         |           |          |            | 36    | 155-A         | 36    |
|           | 34   |    |    |      | Pump in                                                         |           |          |            | 36    | 160-A         | 36    |
|           | 35   |    |    |      | Stir 10 min with lightning mixer for S39                        |           |          |            |       |               |       |
| 356       | 36   |    |    |      | During strike run <sup>14"</sup> 20" (244 G) water into V-356   |           |          |            |       |               |       |
| 8         | 37   |    |    |      | Turn on steam                                                   |           |          |            |       |               |       |
|           | 38   |    |    |      | Add to 267" (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        | 44   |    |    |      | When S29 complete, heat SV to 198-200°F in 5-10 min             |           |          |            |       |               |       |
| &         | 45   |    |    |      | Close water line & discharge valves at stearate pump            |           |          |            |       |               |       |
| SP        | 46   |    |    |      | Open V-356 Discharge valves to stearate pump inlet              |           |          |            |       |               |       |
| 9         | 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                                            |           |          |            |       |               |       |

| EQUIPMENT | PAGE 3 CG 03 CODE KY-907-D (D) EST. WGT. 3480 LBS.         | USE LBS.   | N CODE  | ACCT. LBS. |
|-----------|------------------------------------------------------------|------------|---------|------------|
| SV & SP   | 52 When S51 complete turn off Homog & stearate pump        |            |         |            |
|           | 53 Stir 5 min at 198-200°F                                 |            |         |            |
|           | 54 Shut off steam                                          |            |         |            |
| 9         | 55 When S54 complete, Operator PB                          |            |         |            |
| Con'T     | 56 SP Step 23/53 Record pH 3.4 (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 6.0 (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% | 30      | 27-D       |
|           | Siphon N-7-D into SV                                       |            |         | 23         |
|           | 60 Operator Step PB                                        |            |         |            |
|           | 61 Operator Step PB                                        |            |         |            |
|           | 62 SP Step 60 - Batch complete                             |            |         |            |
|           | Pumped to V-240                                            |            |         |            |
|           | START                                                      | FINISH     | OPTR    |            |
|           | Time                                                       | Time       | SP Step |            |
|           | 3:14 PM                                                    | 11:11 PM   |         | 54-259     |
|           | 11:00 PM                                                   | 2:20 AM    |         | 409-223    |





GRAPHIC CONTROLS CORPORATION

DUP050094120

