

MAKING INSTRUCTIONS: BATCH UNIT

SV 24-241 (AUTOMATED)

CV

DV

CG 03 CODE KY-787-D PKG

PUNCHED & CHECKED

EST WGT 1090 LBS

36046

JUN 1 1967

STD HRS 8.9 TIME 3P M14 YC-2-B 93 4 LOT _____ #
LOT _____ #
LOT _____ #

PROCESSES		APPROVED BY
() KY-787-D	Q	EWK 9-22-76
()	()	DCG 9-27-76
()	()	MTW 9-30-76
()	()	
RE TYPED BY		
CJH 2-8-80		

#4 Homog 1st pass
2nd pass

TOTAL WGT 3490#

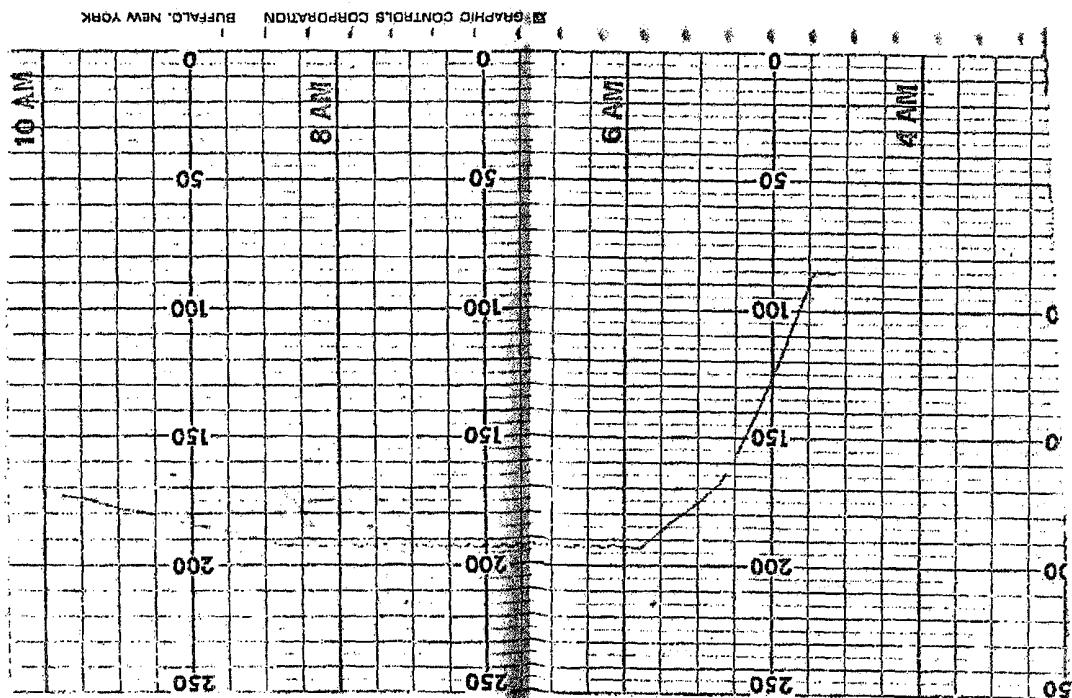
NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205 1	1 RUN 60" (992 G) WATER INTO V-203 <i>Set agitator at high speed</i>			
	2 WEIGH IN DRUM & POUR IN	320	32-D	320
	3 DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
	RECORD: START <u>1:45 PM</u>			
	FIN <u>1:48 PM</u>			
	4 ADD TO 70" (1200 G) <i>2400-2600</i>			
	5 PUMP V-203 THRU HOMOG #3 AT 1800-2000 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 <u>41</u> " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205 & SV 2	9 RUN 10" (514 G) WATER INTO SV START AGITATOR			
	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V-205			
	RECORD: TIME START <u>9:35P</u> TOTAL MIN <u>1:20</u>			
	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 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 <u>89%</u> - PRESET #1 80 GAL		15-A	160
	B. 13LG <u>78%</u> - 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	275
	B. 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	C. 3ER10 (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 & SP & CP 4	16 OPERATOR STEP PB			
	17 RECORD LEVEL 2 I.G. <u>88%</u> IF BELOW 35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
	18 ADJ TO 48" (2470 G)			
	19 RECORD: pH <u>10.5</u>			
	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)	20	1-D	10
	SIPHON INTO SV. RECORD pH <u>11.1</u>			
	21 OPERATOR STEP PB			

V-244

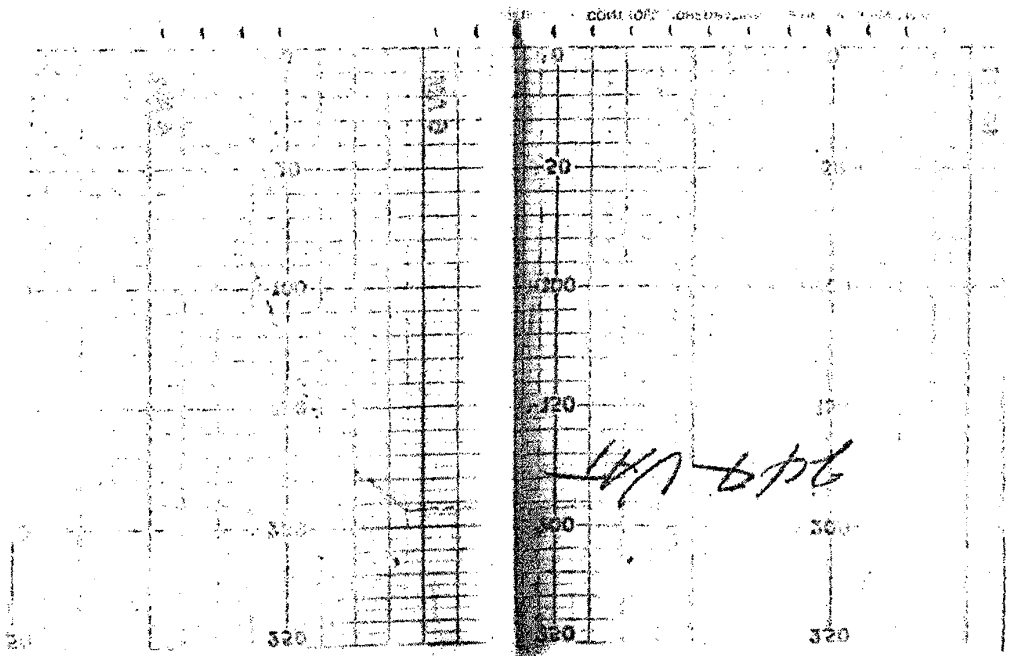
EQUIPMENT	PAGE 2 CG 03 CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH <u>9.95</u> (9.5-10.0)				
SP	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO				
&	24	OPERATOR STEP PB				
CP	25	SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS				
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>9.8</u>	9.0-10.0	<u>1:55</u>	
		14/47 (60 MIN)	<u>9.8</u>	9.0-10.0	<u>2:25</u>	
		15/48 (2 HRS)	<u>9.8</u>	9.0-10.0	<u>3:25</u>	
		16/49 (2 HRS 25 MIN)	<u>9.8</u>	9.0-10.0	<u>4:50</u>	
		17/50 (3 HRS FINAL)	<u>7.7</u>	7.5-8.5	<u>4:25</u>	
		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	
339	29	WHILE STRIKING, RUN 30" (234 G) WATER INTO V-339				
6	30	ADD IN 7-8 MIN		350	530-A	350
	31	ADJ TO 49" (382 G) AT 80 - 100°F				
	32	STIR 5 MIN & RECORD pH <u>10.1</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>38.2</u>				
	35	SET PRESET #8 TO <u>38.2</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%	160	7-D 80
243	38	SP STEP 17/50 - AFTER CHECKING pH, OPERATOR STEP PB				
	39	SIFT IN 2 BAGS		100	128-A	100
SP	40	SP STEP 23/53 - RECORD pH <u>3.5</u> (3.7-4.2)				
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN				
CF	42	RECORD: pH <u>9.4</u> (9.0-9.5) & IF NECESSARY ADJ. pH 9.0-9.5				
8		& RECORD: pH		ASSUME 77%	27-D	
		(DILUTE 10 PARTS WATER TO 1 PART N-7-D)		ASSUME 50%	7-D	
		SIPHON N-7 INTO SV				
	43	OPERATOR STEP PB				
	44	SP STEP 29/58 RECORD: pH <u>9.9</u> (9.0-10.0) TIME				
	45	OPERATOR STEP PB				
	46	SP STEP 60 - BATCH COMPLETE				
		START	FINISH			
		TIME	TIME	SP STEP	OPTR	
		<u>3:PM</u>	<u>11:PM</u>		<u>54-120</u>	
		<u>11:00P</u>	<u>3:00/AM</u>		<u>285-323</u>	

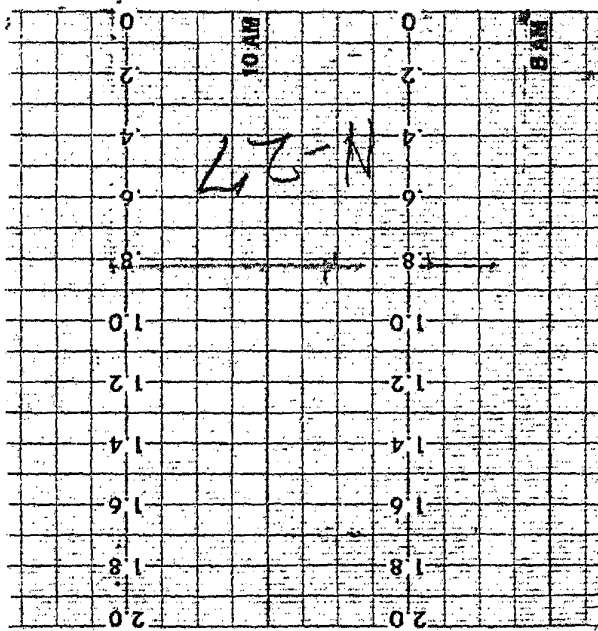
1:25/AM

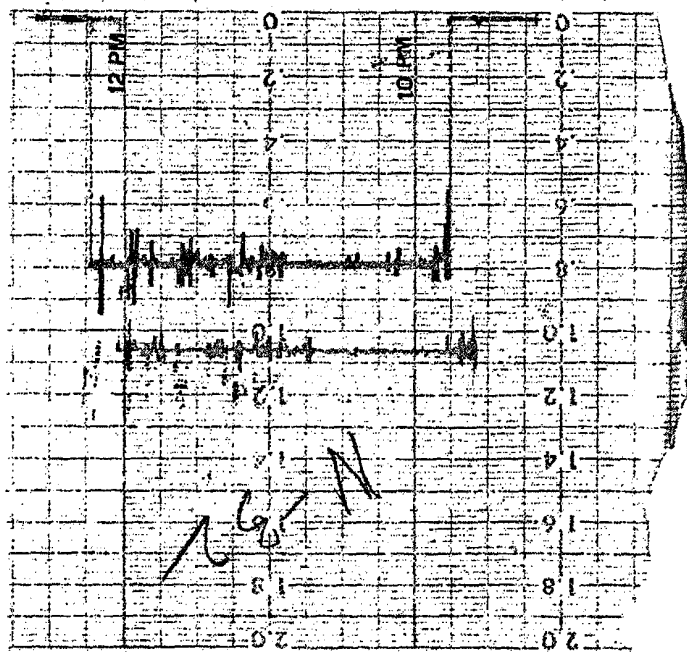


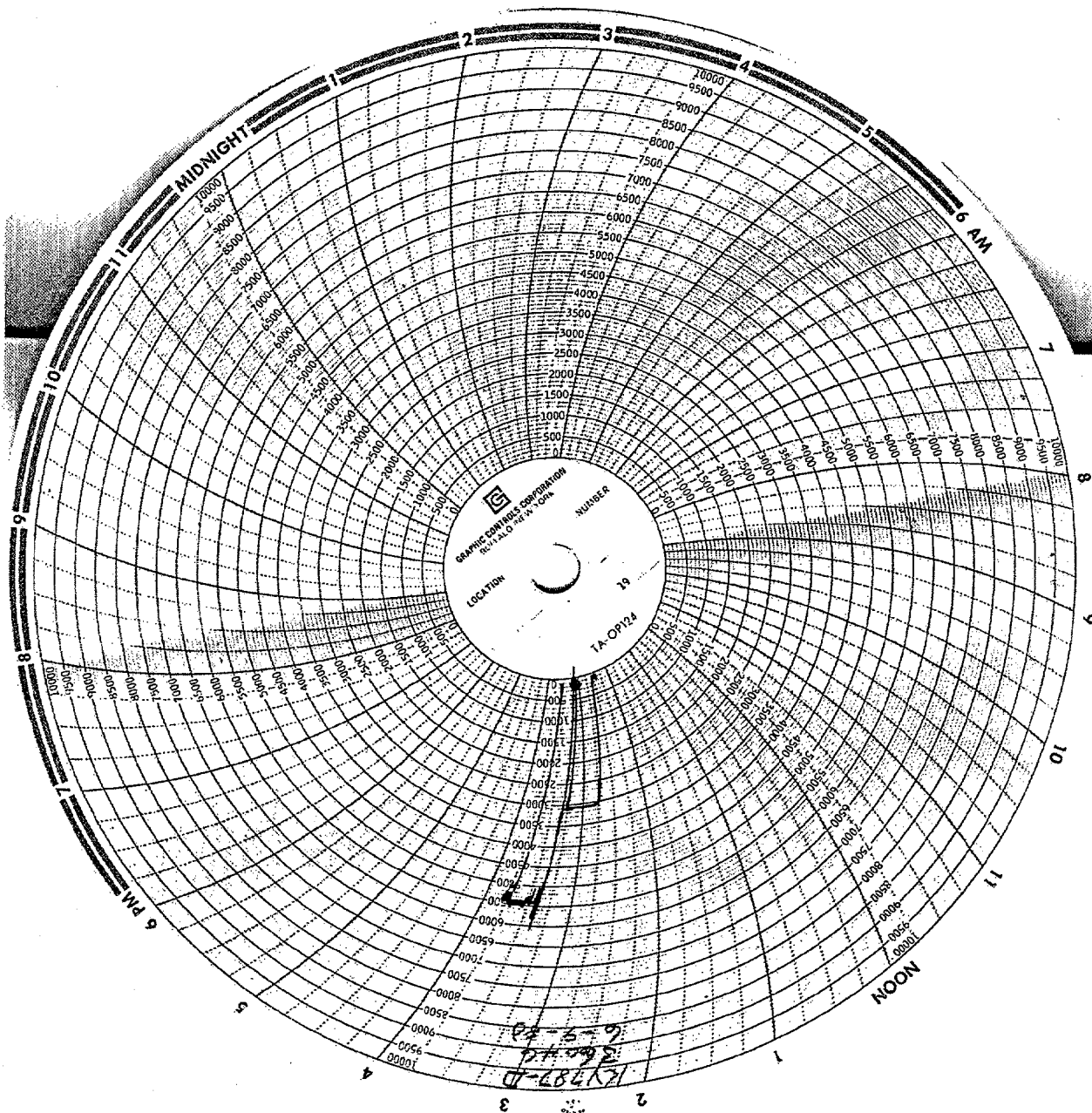
N32434.01

DUP050461214









N32434.02

DUP050461218

