

(243) 244, 246, 247, 262

C.V.

D.V.

CO 03 CODE KY-787-D PKO, _____

DEC 14 33311

EST. WGT. 1921 LBS.

STD. HRS. _____ TIME 3 P M

14 YC-2-B 93 4 Lot _____ #
 14 YC-2-B 93 4 Lot _____ #
 14 YC-2-B 93 4 Lot _____ #

PROCESSES		APPROVED BY
() KY-787-D	(S)	EWK 10-19-77
() Alternate	()	DCG 10-25-77
()	()	MTW 10-26-77
()	()	
TYPED BY		
JIC 11-4-77		

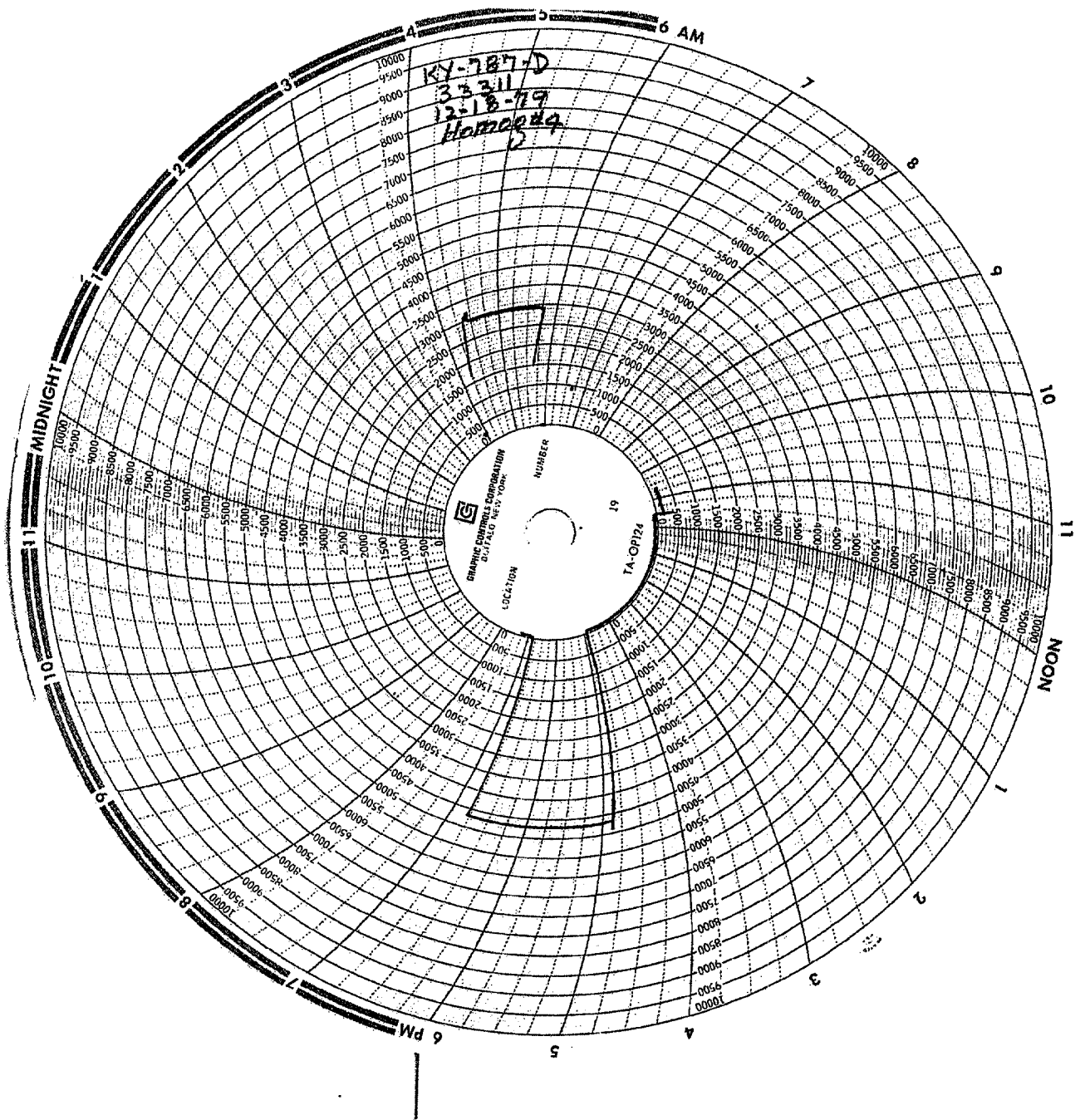
Total Wgt 6121# (REQ. _____)

NON-BLEEDING

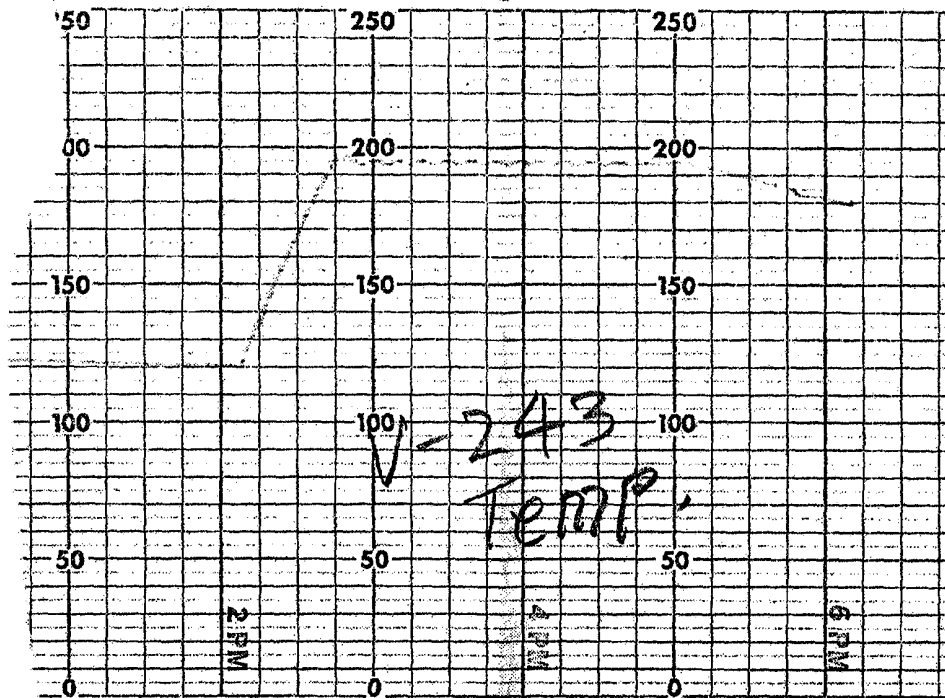
PMENT		NAME: KROLO® YELLOW-MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1	Run 39" (645 G) water into V-203 & pour in Assume 50%	40	7-D	20
	2	Weigh in drum & pour in	560	32-D	560
	3	Dump in & stir 5 min LOT	84 x 50	YC-2-B	4200
		Record: Start			
		Fin			
	4	Adj to 75" (1275 G)			
	5	Pump V-203 thru Homog 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. " & adj to 60" (2100 G)			
	8	Inspect Homog strainer & clean if necessary			
SV & 205 2	9	Run " (200 G) water into V- install temp chart & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into SV-			
		Record: Time Start Total Min			
	*	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 & pump thru Homog at 4800-5200 psi			
349 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ± 1000# water into V-384 & heat to 110-120°F			
	14	Weigh into V-384 & pump to V-349	3220	32-D	3220
	15	Run ± 1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 17" (805 G) & stir 15 min or longer			
	17	Record: Be' (18.0 ± 0.2)			
SV 4	18	When S 11 Homog complete, adj SV to " (2570 G)			
	19	Record: pH & adj to 11.4-11.6 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon into SV & Record: pH			
	20	Heat to 190-194°F in 35-45 min (V-262) or in 55-65 min (V-243, 244, 246, 247) & Record: HT °F & Rec °F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 39" (1070 G) water into V-343			
	22	Meter in from V-386 M #/G Gal		27-D	481
	23	Stir 15 min or longer			
	24	Record: Be' (4.8 ± 0.1)			

V-243

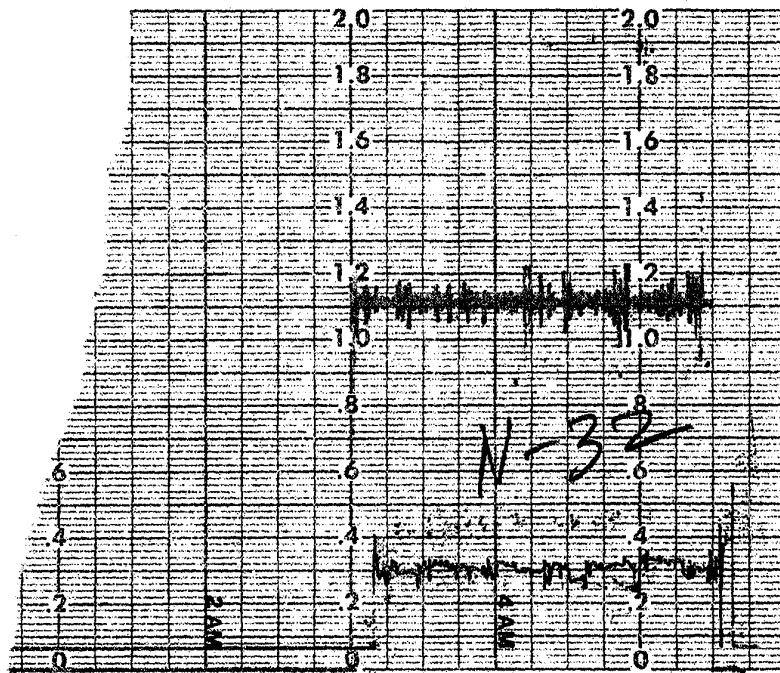
JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22	SP Step 06/39 - After heat up Record: pH <u>9.9</u> (9.5-10.0)						
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
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)	<u>9.8</u>	9.0-10.0	<u>10:30 AM</u>			
		14/47 (60 min)	<u>9.9</u>	9.0-10.0	<u>11:00 AM</u>			
		15/48 (2 hrs)	<u>9.9</u>	9.0-10.0	<u>12:00 AM</u>			
		16/49 (2 hrs 25 min)	<u>9.9</u>	9.0-10.0	<u>12:25 AM</u>			
		17/50 (3 hrs Final)	<u>7.9</u>	7.5-8.5	<u>1:00 AM</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 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	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>49</u> & calculate <u>49</u> (Vol) x 0.78 = <u>38.2 G</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>3.4</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>9.3</u> (9.0-9.5) & if necessary add 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-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.3</u> (9.0-10.0) Time <u>2:15 AM</u>						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time	Time	SP Step				
		<u>1:00 AM</u>	<u>7:00 AM</u>			<u>235-54</u>		
		<u>11:00 AM</u>	<u>2:15 AM</u>			<u>235-301</u>		



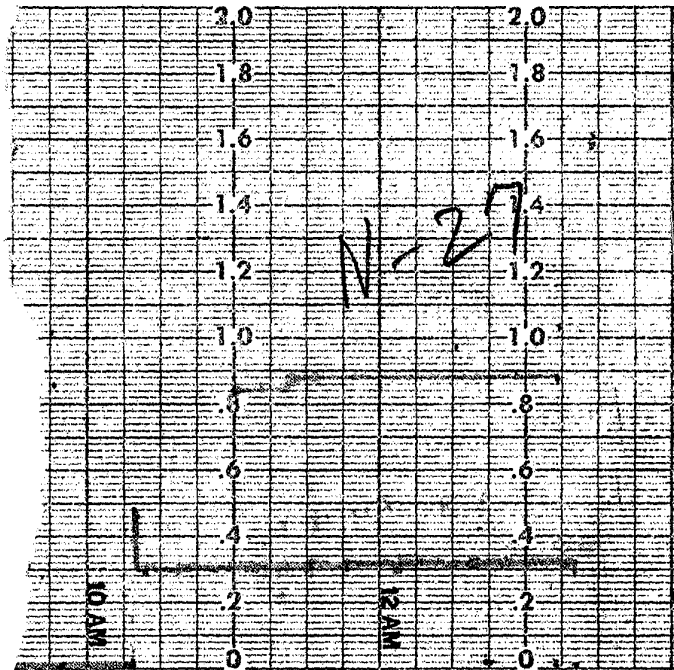
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