

S.V.

243244 (Automated)

C.V.

D.V.

CG 03 CODE KY-908-D PKG.

→ JAN 19 33896

EST. WGT. 949 LBS.

STD. HRS. TIME 7A M

14 YC-3-B 93 4 Lot 24421 2.614
14 YC-3-B 93 4 Lot
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Total Wgt. 3549#

PROCESSES		APPROVED BY	
() KY-908-D	(D)	EWK	12/12/77
()	()	DCG	12/14/77
()	()	MW	12/19/77
()	()		
TYPED BY			
rj 1/31/78			

Homog #3 — 1st Pass

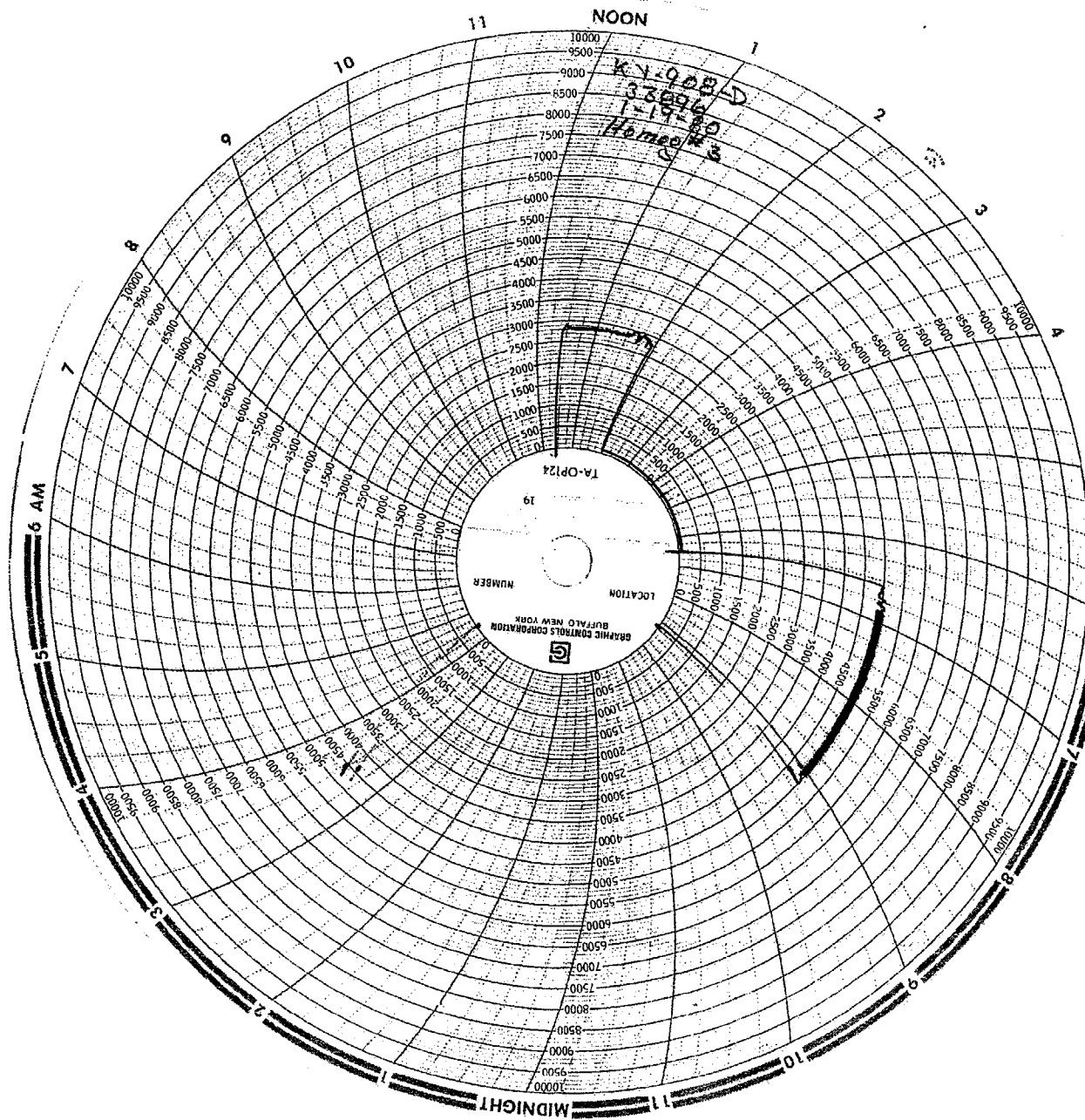
EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	60" (890 G) KROLO® YELLOW - LIGHT 1 Run 23" (360 G) water into V-203 2 Pour in 3 Dump in Record: Start 10:45 AM Lot 24421 Fin 12:00 75" (925 G) 60" (890 G) 4 Adj to 70" (1200 G) 2400-2600 5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using Minimum water 7 Record: V-205 Vol 42" & adj to 60" (2100-G) 8 Inspect Homog, strainer & clean if necessary	345 52 x 50 52	32-D YC-3-B	345 2600
205 & SV 2	9 Run 10" (514 G) water into V-205 start agitator 10 Pump V-205 thru Homog at 4800-5200 psi into V- Record: Time Start 1:00 PM Total Min 15.5 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 #3 (V-243) or #8 (V-244) 13 Press SV Cam Reset PB - Set 22 TC in Auto Remote (Temperature is set at 190-194°F) 14 Record levels and set Raw Material Counter #1 as follows 11LG 70% - preset #2 208 Gal 15 Set strike flow controllers as follows a. 3FC10 (N-27-D Controller) In Manual 0.54 GPM b. 3FC20 (N-27-D water) in Manual Local 4.4 GPM c. 3FR10 (N-27-D Water) Ratio 0.8 d. 8FC10 (N-32-D Controller) in Manual 0.72 GPM 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		15-A	416
SV SP & CP 4	16 Operator Step PB 17 Record Level 21G 77%. If below 35% follow solution make-up procedure for N-27-D 18 Adj SV to 47" (2400 G) 19 Record pH 10.9 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 11.2 20 Operator Step PB	14	7-D	7

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EQUIPMENT	PAGE 2	CG 03	CODE KY-908-D (D)	EST. WGT. 3549	LBS.	USE LBS.	N CODE	ACCT LBS.
SV SP 5	21	SP Step 06/39 - After heat up Record: pH 9.9 (9.5-10.0)						
	22	Switch 3FC20, 8FC10, 8FC20 to auto						
	23	Operator Step PB						
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits Switch 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: 11:15 PM						
		SP Step						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	9.7	9.3-10.0	11:45 PM			
		14/47 (60 min)	9.7	9.3-10.0	12:15 PM			
		15/48 (2 hrs)	9.7	9.3-10.0	1:15 PM			
		16/49 (2 hrs 25 min)	9.7	9.3-10.0	1:40 PM			
		17/50 (Final 3 hrs)	8.3	7.5- 8.5	2:15 PM			
		Note: (1) If pH not as specified notify Supervisor & note in						
		Log (2) If final pH is above 8.5 adj to 7.5-8.5						
		& Record: pH Assume 78%						
	28	Sift in			50	27-D	128-A	50
302	29	Add 17" (208G) water to V-302						
	30	Add & stir 2 min for S57			Assume 50%	100	7-D	50
PT	31	During Strike pump into PT				312	169-A	312
	32	Pump in				36	155-A	36
	33	Pump in				36	160-A	36
	34	Stir 10 min with lightning mixer for S38						
356	35	During strike Run 29" (244G) water into V-356						
8	36	Turn on steam						
	37	Adj to 26% (317G) at 178-182°F 81-82°C						
	38	Pump PT mixture from S34 thru undersurface						
		Distributor AFAP						
	39	Rinse PT with hot water from hot water mixer & pump in						
	40	Shutoff pump 81-82°C						
	41	Stir 30 min at 178-182°F for S48						
	42	Do not shut off Agitator						
SV & SP 9	43	When S28 complete, heat SV to 198-200°F in 5-10 min						
	44	Close water line & Discharge valves at stearate pump						
	45	Open V-356 Discharge valves to stearate pump inlet						
	46	Open water valve at stearate pump & run water thru Homog at 2900-3100PSI to sewer						
	47	While Homog water at 2900-3100 PSI, open Homog Discharge valve to SV & close valve to sewer						
	48	Immediately open stearate pump Discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 PSI maintain SV at 198-200 F						
	49	While Homog V-356 to SV, shut off water valve at stearate pump ASAP						
	50	When Homog complete, Rinse in V-356 with hot water from hot water mixer						
	51	When S50 complete turn off Homog & stearate pump						
	52	Stir 5 min at 198-200°F						
	53	Shut off steam						

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EQUIPMENT	PAGE 3	CG 03	CODE KY-908-D (D)	EST. WGT. 3549	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV & SP	54	When S53 complete, Operator PB						
	55	SP Step 23/53 Record pH <u>3.1</u> (3.3-3.7)						
	56	If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH _____						
9		NOTE: Dissolve extra N-15-A in water at 110-120°F in drum						
Con't		Use - 30 gal of water to 50# N-15-A. Stir SV 5 min						
		After each addition						
	57	Run in N-7-D from S30 in 10-12 min & stir 5 min						
	58	Record: pH <u>3.6</u> (4.2-4.4) & if necessary adj to pH 4.2-4.4						
		& Record: pH <u>4.3</u> Assume 50%						
		(Dilute 10 parts water to 1 part N-7-D) Assume 78%						
		Siphon N-7-D into SV						
	59	Operator Step PB						
	60	Operator Step PB						
	61	SP Step 60 - Batch complete						



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