

S.V.

243 244 (Automated)

C.V.

D.V.

MAKING INSTRUCTIONS: BATCH UNIT

CG 03 CODE KY-908-D PKG.

JAN 27

24064

34129

EST. WGT. 949

LBS.

STD. HRS.

TIME

7 A M

14 YC-3-B 93 4 Lot

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24411, 2000#

23884, 600#

23884, 600#

Total Wgt. 3549#

NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	60" (990 G) KROLOR® YELLOW - LIGHT			
&	1 Run 23" (360 G) water into V-203			
205	2 Pour in	345	32-D	345
1	3 Dump in	52 x 50	YC-3-B	2600
	Record: Start 3:45 - PM.			
	Fin 4:25 PM			
	24411			
	23884			
75" (575 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	9 Run 10" (514 G) water into V-243 & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time Start 11:30 AM Total Min 14.5			
2	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	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)			
CP	14 Record levels and set Raw Material Counter #1 as follows			
3	11LG 52 % - preset #2 208 Gal		15-A	416
	15 Set strike flow controllers as follows			
	a. 3FC10 (N-27-D Controller) In Manual 0.54 GPM		27-D	180
	b. 3FC20 (N-27-D water) in Manual Local 4.4 GPM			
	c. 3ER10 (N-27-D/Water) Ratio 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 0.72 GPM		32-D	1215
	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			
	16 Operator Step PB			
SV	17 Record Level 21G = 48 % If below 35% follow solution			
SP	make-up procedure for N-27-D			
&	18 Adj SV to 47" (2400 G)			
CP	19 Record pH 10.2. Adj to 11.0-11.2 using N-7-D diluted to 5%			
4	(10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
	Siphon into SV & Record: pH 11.4			
	20 Operator Step PB			

N 27600

(JL)

EQUIPMENT		PAGE 2 CG 03 CODE KY-908-D (D) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT LBS.
SV	21	SP Step 06/39 - After heat up Record: pH 9.6 (9.5-10.0)			
SP	22	Switch 3FC20, 8FC10, 8FC20 to auto			
5	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:			
		SP Step			
		V-243/V-244			
		13/46 (30 min)	pH 9.6	Range 9.3-10.0	Time 8:10 AM
		14/47 (60 min)	9.6	9.3-10.0	8:40 AM
		15/48 (2 hrs)	9.7	9.3-10.0	9:40 AM
		16/49 (2 hrs 25 min)	9.7	9.3-10.0	10:10 AM
		17/50 (Final 3 hrs)	8.1	7.5- 8.5	10:45 AM
		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%		27-D	
	28	Sift in 31" (3796)	50	128-A	50
302	29	Add 17" (2080) water to V-302			
6	30	Add & stir 2 min for S57 Assume 50%	100/60	7-D	50%
PT	21	During Strike pump into PT	312	169-A	312
7	22	Pump in	36	155-A	36
	23	Pump in	36	160-A	36
	24	Stir 10 min with lightning mixer for S38			
356	25	During strike Run 20" (244G) water into V-356			
8	26	Turn on steam			
	27	Adj to 269 (317G) at 178-182°F 81-82°C			
	28	Pump PT mixture from S34 thru undersurface Distributor AFAP			
	29	Rinse PT with hot water from hot water mixer & pump in			
	30	Shutoff pump 81-82°C			
	31	Stir 30 min at 178-182°F for S48			
	32	Do not shut off Agitator			
SV & SP	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			
9	46	Open water valve at stearate pump & run water thru Homog at 2900-3100 PSI 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			

[illegible]



