

CG 03 CODE KY-787-D

PKG.

FEB 29

34628

PUNCHED & CHECKED

EST. WGT.

1090

LBS.

STD. HRS.

8.9

TIME

31 MAR - 3 1980

14 - YC-2-B 98 4

Lot 24480, 2400 #

Lot #

Lot #

PROCESSES		APPROVED BY	
() KY-787-D	()	()	EWK 9/22/76
()	()	()	DCG 9/27/76
()	()	()	MTW 9/30/76
()	()	()	
TYPED BY			
N.E. 2/12/77			

Homog # 3 - 1st Pass

Total Wgt. - 3490# 3390

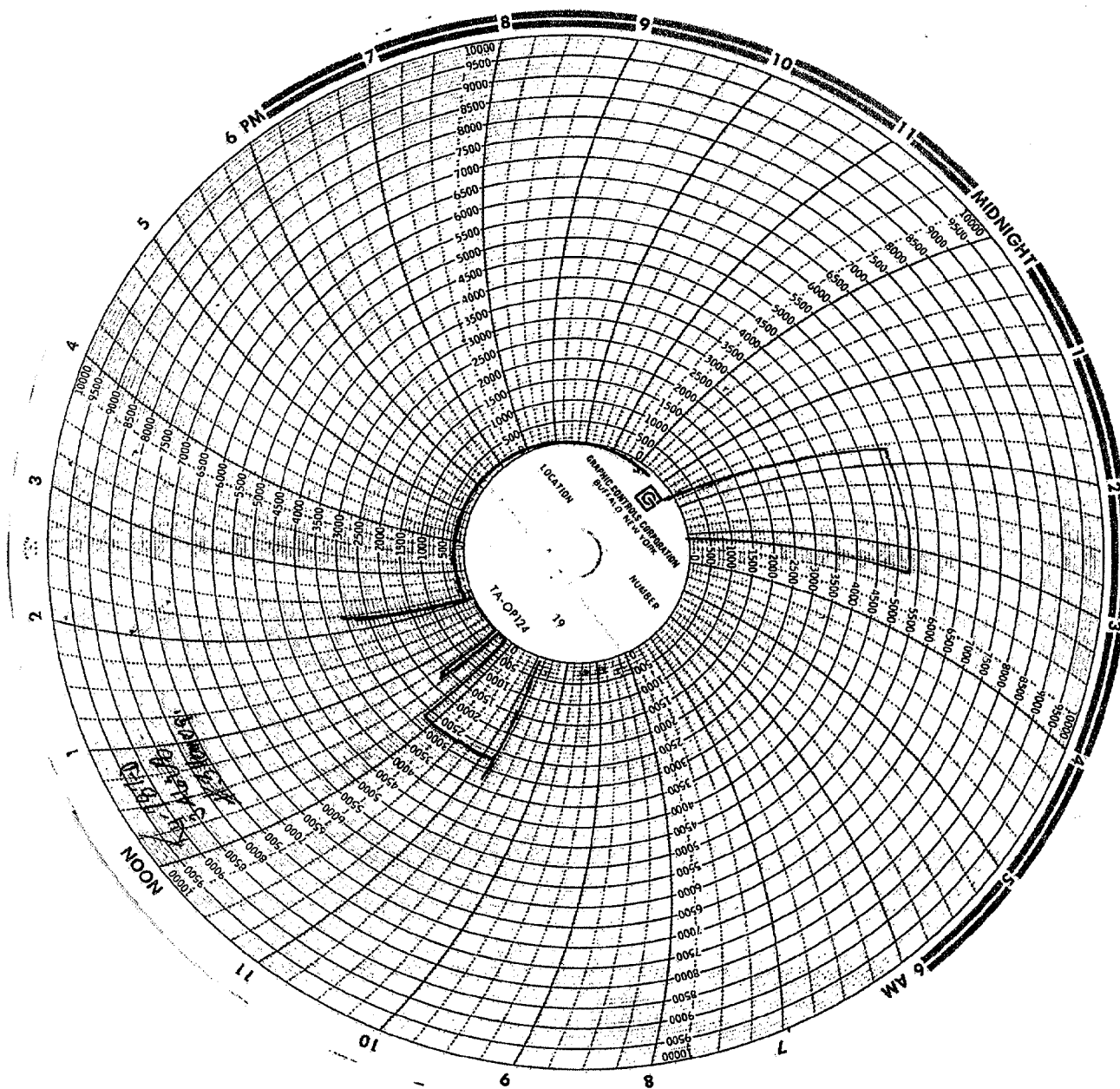
NON-BLEEDING

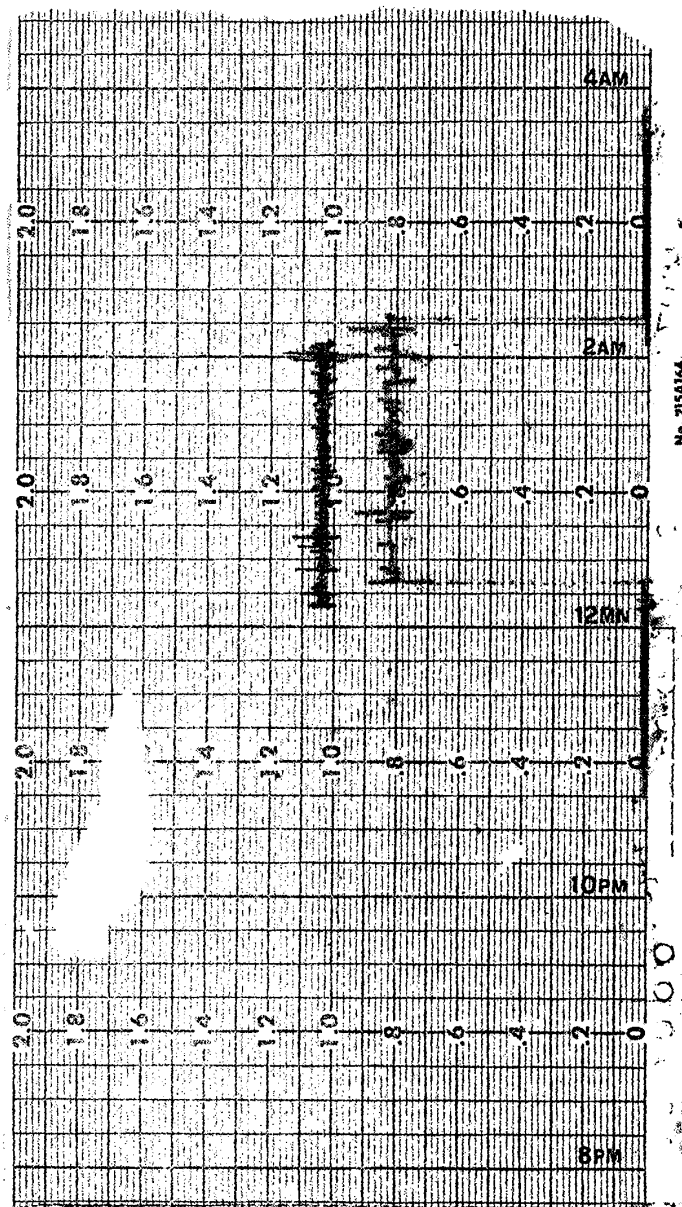
ITEM	NAME:	USE LBS.	N CODE	ACCT. LBS.
203	"KROLOR" - YELLOW MEDIUM			
203 & 205	1 Run 60" (992 G) water into V-203. <i>Set agitator on high speed</i>			
1	2 Weigh in drum & pour in	320	32-D	320
	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 3:00 PM	24480		
	Fin 4:00 PM			
	25" (12756)			
	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 1800-2000 psi using minimum water U-2163			
	7 Record V-205 Vol " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 <i>Run 10" (514G) Water into SV & start agitator</i>			
	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time start 3:45 Total Min 1:20			
	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 #2 (V-243) or #7 (V-244)			
& CP	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11G 64% - preset #1 80 Gal		15-A	160
	b. 13G 88% - 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-D	275
	b. 3FC20 (N-27-D Water) in Manual Local 5.28 GPM			
	c. 3FR10 (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	16 Operator Step PB			
SP	17 Record Level 2 LG 89%. If below 35% follow solution make-up procedure for N-27-D			
& CP	18 Adj to 48" (2470 G)			
4	19 Record: pH 10.5			
	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)	40	1-D	20
	Siphon into SV. Record pH 11.5			
	21 Operator Step PB			

V-243

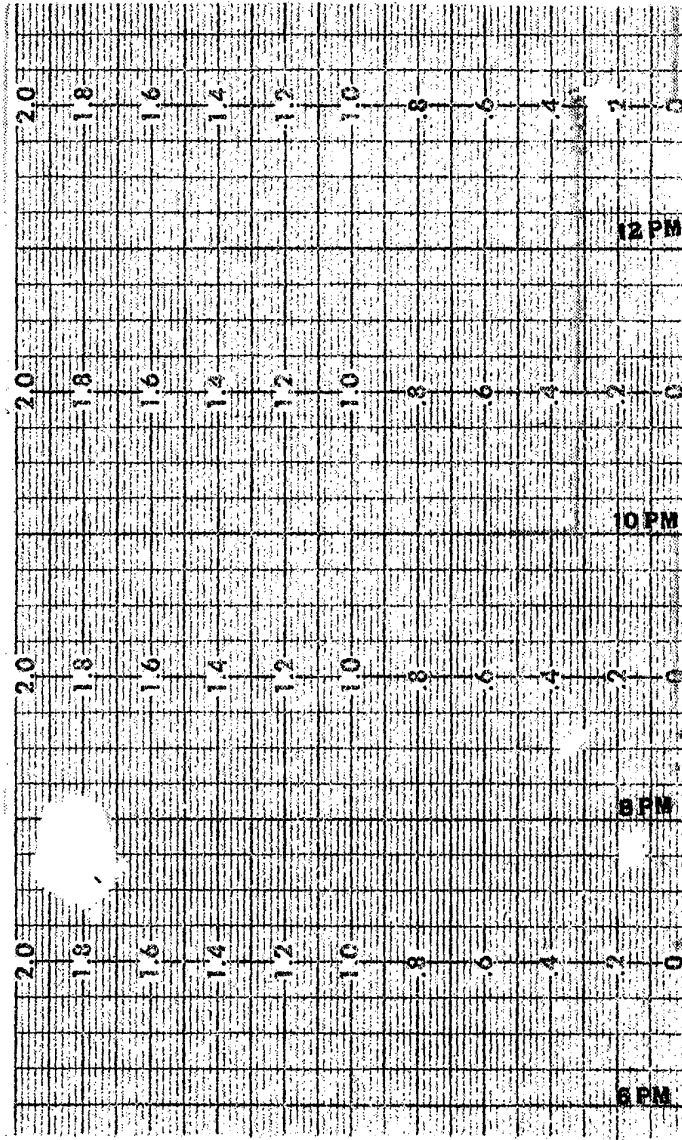
JIPMENT	PAGE 2	CG 03	CODE XY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACI LB
SV	22	SP Step 06/39 - After heat up Record: pH	10.0	(9.5-10.0)				
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
		Switch 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 7.0	Range	Time 6:40			
		13/46 (30 min)	7.0	9.0-10.0	7:10			
		14/47 (60 min)	9.8	9.0-10.0	7:40			
		15/48 (2 hrs)	9.8	9.0-10.0	8:40			
		16/49 (2 hrs 25 min)	9.75	9.0-10.0	9:25			
		17/50 (3 hrs Final)	9.8	7.5-8.5	9:40			
		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 10.1 (9.5-10.5)						
	33	Stir 15 min or longer to dissolve for SP Step 26			38.7			
	34	Record Vol 49 & calculate 49 (Vol) x 0.78 = G						
	35	Set preset #8 to 38.2 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	SP Step 18/51 - 2 Bags				100	128-A	100
SP	40	SP Step 23/53 - Record: pH 2.75 (3.7-4.2)						
&	41	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
CP	42	Record: pH 6.14 (9.0-9.5) & if necessary adj pH 9.0-9.5						
8		& Record: pH 9.4 Assume 77%					27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%				70	7-D	35
		Siphon N-7-D into SV						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH 9.0 (9.0-10.0) Time 11 AM						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish		Optr			
		Time	SP Step	Time	SP Step			
		7:4	51	11:00 P	120-201			
		3:00 P	11:00 P	2:35-2:59				
		7:4	11:15 A	120-101				

Batch
Pumped
to V 240





DUP050093853



GRAPHIC CONT'

REC'D IN USA

