

S.V. 243 244, Automated

C.V.

D.V.

PROCESSES		APPROVED BY	
()	KY-781-D (N)	FNP	101378
()	()	SMJ	101378
()	()		
()	()		
TYPED BY			
EMW101378			

CG 03 CODE KY-781-D PKG.

→ JAN 22 33962

EST. WGT. 328 4128 LBS.

STD. HRS. TIME 3:PM

14 YC-3-B 93' 4 24425 2.000 #

14 YC-3-B 93 4 24426 1.100 #

14 YC-3-B 93 4 #

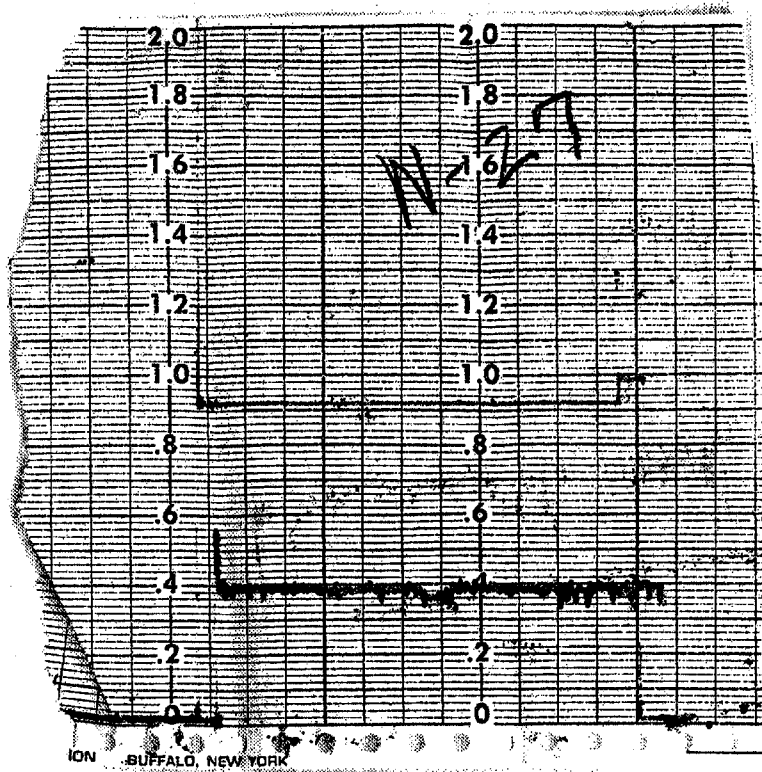
Total Wgt. 4428# (Req)

Homog #3 - 2nd pass
NON-BLEEDING

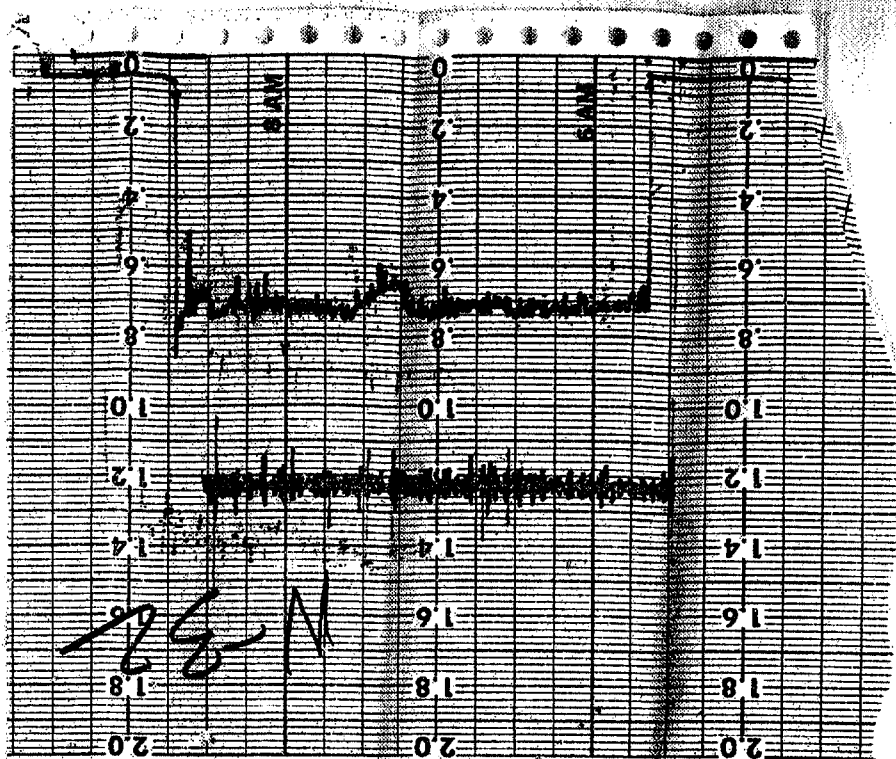
QUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203 & 205	1 Run 60" (992 G) water in V-203 & add	Assume 50%	36	7-D 18
	2 Weigh in drum & pour in		442	32-D 442
1	3 Dump in & stir 5 min	Lot 62	68 x 50	YC-3-B 3300
	Record: Start 9:00 AM	24425	2.00	3100
	Fin 10:10 PM	24426	1.10	
	75" (1225 G)	2400-2600		
	4 Adj to 80" (1360 G) & Record: pH (10.5-11.5)			
	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 38" & adj. to 45" (1662 G)			
	8 Inspect Homog strainer & clean if necessary			
205 & SV	9 Run 12" (200 G) water into SV & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
	Record: Time Start 5:00 PM Total Min 170			
	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	12 SP Step 01 - Set Formula Selector to position #1 (V-243) or #6 (V-244)			
3	13 Press SV Cam Reset PB-Set 22TC in Auto Remote (Temperature is set at 190-194°F)			
	14 Record levels and set Raw Material Counter #1 as follows:			
	a) 11LG 31% - preset #3	187 Gal	15-A	374
	15 Set strike flow controllers as follows:			
	a) 3FC10 (N-27-D Controller) in Manual	0.9 GPM	27-D	373
	b) 3FC20 (N-27-D Water) in Manual Local	6.3 GPM		
	c) 3FR10 (N-27-D / Water Ratio)	0.7		
	d) 8FC10 (N-32-D Controller) in Manual	1.20 GPM	32-D	2527
	e) 8FC20 (N-32-D Water) in Manual Local	5.4 GPM		
	f) 8FC20 (N-32-D Water) in Remote			
	g) 8FR10 (N-32-D / Water Ratio)	0.9		
SV	16 Operator Step PB			
SP & CP	17 Record Level 2LG 44%. If below 35% follow solution make-up procedure for N-27-D			
4	18 Adj SV to 54" (2800 G)			
	19 Record: pH 10.5			
	20 Adj pH to 11.4-11.6 using	Assume 50%	24	7-D 12
	(Dilute to 5% (10 parts water to 1 part N-7-D)			
	Siphon into SV. Record: pH 11.4			
	21 Operator Step PB			

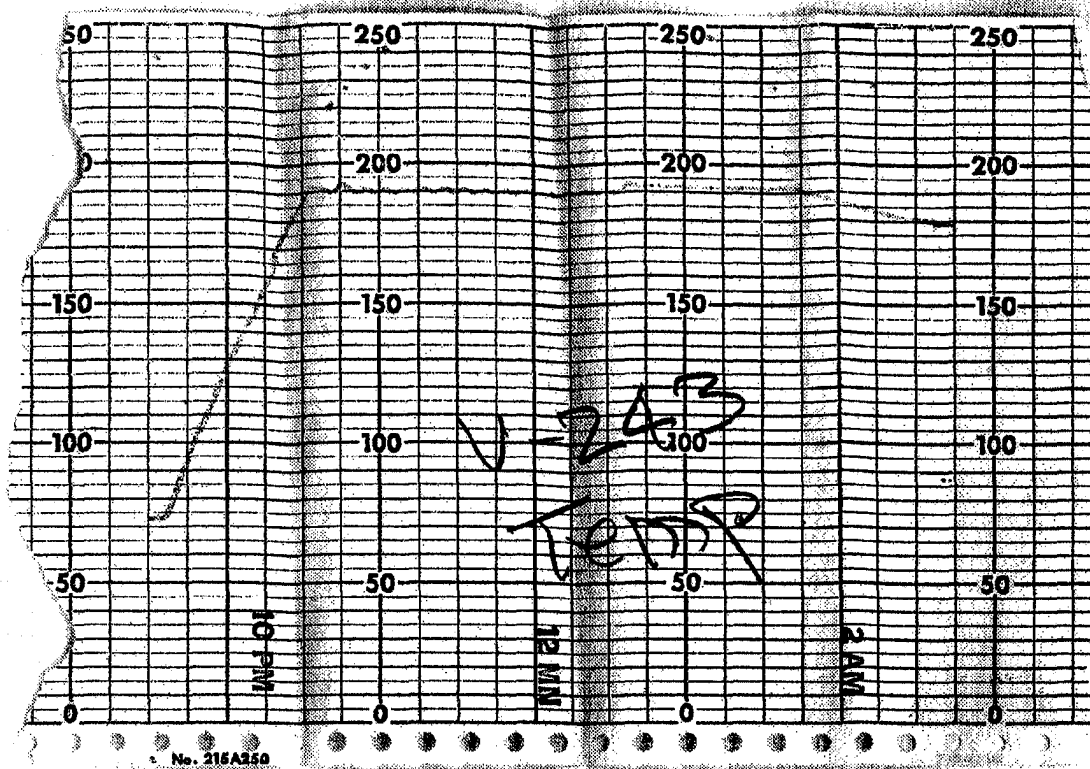
V-243

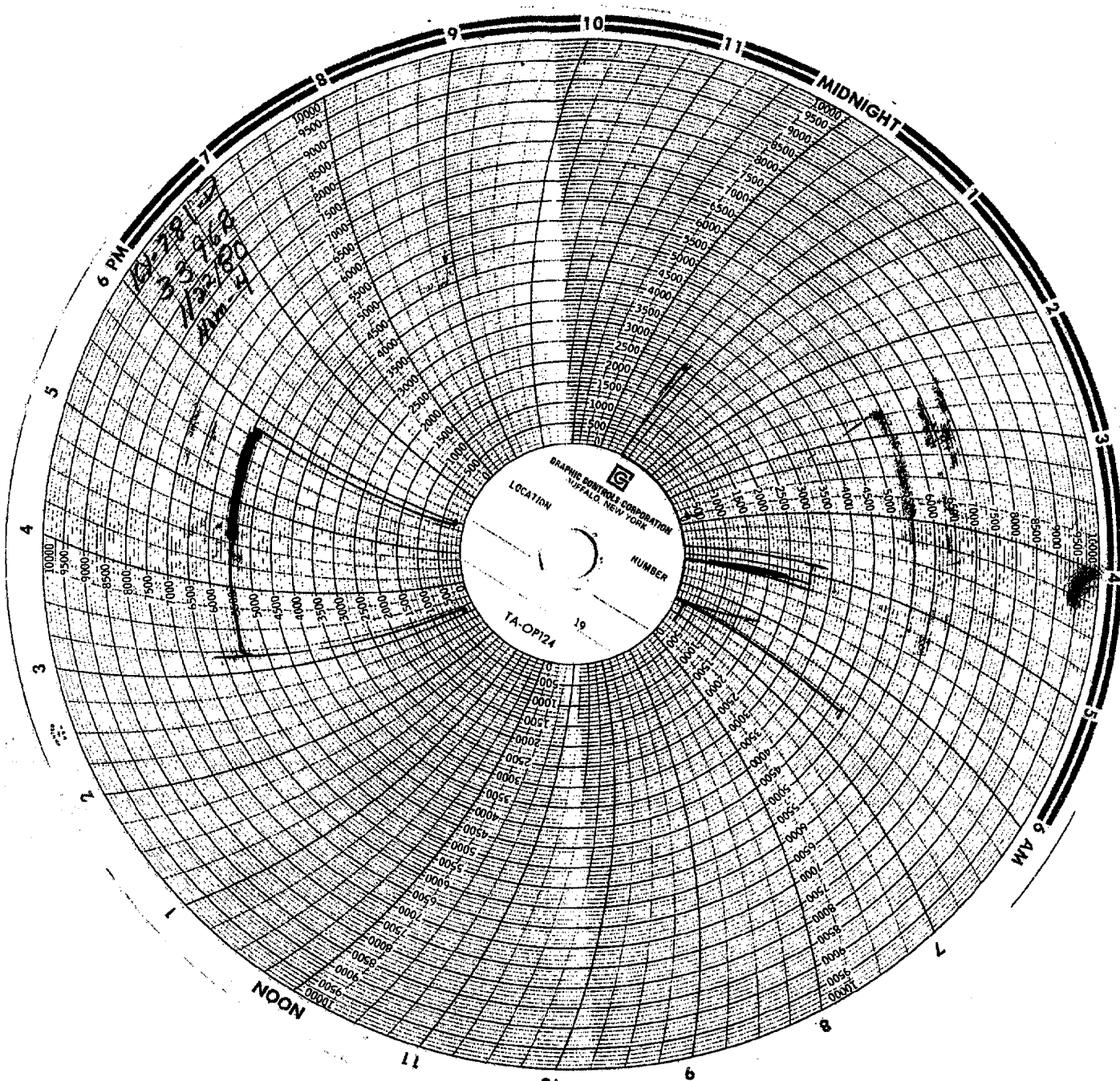
EQUIPMENT	PAGE 2 CG 03 CODE KY-781-D N EST. WGT. 1128 LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22 SP Step 06/39. After heat up Record: pH <u>10.7</u> (9.6-10.2)			
SP	23 Switch 3FC20, 8FC10, 8FC20, to Auto			
&	24 Operator Step PB			
CP	25 SP Step 10.43 - When 3FC20, 8FC10, 8FC20 water flow in limits switch 3FC10 to Auto. Operator Step PB			
5	26 SP Step 11/44 - When 3FC10, 3FC20, flow in limits, switch 3FC20 to Remote. Operator Step PB			
	27 During Strike, Record pH & Time as follows:			
	SP Step pH Range Time			
	13/41 (30 min) 9.9 9.3-10.0 11:00			
	14/47 (60 min) 9.9 9.3-10.0 11:30			
	(2 hrs) 9.9 9.3-10.0 12:30	INCREASED	N-Z	
	(3 hrs) 7.85 9.3-10.0 1:30	0.94		
	17.50 (Final) 8.5 7.5-8.5 2:15			
	NOTE: If pH not as specified notify Supervisor & note in log. If final pH is above (8.5) Adj to pH 7.5-8.5			
	M %		27-D	
V-302	28 Add 31" (379 G) water to V-302			
6	29 Add & stir 5 min Assume 50%	124	7-D	62
SV	30 SP Step 17/50 after checking pH. Operator PB			
SP	31 SP Step 23/53 Record: pH <u>3.5</u> (3.3-3.7)			
&	32 If necessary adj pH (DOWN ONLY) Record: pH		15-A	
CP	NOTE: Dissolve extra N-15-A in water at 110-120°F in drum Use ±30 Gal of water to 50% N-15-A. Stir SV 5 min after each addition			
7	33 Sift in	20 150	128-A	150
	34 Run in N-7-D from S 29 & stir 5 min			350
	35 Record: pH <u>4.4</u> (4.2-4.4)			
	36 If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts H ₂ O to 1 part N-7-D) or N-27			
	M %		27-D	
	Assume 50%		7-D	
	Siphon (if N-7-D) into SV. Record: pH			
	37 Operator Step PB			
	38 SP Step 24/54 - Add N-978-A & stir 15 min	20	978-A	20
	39 Operator Step PB			
	40 SP Step 60 - Batch Complete			
	START FIN OPTR			
	TIME SP STEP TIME SP STEP			
	11:00 PM 7:00 AM 104.145			
	7:00 AM 3:00 PM 235-4			
	3:00 PM 11:00 PM 438-406			
	4:30 AM 1:00 AM 144-27			
	7:00 AM 3:00 PM 235			

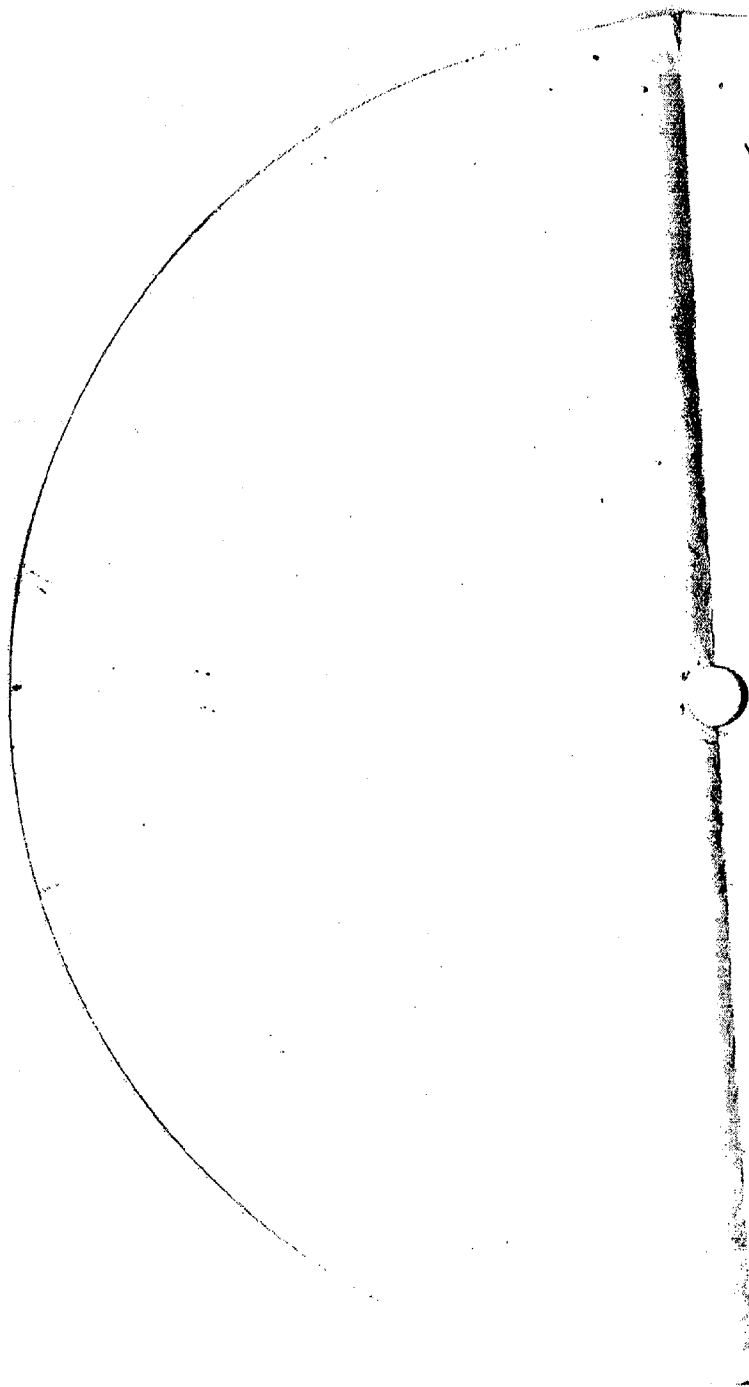


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V-243