S.V. 243 (244) Automated C.V. FEB 26 1985 D.V.

CG 03 CODE KY-781-D PKG.

→ FEB 22 34495

EST. WGT. 1328 ~~1128~~ LBS.

STD. HRS. TIME 3 PM

OK FP

PROCESSES	APPROVED BY
( ) KY-781-D (N)	FWP 101378
( ) ( )	AMJ 101378
( ) ( )	
( ) ( )	
TYPED BY emw101378	

14 YC-3-B 93 4 _____ _____ #

14 YC-3-B 93 4 23865 2,000 #

14 YC-3-B 93 4 23864 1100 #

Total Wgt. 4428# (Req _____)

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® YELLOW LIGHT	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	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
	3	Dump in & stir 5 min with Agitator on high speed. Lot 62	68 x 50	YC-3-B	~~3300~~ 3100
		Record: Start 3:45 PM			
		Fin 4:20 PM 23865			
		25" (1275) 2400-2600 23864			
	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 54" & adj to 45" (1662 G)			
	8	Inspect Homog strainer & clean if necessary			
		During homog, run V-203 Agitator on low speed.			
205 & SV 2	9	Run 12" (200 G) water into SV & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into V- 243			
		Record: Time Start 6 PM Total Min 125			
		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 #1 (V-243) or #6 (V-244)			
	~~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) 110.36 % - 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 SP & CP 4	~~16~~	Operator Step PB			
	~~17~~	Record Level 2LG 78 %. If below 35% follow solution make-up procedure for N-27-D			
	~~18~~	Adj SV to 54" (2800 G)			
	~~19~~	Record: pH 11.0			
	~~20~~	Adj pH to 11.4-11.6 using Assume 50%	10	7-D	5
		(Dilute to 5% (10 parts water to 1 part N-7-D)			
		Siphon into SV. Record: pH 11.4			
	~~21~~	Operator Step PB			

NW

(13629.REV.

243

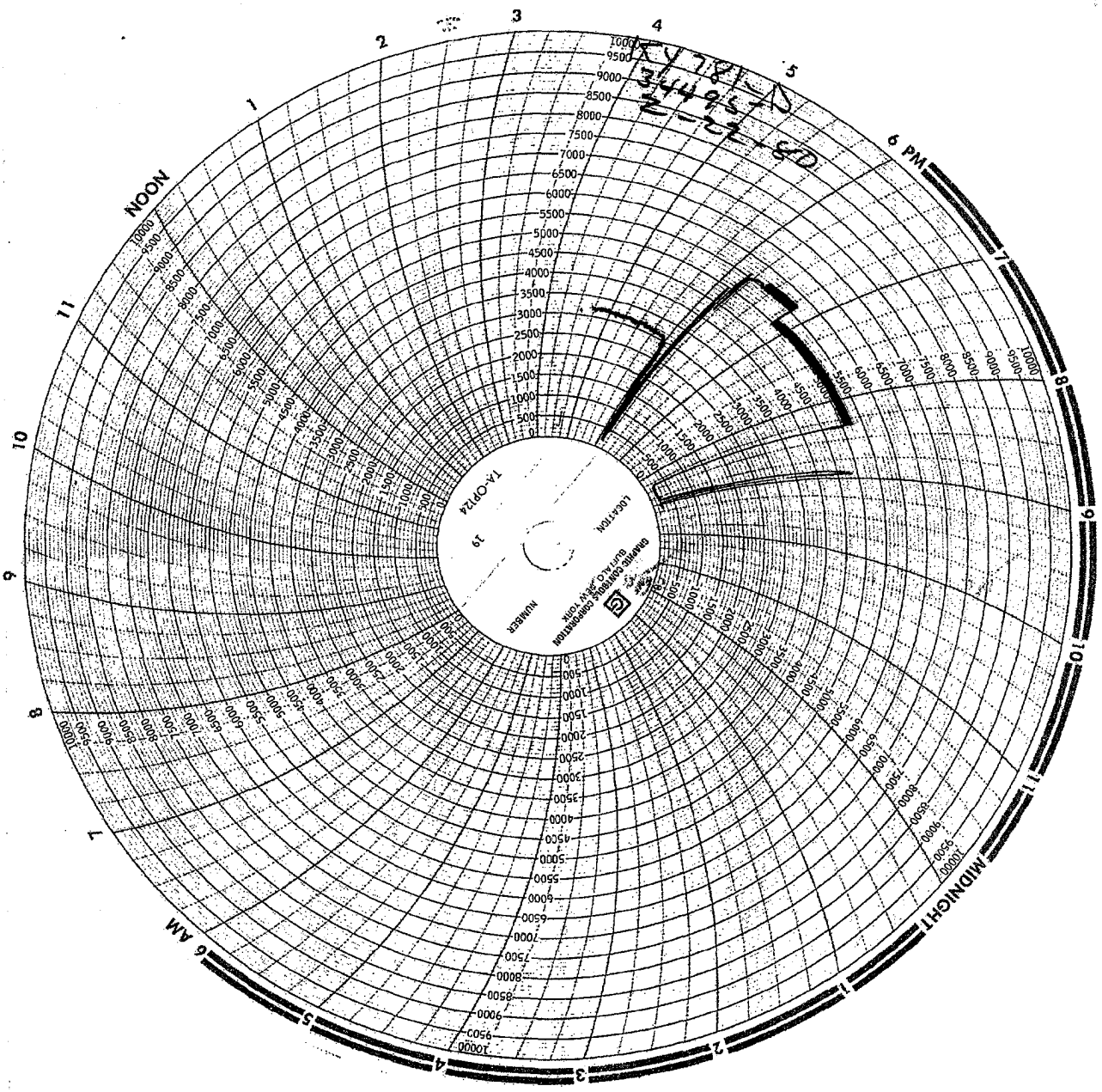
PAGE 2 CG 03 CODE KY-781-D N EST. WGT. 1128 LBS.

EQUIPMENT			USE LBS.	N CODE	ACCT LBS.
SV	22	SP Step 06/39. After heat up Record: pH 10.1 (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 10:40			
		13/41 (30 min) 9.9 9.3-10.0 11:10			
		14/47 (60 min) 9.9 9.3-10.0 11:40			
		(2 hrs) 9.9 9.3-10.0 12:40			
		(3 hrs) 9.9 9.3-10.0 1:40			
		17.50 (Final) 8.4 7.5- 8.5 2:25			
		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 3.5 (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			
7		Use ±30 Gal of water to 50# N-15-A. Stir SV 5 min after each addition			
	33	Sift In	350 150	128-A	150 350
	34	Run in N-7-D from S 29 & stir 5 min			
	35	Record: pH 4.4 (4.2-4.4)			
	36	If necessary adj pH to (4.2-4.4) with dilute N-7-D (10 parts H_2O 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			
		Batch # V-244 & V-246	2000	721-D	2000

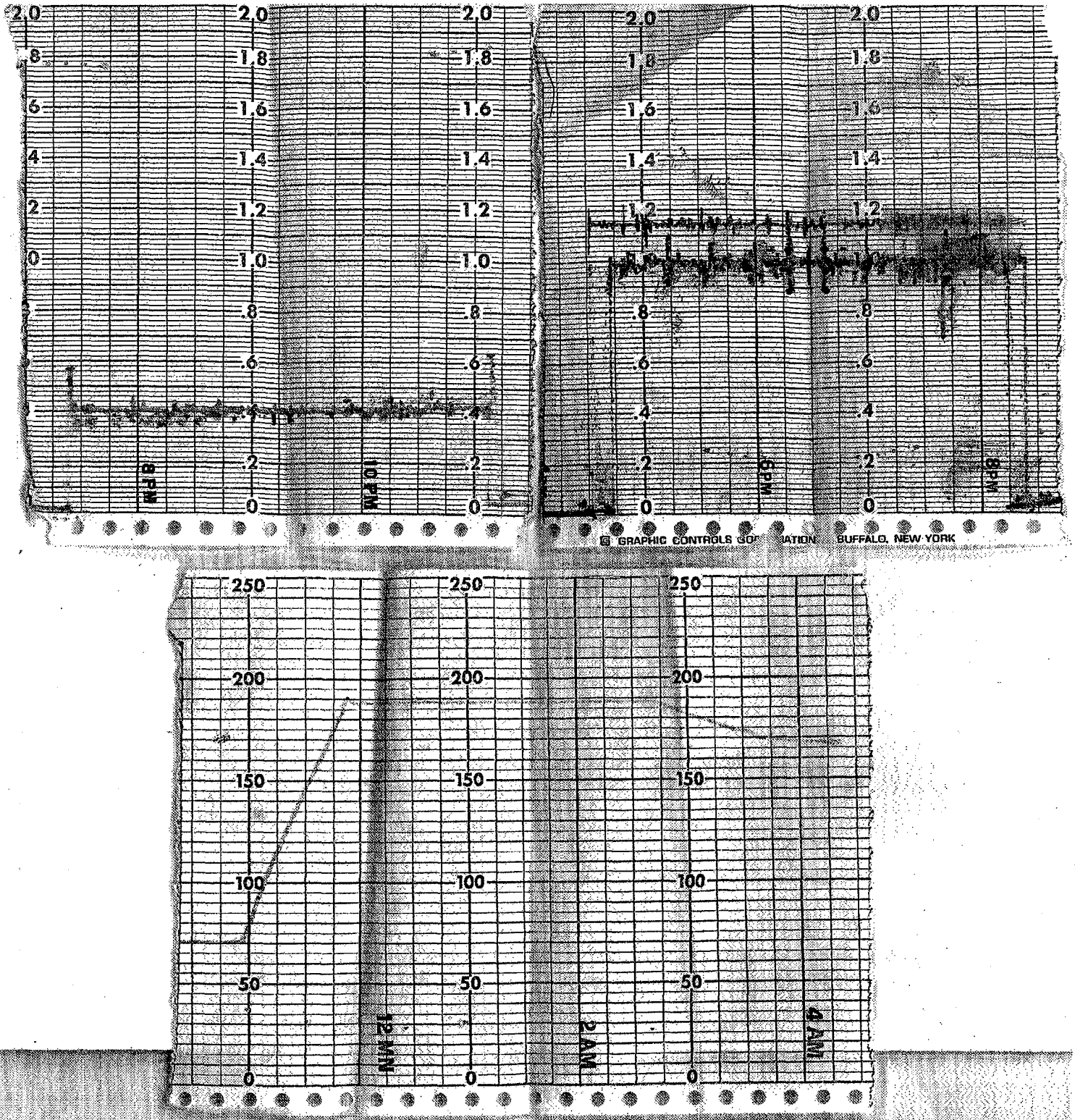
START 4:15 FIN 11 PM OPTR 282

TIME Final SP STEP TIME 3:30 ff SP STEP 120-27

DUP050094817



DUP050094818



DUP050094819