

243 (Automated)

C.V.

D.V.

CP 03 CODE KY-787-D PKG.

JAN 16 33721

EST. WGT. 1096 990 LBS.

STD. HRS. 8.9 TIME 11 P M

14 - YC-2-B 98 4 Lot 23966, 150 #
 Lot 24080, 250 #
 Lot 24171, 2000 #

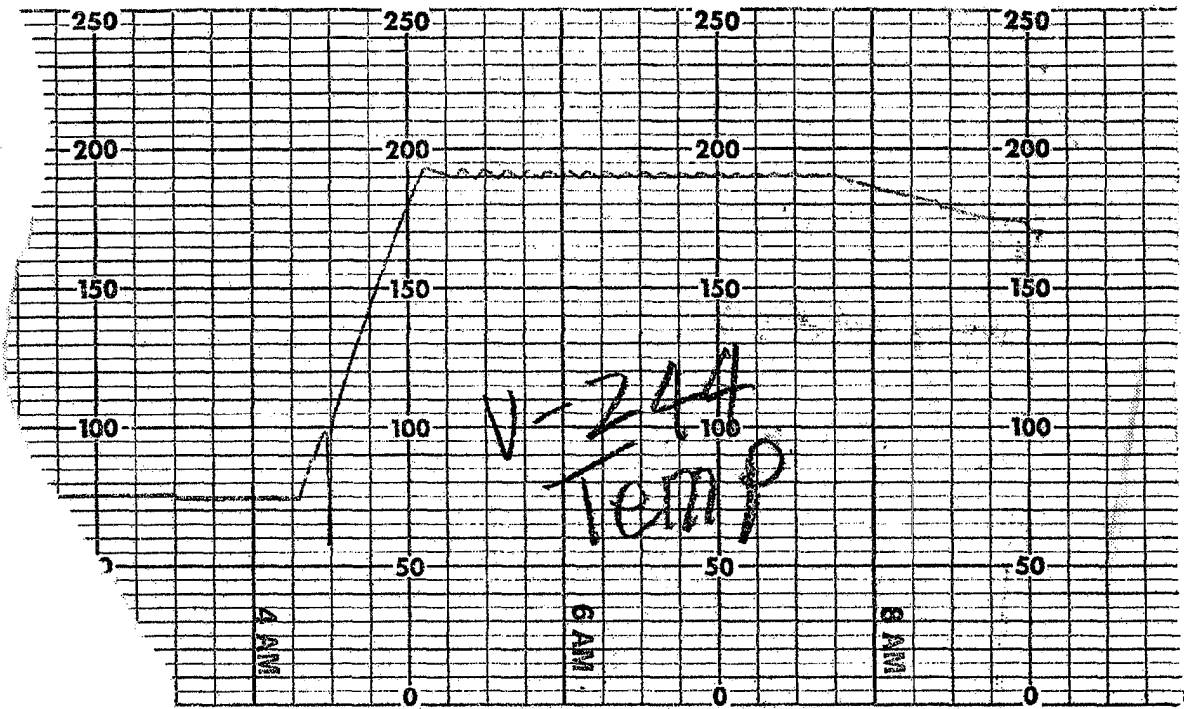
PROCESSES	APPROVED BY
() KY-787-D ()	FWK 9/22/76
() ()	DCG 9/27/76
() ()	MTW 9/30/76
() ()	
TYPED BY	
N.E. 2/12/77	

Total Wgt. -- 3490# 3590

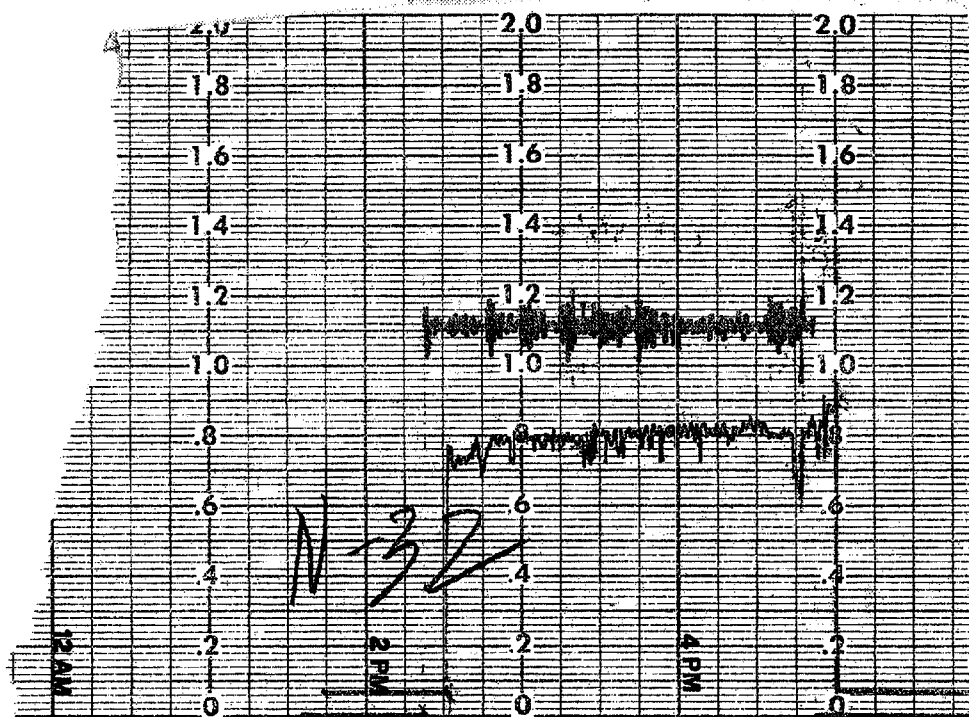
NON-BLEEDING

MENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
03	"KROLOR" - YELLOW MEDIUM			
&	1 Run 60" (992 G) water into V-203 AND ADD	30	7-D	15
05	2 Weigh in drum & pour in	320	32-D	320
1	3 Pump in and stir 5 min	48 x 50	YC-2-B	2400
	Record: Start 5:30 AM	23966		
	Fin 7:00 AM	24080		
		24171		
	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			
	7 Record V-205 Vol 54 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 Run 10" (514G) water into SV & start agitator			
	10 Pump V-205 thru Homog at 4800-5200 psi into V-244			
	Record: Time start 3:30 PM Total Min 150			
	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)			
&	13 Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
CP	14 Record levels and set Raw Materials Counter #1 as follows:			
3	a. 11LG 56% - preset #1 80 Gal		15-A	160
	b. 13LG 43% - 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 66%. If below 35% follow solution make-up procedure for N-27-D			
&	18 Adj to 48" (2470 G)			
CP	19 Record pH 10.4			
4	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)	70	7-D	15
	Siphon into SV. Record pH 11.2			
	21 Operator Step PB			

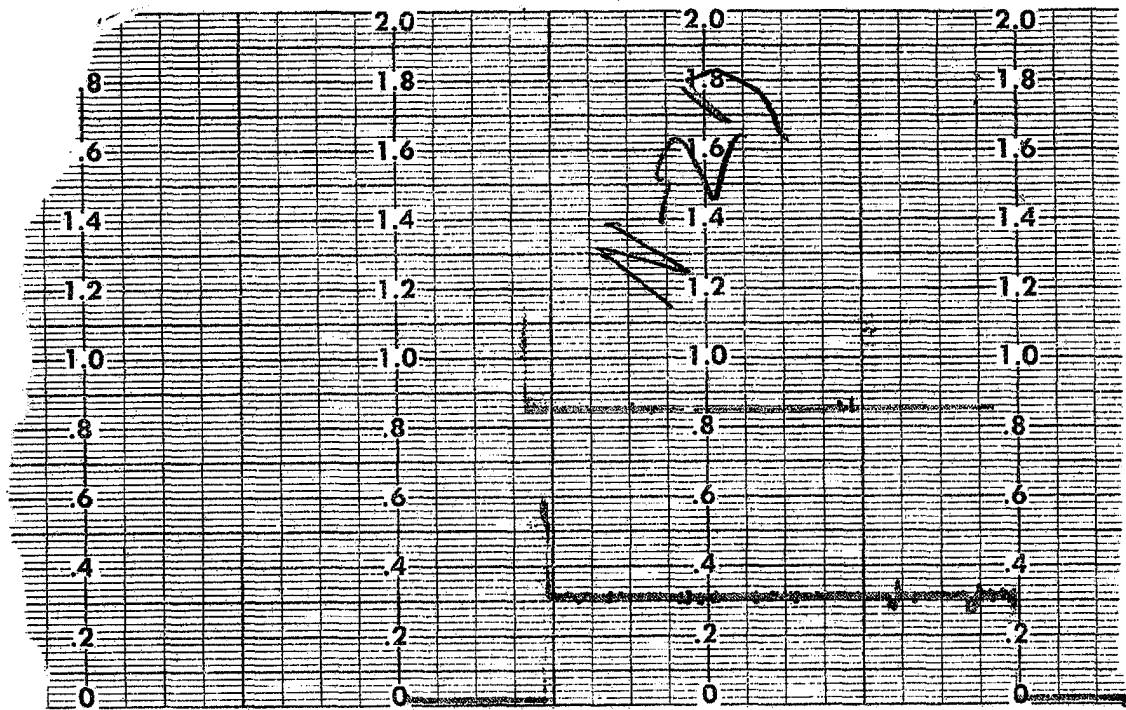
NT	USE	N	ACC
PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490
LBS.	USE	N	ACC
LBS.	LBS.	CODE	LBS.
21	SP Step 06/30 - After heat up Record: pH	10.0 (9.5-10.0)	
22	Switch 3FC20, 8FC10, 8FC20 to Auto		
23	Operator Step PB		
24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits		
25	Switch 3FC10 to Auto.		
26	Operator Step PB		
27	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20		
28	to Remote.		
29	Operator Step PB		
30	During strike, record pH & time as follows:	9:00 PM	
31	SP STEP		
32	V-243/V-244	pH	Range
33	13/46 (30 min)	9.8	9.0-10.0
34	14/47 (60 min)	9.8	9.0-10.0
35	15/48 (2 hrs)	9.8	9.0-10.0
36	16/49 (2 hrs 25 min)	9.8	9.0-10.0
37	17/50 (2 hrs Final)	7.9	7.5-8.5
38	NOTE: If not as specified notify Supervisor & note in log		
39	If final pH is above 8.5, add pH to 7.5-8.5 &		
40	Record: pH	Assume 77%	27-D
41	While striking, run 30" (234 G) water into V-339		
42	Add in 7-8 min		
43	Add to 49" (382 G) at 80 - 100°F		
44	Stir 5 min & record pH	10.2 (9.5-10.5)	
45	Stir 15 min or longer to dissolve for SP Step 26		
46	Record Vol	49" & calculate	
47	Set preset #8 to 38.2 G from S 34		
48	Add 30" (360 G) water to V-302		
49	Add & stir 2 min For S 41	Assume 50%	
50	SP Step 17/50 - After checking pH, Operator Step PB		
51	SP Step 23/53 - Record: pH	3.5 (3.7-4.2)	
52	Run in N-7-D from S 37 in 10-12 min & stir 5 min		
53	Record: pH	7.5 (9.0-9.5) & if necessary add pH 9.0-9.5	
54	& Record: pH	Assume 77%	27-D
55	(Dilute 10 parts water to 1 part N-7-D)	Assume 50%	7-D
56	Siphon N-7-D into SV		
57	Operator Step PB		
58	SP Step 29/58 Record: pH	9.4 (9.0-10.0) Time	12:50 AM
59	Operator Step PB		
60	SP Step 60 - Batch complete		
61	Start	Finish	Optr
62	Time	SP Step	Time
63	11:00 PM		11:00 PM
64	11:00 PM		12:54 AM
65			37-237
66			323-135



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



GRAPHIC CONTROLS C



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