CG 03 CODE KY-788-D PKG. _____

MAR 15 34888

EST. WGT. ~~960~~ 860 LBS.

STD. HRS. 8.8 TIME 7A M

14 YC-3-B 98 4 Lot 24406, 2600

14 YC-3-B 98 4 Lot _____,

14 YC-3-B 98 4 Lot _____

PUNCHED & CHECKED

OK / FP

PROCESSES		APPROVED B
(✓) KY-788-D	(J)	EWK 9/28/76
(✓)	(✓)	MTW 9/30/76
(✓)	(✓)	DCG 9/30/76
(✓)	(✓)	
TYPED BY		
NE 2-18-77		

Homog #4 - 1st Pass
" #4 - 2nd "

Total Wgt. ~~3560~~# 3460 MAR 19 1980 MAR 14 1980

NON-BLEEDING

EQUIPMENT		NAME: 60" (9906) "KROLOR" YELLOW - LIGHT	USE LBS.	N CODE	ACC LBS
203 & 205 1	1	Run ~~23" (360 G)~~ water into V-203. SET AGITATOR ON HIGH SPEED.			
	2	Weigh in drum & pour in	345	32-D	345
	3	Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
		Record: Start 4:30A.M. 24406	2600		
		Fin 5:30A.M.			
		75" (1275G)			
	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 washcolor thru Homog at 1800-2200 psi using minimun water			
	7	Record: V-205 Vol 44 "& adj to 60" (2100 G)			
	8	Inspect homog. strainer & clean if necessary			
		DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205 & SV 2	9	Run 10" (514 G) water into V- 244 & startagitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into V-			
		Record: Time Start 8:00AM Total min 135			
		Note: If Homog pressure falls below 4800 ps., 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 #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)			
	14	Record levels and set Raw Material Counter #1 as follows			
		a. 11LG 60 % - preset #2 208 Gal		15-A	416
		b. 13LG 47 % - preset #6 135 Gal		20-A	135
	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. 3FR10 (N-27-D/Water) Ratio 0.8			
		d. 8FC10 (N-32-D Controller) in Manual ~~0.72~~ GPM 0.90		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			
320 243 SP & CP 4	16	Operator Step PB			
	17	Record Level 2LG 56 %. If below 35% follow solution make-up procedure for N-27-D			
	18	Adj SV to 47" (2400 G)			
	19	Record pH 10.4. Adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
		Siphon into SV & Record: pH 11.2			
	20	Operator Step PB			

REV.

V-244

UIPMENT		PAGE 2 CG 03 CODE KY-788-D EST. WGT. 3560 LBS.	USE LBS.	N CODE	ACCT LBS
SV	21	SP Step 06/39 - After heat up Record: pH 9.9 (9.5-10.0)			
SP	22	Switch 3FC20, 8FC10, 8FC20 to Auto			
	23	Operator Step PB			
	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows is limits.			
5		Swich 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:	11:50 AM		
		SP Step			
		V-243/V-244 pH Range Time			
		13/45 (30 min) 9.7 9.3-10.0 12:20			
		14/47 (60 min) 9.65 9.3-10.0 12:50			
		15/48 (2 hrs) 9.65 9.3-10.0 1:50			
		16/49 (2 hrs 25 min) 9.65 9.3-10.0 2:15			
		17/50 (Final 3 hrs) 7.5 7.5-8.5 2:50			
		Note: If not as specified notify Supervisor & Note in log			
		If final pH is above 8.5, adj 7.5-8.5			
		& Record: pH _____ Assume 77%		27-D	
339	28	While striking run 30" (234 G) water into V-339			
6	29	Add in 7-8 min	350	530-A	350
	30	Adj to 49" (382 G) at 80-100 °F			
	31	Stir 5 min & record pH 10.1 (9.5-10.5)			
	32	Stir 15 min or longer to dissolve for SP Step 26/56			
	33	Record Vol 49 " & Calculate 49 " (Vol X 0.78= 38.2 G)			
	34	Set preset #8 to 38.2 from S 33			
302	35	Run 40" (440 G) water into V-302			
7	36	Add & stir 2 min for S 40 Assume 50%	360	7-D	180
SV	37	SP Step 17/50 After checking pH. Operator Step PB			
SP	38	Sift in 2 bags	~~100~~	~~128-A~~	~~100~~
	39	SP Step 23/53 Record: pH 3.2 (3.7-4.2			
8	40	Run in N-7-D from S 36 in 10-12 min & stir 5 min			
	41	Record: pH 9.4 (9.0-9.5) & if necessary adj to pH 9.0-9.5			
		& Record: pH Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV			
	42	Operator Step PB			
	43	SP Step 29 - Record: pH 9.0 (9.0-10.0) Time			
	44	Operator Step PB			
	45	SP Step 60 - Batch complete			

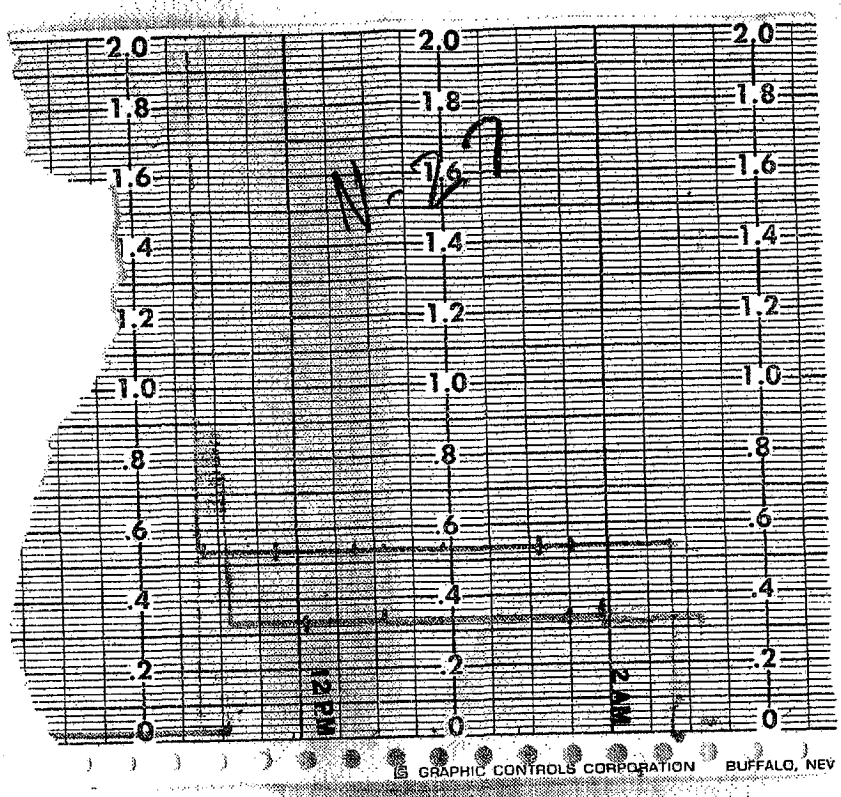
Start Time	Start SP Step	Finish Time	Finish SP Step	Optr
7:00A		3:00PM		235
3-P		4P		120

Note Step:-27 → METERING N-32 Setting

START 11:50 AM	P.H.	9.9	0.90
12:05PM		9.7	
12:20		9.7	
12:35		9.65	Adj to 0.92
12:50		9.65	
1:50		9.65	
2:15		9.65	
2:50		7.5	

DUP050094484

2.0
1.8
1.6
1.4
1.2
1.0
.8
.6
.4
.2
0
2 AM
12 PM
GRAPHIC CONTROLS CORPORATION
BUFFALO, NY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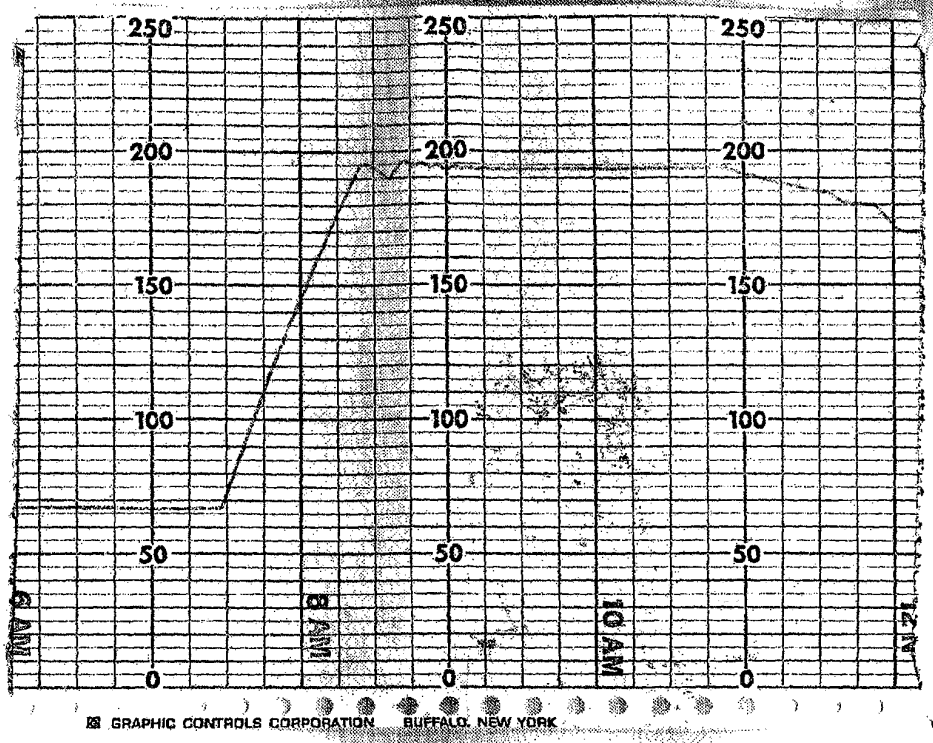
GRAPHIC CONTROLS CORPORATION
BUFFALO, NEW



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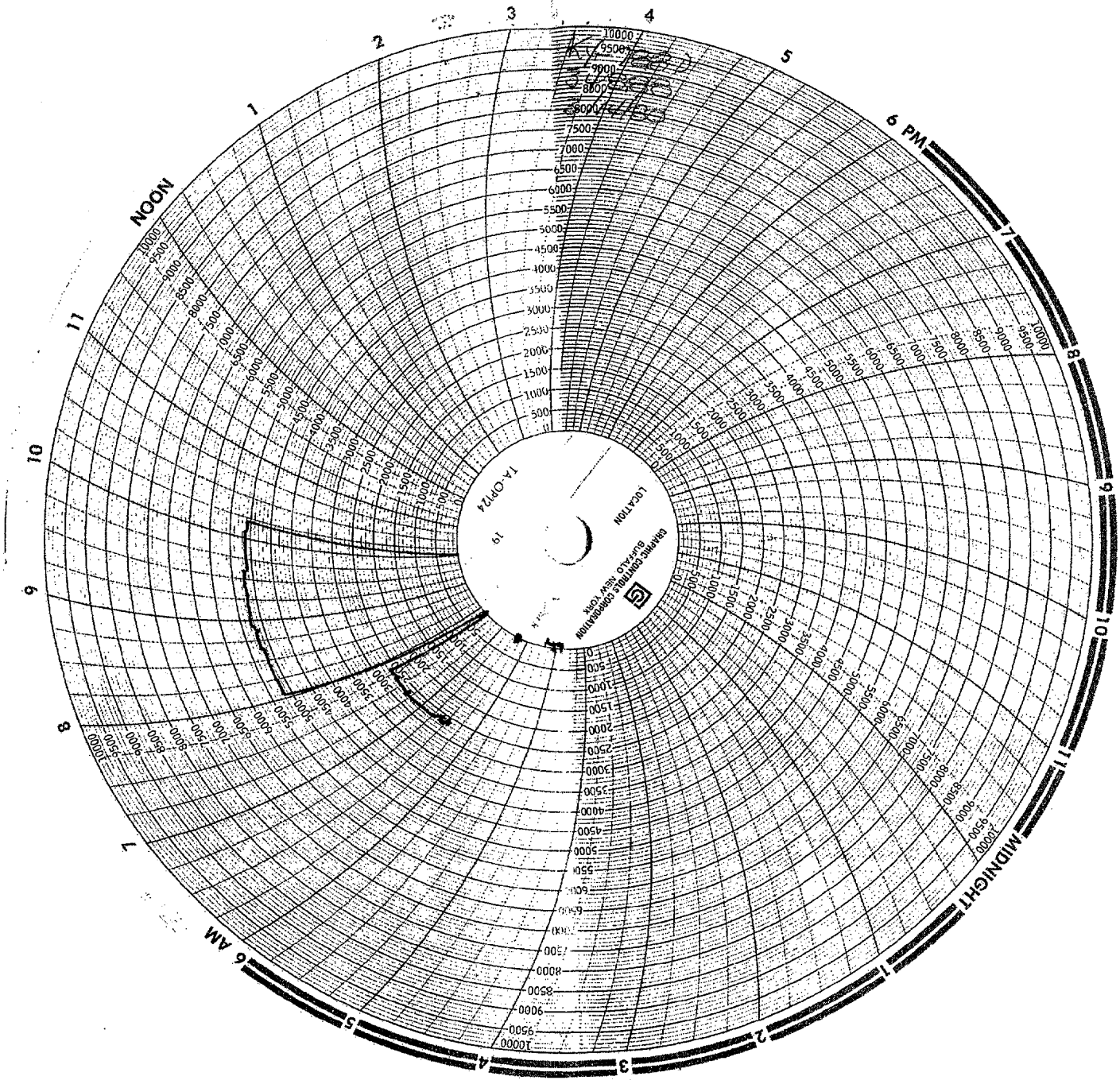

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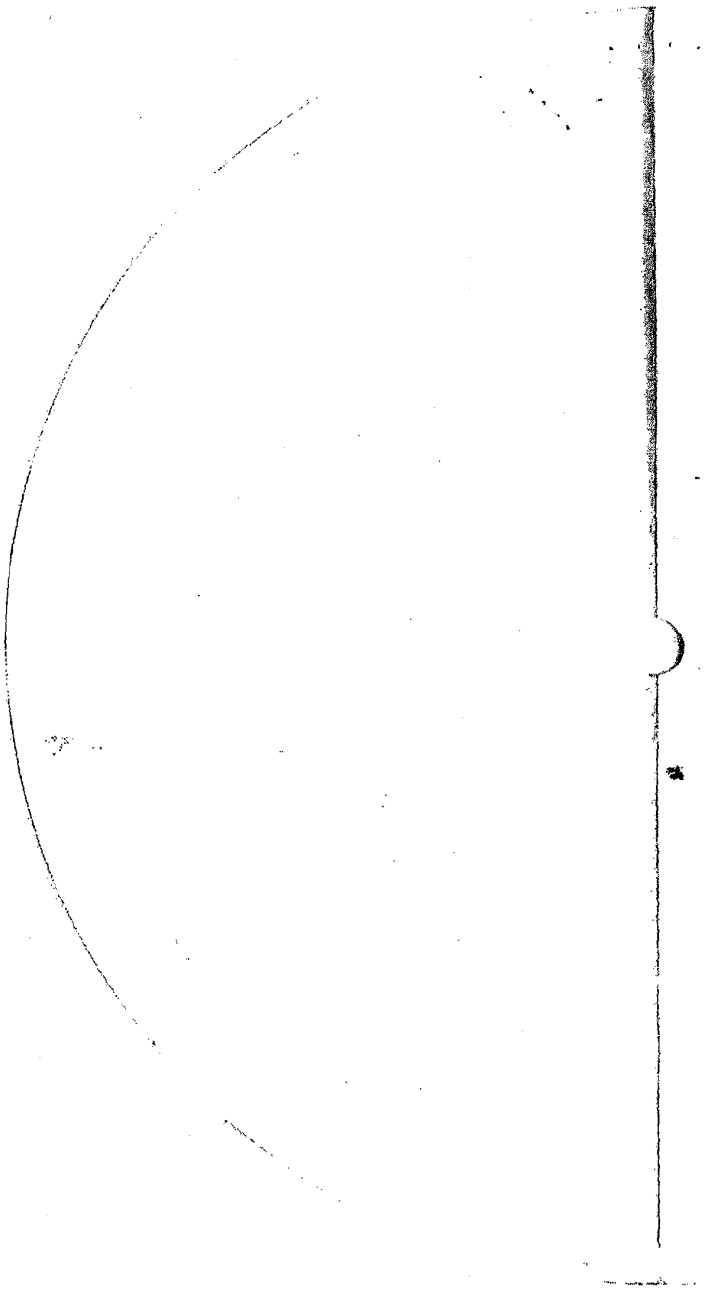

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