

D V

C Y

→	BALE 3	35.17
EST WGT	1090	LBS

STD HRS 8.9 TIME

14 YC-2-B 93 4 LOT 24475, 21200 #
LOT 24474, 200 #
LOT _____, _____ #

~~PUNCHED~~ ° ~~CHECKED~~

APR 1 1983

Homoo #3-1st Pass
" #3-2nd "

PROCESSES

APPROVED BY

() KY-787-D @) EWK 9-22-76

() DCG 9-27-76

() MTW 9-30-76

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RE TYPED BY

CJH 2-8-80

NON-BLEEDING

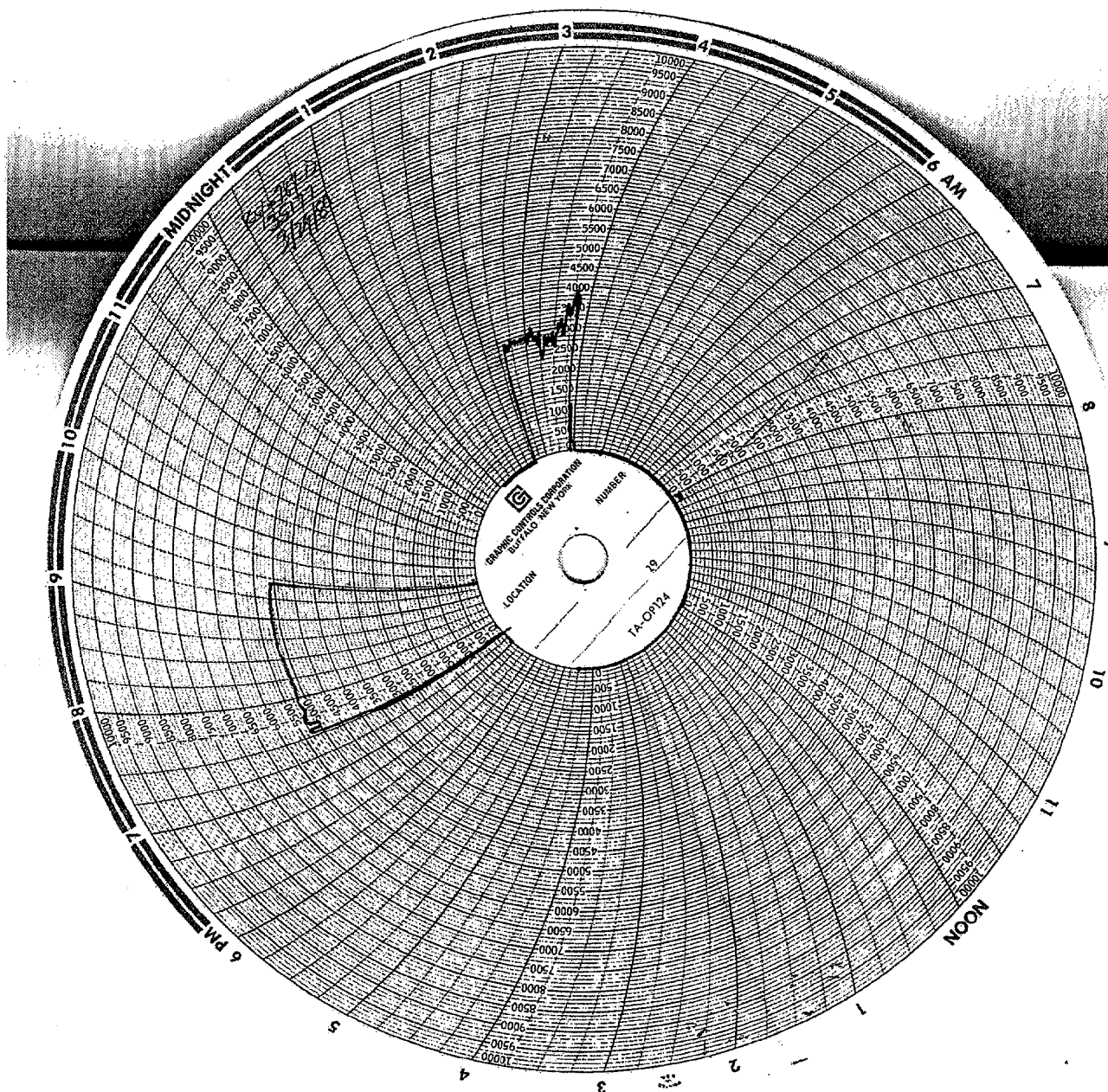
ITEM	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203 & 205	1 RUN 60" (992 G) WATER INTO V-203 SET AGITATOR ON HIGH SPEED			
1	2 WEIGH IN DRUM & POUR IN	320	32-D	320
	3 DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
	RECORD: START 1:20 PM	24475		
	FIN 1:10 PM	24474		
	25" (1275 G)			
	4 ADJ TO 70" (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 45 " & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
	9 RUNNING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
205 & SV	10 RUN 10" (514 G) WATER INTO SV. START AGITATOR			
2	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO V- 244			
	RECORD: TIME START 7:30 PM TOTAL MIN 120			
	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 #2 (V-243) OR #7 (V-244)			
3	13 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE (TEMPERATURE IS SET AT 190-194F)			
	14 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 50% - PRESET #1 80 GAL		15-A	160
	B. 13LG 12% - 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	275
	B. 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	C. 3ER10 (N-27-D/WATER RATIO) 0.64			
	D. 8FC10 (N-32-D CONTROLLER) IN MANUAL 1.08 GPM		32-D	1840
	E. 8EC20 (N-32-D WATER) IN MANUAL LOCAL 4.47 GPM			
	F. 8FC20 (N-32-D WATER) IN REMOTE			
	G. 8ER10 (N-32-D/WATER RATIO) 0.83			
SV	16 OPERATOR STEP PB			
SP & CP	17 RECORD LEVEL 2 LG 42% IF BELOW 35% FOLLOW SOLUTION MAKE-UP PROCEDURE FOR N-27-D			
4	18 ADJ TO 48" (2470 G)			
	19 RECORD: pH 10.6			
	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)	20	7-D	10
	SIPHON INTO SV. RECORD pH 11.1			
	21 OPERATOR STEP PB			

4 REV.

N32154

V-244

EQUIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV SP & CP 5	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH 10.1 (9.5-10.0)						
	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO						
	24	OPERATOR STEP PB						
	25	SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS						
	26	SWITCH 3FC10 TO AUTO OPERATOR STEP PB						
	27	SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH						
	28	3FC20 TO REMOTE						
	29	OPERATOR STEP PB						
	30	DURING STRIKE, RECORD pH & TIME AS FOLLOWS:						
	31	SP STEP						
	32	V-243/V-244						
	33	13/46 (30 MIN) 9.8 9.0-10.0 11:45						
	34	14/47 (60 MIN) 9.8 9.0-10.0 12:15						
	35	15/48 (2 HRS) 9.8 9.0-10.0 1:15						
	36	16/49 (2 HRS 25 MIN) 9.8 9.0-10.0 1:40						
	37	17/50 (3 HRS FINAL) 7.4 7.5-8.5 2:15						
	38	NOTE: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG						
	39	IF FINAL pH IS ABOVE 8.5, ADJ pH TO 7.5-8.5 &						
	40	RECORD: pH ASSUME 77% 27-D						
339 6	29	WHILE STRIKING, RUN 30" (234 G) WATER INTO V-339						
	30	ADD IN 7-8 MIN						
	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						
302 7	34	RECORD VOL 49" & CALCULATE 49" (VOL) X 0.78 = 38.26						
	35	SET PRESET #8 TO 38.26 FROM S 34						
	36	ADD 30" (360 G) WATER TO V-302						
	37	ADD & STIR 2 MIN FOR S 41						
	38	ASSUME 50% 160 7-D 80						
243 SP & CP 8	38	SP STEP 17/50 - AFTER CHECKING pH, OPERATOR STEP PB						
	39	SHIFT IN 2 BAGS						
	40	SP STEP 23/53 - RECORD pH 4.2 (3.7-4.2)						
	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN						
	42	RECORD: pH 9.3 (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5						
	43	& RECORD: pH ASSUME 77% 27-D						
	44	(DILUTE 10 PARTS WATER TO 1 PART N-7-D) ASSUME 50% 7-D						
	45	SIPHON N-7 INTO SV						
	46	OPERATOR STEP PB						
	47	SP STEP 29/58 RECORD: pH 9.0 (9.0-10.0) TIME 4:00 AM						
	48	OPERATOR STEP PB						
	49	SP STEP 60 - BATCH COMPLETE						
		START FINISH						
		TIME SP-STEP TIME SP-STEP OPTR						
		3:00 PM 11:00 PM 235						
		11:00 PM 4:00 AM 409						



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DUP050456858

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