

243.244 (Automated)

C.V.

D.V.

CQ 03 CODE KY-787-D

PKG.

JAN 13

33792

EST. WGT.

1090

LBS.

STD. MRS.

8.9

TIME

3 P M

14 - YC-2-B 98 4

Lot 24072, 2200 #

Lot 24078, 200 #

Lot , #

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		

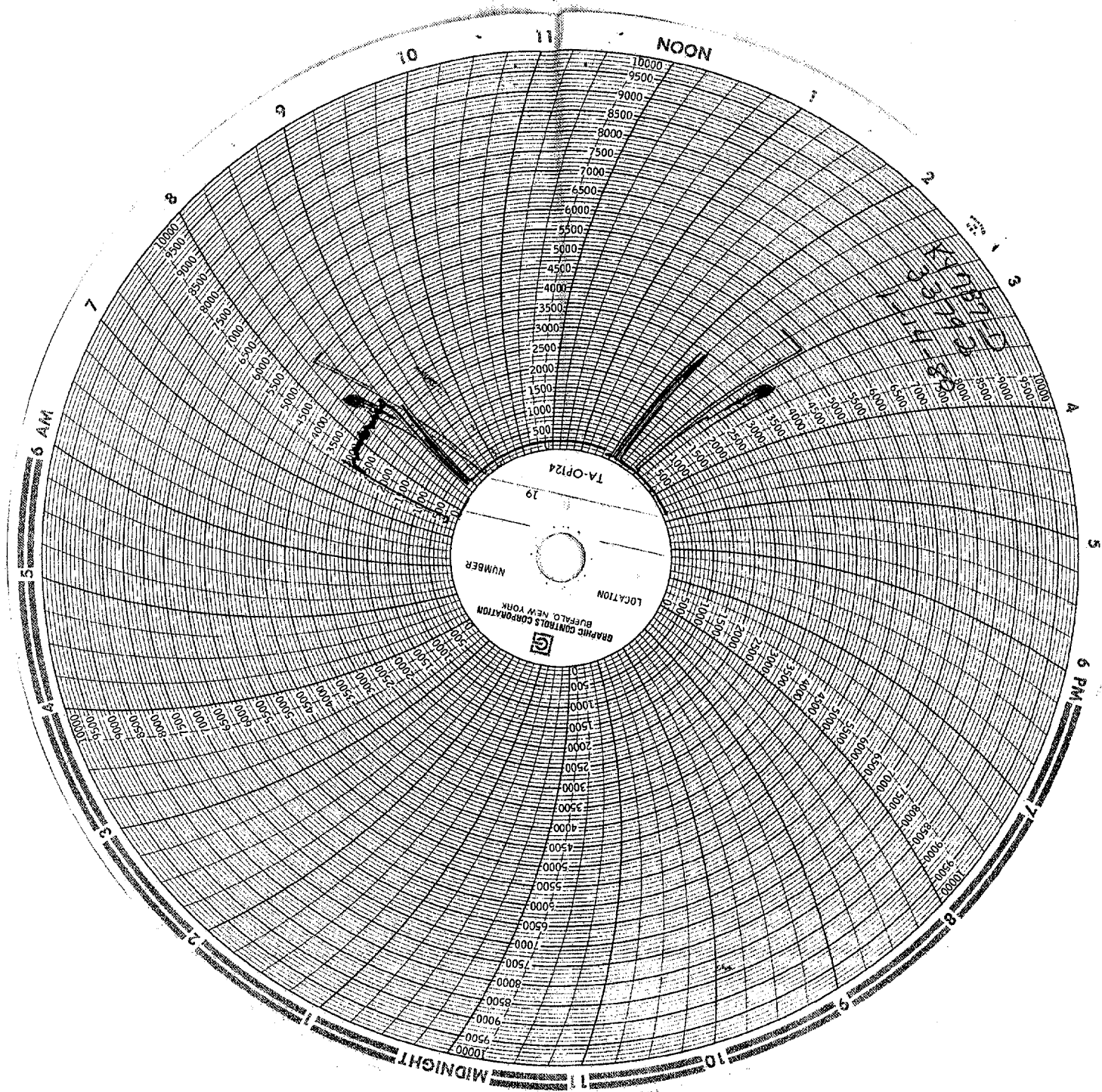
Total Wgt. - 3490#

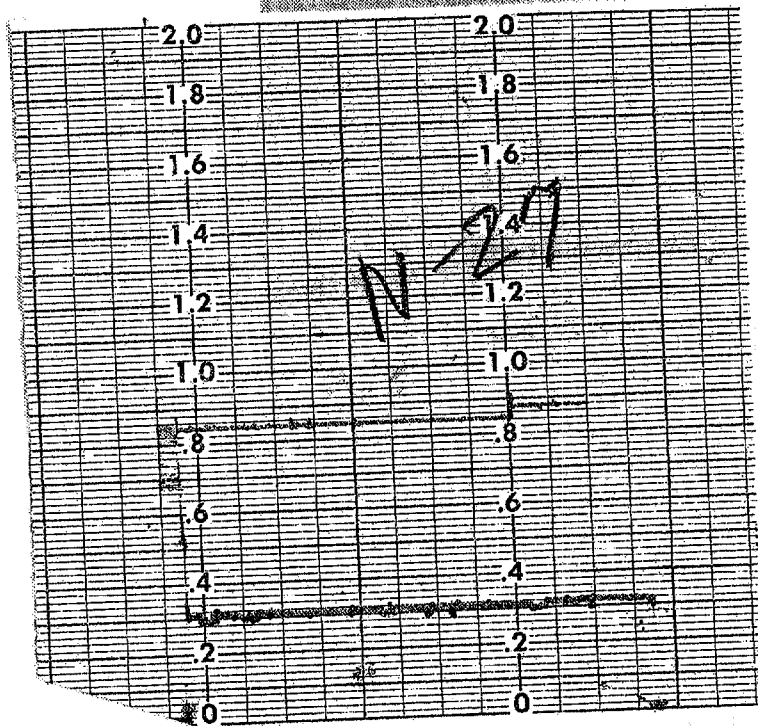
NON-BLEEDING

ITEMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	1 Run 6" "KROLOR" - YELLOW MEDIUM			
&	2 Weigh in drum & pour in	320	32-D	320
205	3 Pump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start 4:30 AM	24072	2200	
	Fin 5:45 AM	24078	200	
	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 100 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514G) water into SV & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time start 5:30 PM Total Min 150			
2	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 42 (V-243) or #7 (V-244)			
&	13 Press SV Cam Reset PB-set 22TC in Auto Remote			
CP	(Temperature is set at 190-194F)			
3	14 Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 68 % - preset #1	80 Gal	35-A	160
	b. 13LG 36 % - preset #2	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. 3FER10 (N-27-D/Water Ratio)	0.64		
	d. 3FC10 (N-32-D Controller) in Manual	1.08 GPM	32-D	1840
	e. 3FC20 (N-32-D Water) in Manual Local	4.47 GPM		
	f. 3FC20 (N-32-D Water) in Remote			
	g. 3FER10 (N-32-D/Water Ratio)	0.83		
SV	16 Operator Step PB			
SP	17 Record Level 2 LG 90 %. If below 35% follow solution make-up procedure for N-27-D			
&	18 Adj to 48" (2470 G)			
CP	19 Record pH: 11.1			
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)			
	Siphon into SV, Record pH 11.1			
	21 Operator Step PB			

V-243

PMENT	PAGE 2 CG 03	CpDE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	22	SP Step 06/39 - After heat up Record: pH <u>9.6</u> (9.5-10.0)					
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto					
&	24	Operator Step PB					
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits					
5		Switch 3FC10 to Auto. Operator Step PB					
	26	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote.					
	27	Operator Step PB					
	28	During strike, record pH & time as follows:					
		SP STEP					
		V-243/V-244	pH	Range	Time		
		13/46 (30 min)	<u>9.3</u>	9.0-10.0	<u>11:40</u>		
		14/47 (60 min)	<u>9.3</u>	9.0-10.0	<u>12:10</u>		
		15/48 (2 hrs)	<u>9.6</u>	9.0-10.0	<u>1:10</u>		
		16/49 (2 hrs 25 min)	<u>9.6</u>	9.0-10.0	<u>1:35</u>		
		17/50 (3 hrs Final)	<u>6.9</u>	7.5-8.5	<u>2:10</u>		
		NOTE: If not as specified notify Supervisor & note in log					
		If final pH is above 8.5, adj pH to 7.5-8.5 &					
		Record: pH		Assume 77%		27-D	
39	29	While striking, run 30" (234 G) water into V-339					
6	30	Add in 7-8 min			350	530-A	350
	31	Adj to 49" (382 G) at 80 - 100°F					
	32	Stir 5 min & record pH <u>10.1</u> (9.5-10.5)					
	33	Stir 15 min or longer to dissolve for SP Step 26					
	34	Record Vol <u>77</u> & calculate <u>49</u> (Vol) x 0.78 = <u>38.2 G</u>					
	35	Set preset #8 to <u>38.2 G</u> from S 34					
02	36	Add 30" (360 G) water to V-302					
7	37	Add & stir 2 min For S 41		Assume 50%	160	7-D	80
243	38	SP Step 17/50 - After checking pH, Operator Step PB					
	39	SIFT in 2 Bags			100	128-A	100
SP	40	SP Step 23/53 - Record: pH <u>3.3</u> (3.7-4.2)					
&	41	Run in N-7-D from S37 in 10-12 min & stir 5 min					
CP	42	Record: pH <u>7.2</u> (9.0-9.5) & if necessary adj pH 9.0-9.5					
8		& Record: pH <u>9.3</u> Assume 77%				27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%			2.6	7-D	1.3
		Siphon N-7-D into SV					
	43	Operator Step PB					
	44	SP Step 29/58 Record: pH <u>9.15</u> (9.0-10.0) Time <u>3:25 PM</u>					
	45	Operator Step PB					
	46	SP Step 60 - Batch complete					
		Start	Finish	Optr			
		Time	Time	SP Step			
		<u>7:00 AM</u>	<u>3:00 PM</u>		<u>409-86</u>		
		<u>3:00 PM</u>	<u>11:24 PM</u>		<u>144</u>		
		<u>11:00 P</u>	<u>3:30 A</u>		<u>235-242</u>		





GRAPHIC CONTROLS CORPORATION

