

243244 (Automated)

C.V.

D.V.

CG 03 CODE KY-787-D PKG.

JAN 12 33775

EST. WGT. 1090 LBS.

STD. HRS. 8.9 TIME 3P M

14 - YC-2-B 98 4 Lot 24171 400 #
Lot 24082 2000 #
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	

OIC
S.P.
Homog # 3 - 1st Pass
" 3 - 2nd Pass

Total Wgt. - 3490#

NON-BLEEDING

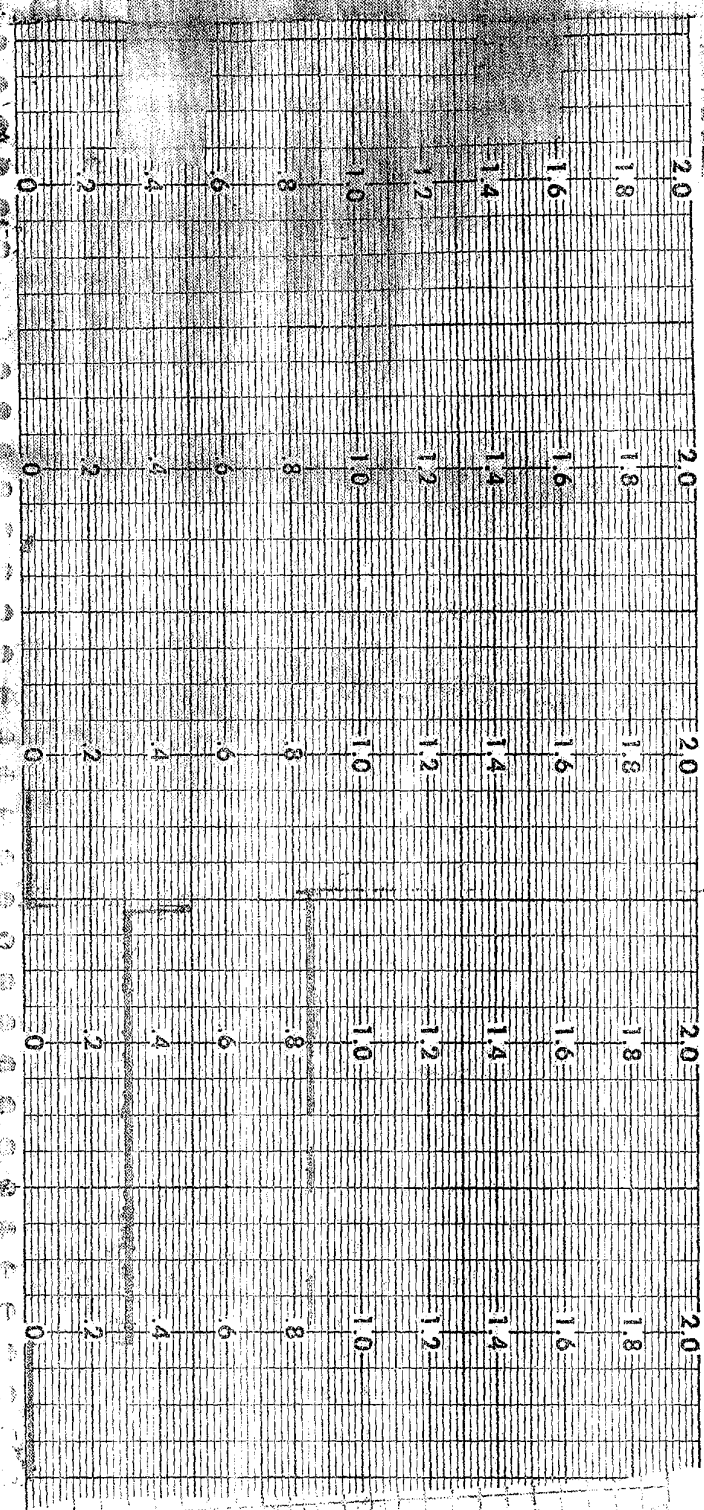
IPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	1 Run 10" (992 G) water into V-203			
8	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in and stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start 11:00 PM 24171 400			
263	Fin 12:30 AM 24082 2000			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 263			
	6 When V-203 MTY, wash color thru Homog at 1800-2000 psi using minimum water 263			
	7 Record V-205 Vol 45 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
205	9 Run 10" (514G) water into SV & start agitator			
263	10 Pump V-205 thru Homog at 4800-5200 psi into V-243			
SV	Record: Time start 11:00 AM Total Min 105			
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 #2 (V-243) or #7 (V-244)			
8	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 25 % - preset #1 80 Gal 35-A 160			
	b 13LG 52 % - 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 3FR10 (N-27-D/Water Ratio) 0.64			
	d 8FC10 (N-32-D Controller) in Manual 1.08 GPM 32-D 184			
	e 8FC20 (N-32-D Water) in Manual Local 4.47 GPM			
	f 8FC20 (N-32-D Water) in Remote 0.83			
	g 8FR10 (N-32-D/Water Ratio)			
SV	16 Operator Step PB			
SP	17 Record Level 2 LG 90 %. If below 35% follow solution make-up procedure for N-27-D			
8	18 Adj to 48" (2470 G)			
CP	19 Record pH 10.5			
4	20 Adj to 11.1 - 11.3 using N-7-D diluted 5% Assume 50% 30 70 15			
	(10 parts water to 1 part N-7-D)			
	Siphon into SV, Record pH 11.1			
	21 Operator Step PB			

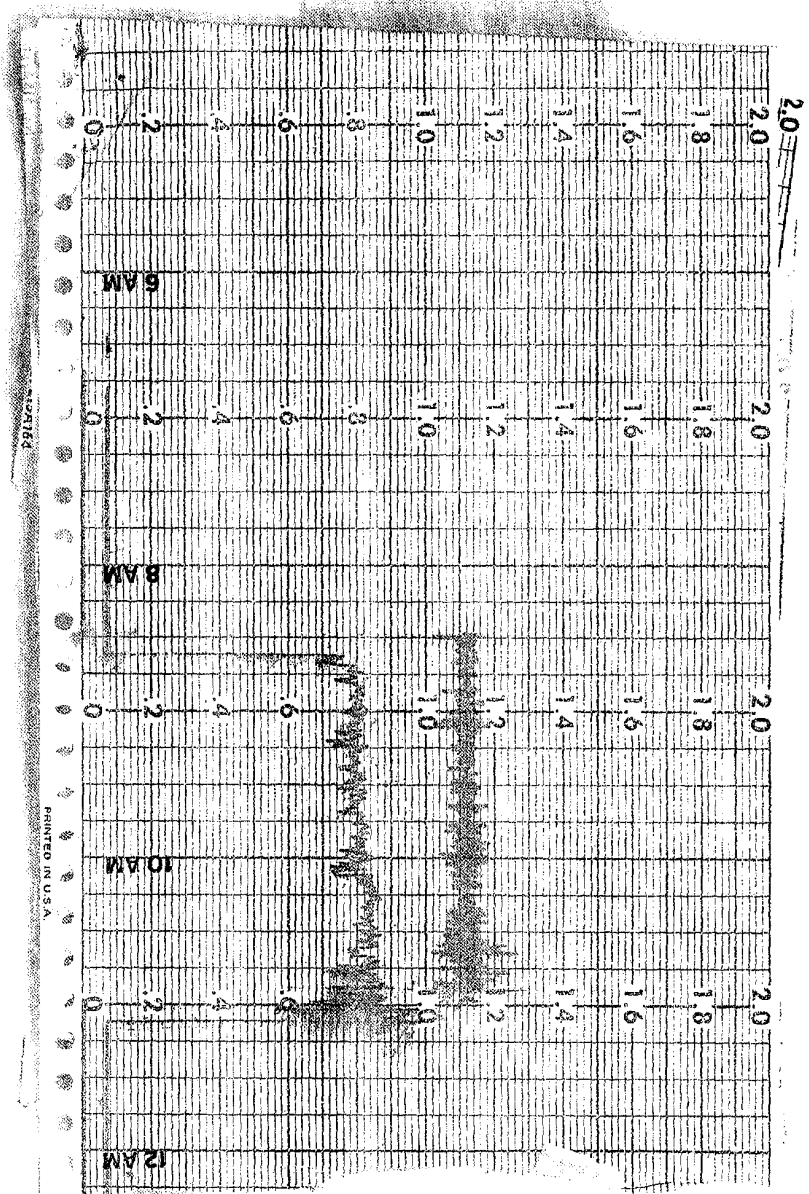
V-243

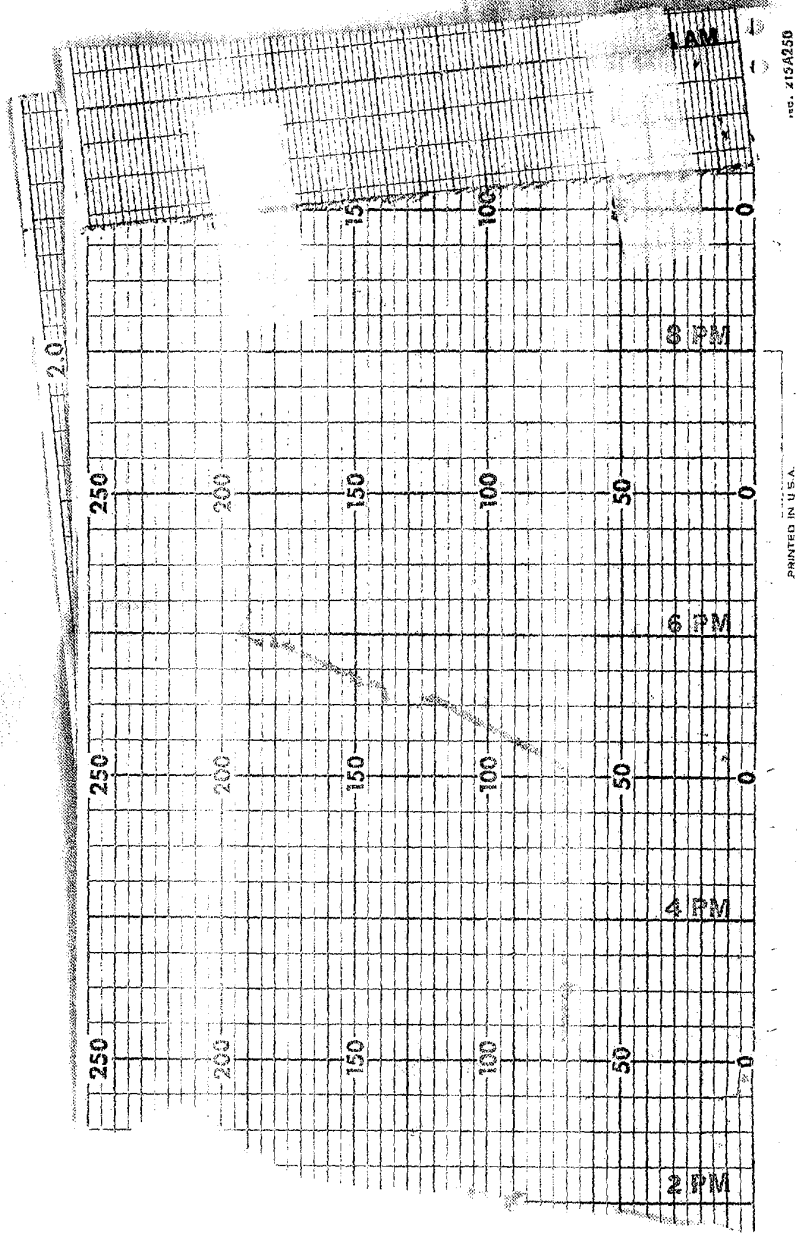
PMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT.	3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22	SP Step 06/39 - After heat up Record: pH <u>9.6</u> (9.5-10.0)							
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto							
&	24	Operator Step PB							
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits							
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>9.5</u>	9.0-10.0	<u>4:00</u>				
		14/47 (60 min)	<u>9.5</u>	9.0-10.0	<u>4:30</u>				
		15/48 (2 hrs)	<u>9.6</u>	9.0-10.0	<u>5:30</u>				
		16/49 (2 hrs 25 min)	<u>9.6</u>	9.0-10.0	<u>5:55</u>				
		17/50 (3 hrs Final)	<u>7.7</u>	7.5-8.5	<u>6:30 PM</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	
339	29	White 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>10.2</u> (9.5-10.5)							
	33	Stir 15 min or longer to dissolve for SP Step 26							
	34	Record Vol <u>49</u> & calculate <u>49</u> (Vol) x 0.78 = <u>38.22G</u>							
	35	Set preset #8 to <u>38.22G</u> from S 34							
302	36	Add 30" (360 G) water to V-302							
7	37	Add & stir 2 min For S 41				Assume 50%	<u>80</u>	721-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>3.0</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>7.0</u> (9.0-9.5) & if necessary adj pH 9.0-9.5							
8		& 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							
	43	Operator Step PB							
	44	SP Step 29/58 Record: pH <u>8.9</u> (9.0-10.0) Time <u>7:30 PM</u>							
	45	Operator Step PB							
	46	SP Step 50 - Batch complete							
		Start		Finish		Optr			
		Time	SP Step	Time	SP Step				
		<u>12:30 A</u>		<u>7:00 A</u>		<u>215-54</u>			
		<u>1:00 PM</u>		<u>3:00 PM</u>		<u>321-438</u>			
		<u>3:00 PM</u>		<u>7:45 PM</u>		<u>320-146</u>			

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