

241244 (Automated)

C.V.

D.V.

CG 03 CODE KY-787-D PKG.

JAN 11 33738

EST. WGT. 1090 L.J.

STD. HRS. 8.9 TIME

14 - YC-2-B 98 4 Lot 24069, 2000

Lot

Lot 24171, 400

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

Homog #3-1ST Pass

Total Wgt. - 3490#

NON-BLEEDING

MENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
03	"KROLOR" - YELLOW MEDIUM			
03 & 05	1. Run 60" (992 G) water into V-203 AND ADD	320	7-D	15
1	2. Weigh in drum & pour in	320	32-D	320
63	3. Pump in and stir 5 min	48 X 50	YC-2-B	2400
	Record: Start 9:20 P/M	24069		2000
	Fin 10:30 P/M	24171		400
	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	263		
	7. Record V-205 Vol 56 " & adj to 60" (2100 G)			
	8. Inspect Homog strainer & clean if necessary			
03	9. Run 10" (514G) water into SV & start agitator			
63	10. Pump V-205 thru Homog at 4800-5200 psi into V-	294		
SV	Record: Time start 9:15 AM Total Min 1:20			
2	NOTE: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
	12. 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)			
& CP	13. Press SV Cam Reset PB-set 22TC in Auto Remote (Temperature is set at 190-194F)			
3	14. Record levels and set Raw Materials Counter #1 as follows:			
	a. 11LG 31% - preset #1	80 Gal	15-A	160
	b. 13LG 31% - preset #6	135 Gal	20-A	135
	15. Set strike flow controllers as follows:			
	a. 2FC10 (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. 3FC10 (N-27-D/Water Ratio)	0.64		
	d. 2FC10 (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. 3FC10 (N-32-D/Water Ratio)	0.83		
SV	16. Operator Step PB			
SP	17. Record Level 2 LG 89 % If below 35% follow solution make-up procedure for N-27-D			
& CP	18. Adj to 48" (2470 G)			
4	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)	30	7-D	15
	Siphon into SV. Record pH 11.1			
	21. Operator Step PB			

U:244

NT	PAGE	CODE	EST. WGT.	LBS.	USE	N	ACC
	2	CG-03	KY-787-D	3490	LBS.	CODE	LBS.
22	SP Step 06/39	After heat up Record pH	9.8	(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					
	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	1:45 PM		
	13/46 (30 min)	9.5	9.0-10.0	2:15 PM			
	14/47 (60 min)	9.5	9.0-10.0	2:45 PM			
	15/48 (2 hrs)	9.5	9.0-10.0	3:45 PM			
	16/49 (2 hrs 25 min)	9.5	9.0-10.0	4:10 PM			
	17/50 (3 hrs Final)	7.5	7.5-8.5	4:45 PM			
	NOTE: If not as specified notify Supervisor & note in log						
	If final pH is above 8.5, add pH to 7.5-8.5 & Record: pH Assume 77%						
						27-D	
9	28	While striking, run 30" (234 G) water into V-339					
	29	Add in 7-8 min			3	250	530-A 350
	31	Add to 49" (382 G) at 80 - 100°F					
	32	Stir 5 min & record pH	10.3	(9.5-10.5)			
	33	Stir 15 min or longer to dissolve for SP Step 26					
	34	Record Vol 49" & calculate 49" (Vol) x 0.78 = 38.2 G					
	35	Set preset #8 to 38.2-G from S 34					
	36	Add 30" (300 G) water to V-302					
	37	Add & stir 2 min For S 41	Assume 50%		160	7-D	80
3	38	SP Step 17/50 - After checking pH, Operator Step PB					
	39	SIFT in 2 Bags			100	128-A	100
P	40	SP Step 23/53 - Record: pH	3.7	(3.7-4.2)			
&	41	Run in N-7-D from S 37 in 10-12 min & stir 5 min					
P	42	Record: pH 9.5 (9.0-9.5) & if necessary add pH 9.0-9.5					
3		& 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	9.5	(9.0-10.0)	Time 5:45 PM		
	45	Operator Step PB					
	46	SP Step 60 - Batch complete					
	Start Finish Optr						
	Time SP Step	Time SP Step					
	11:00 PM	7:00 AM			235 - 322		
	7:00 PM	3:00 PM			282 - 381		
	3:00 PM	5:45 PM			237 - 321		





