

D.V.

PROCESSES		APPROVED BY	
()	KY-795-D	(H)	EWK 10-05-76
()		()	DCG 10-07-76
()		()	MTW 10-11-76
()		()	FWP 12-22-78
TYPED BY			
emw122278			

243
243 (Automated)

CG 03 CODE KY-795-D PKG.

LST. WGT 880 1110 LB.

STD. HRS 8.2

TIME

14 YC-2-B 93 4 Lot 24775, 3500# MAY - 5 1980

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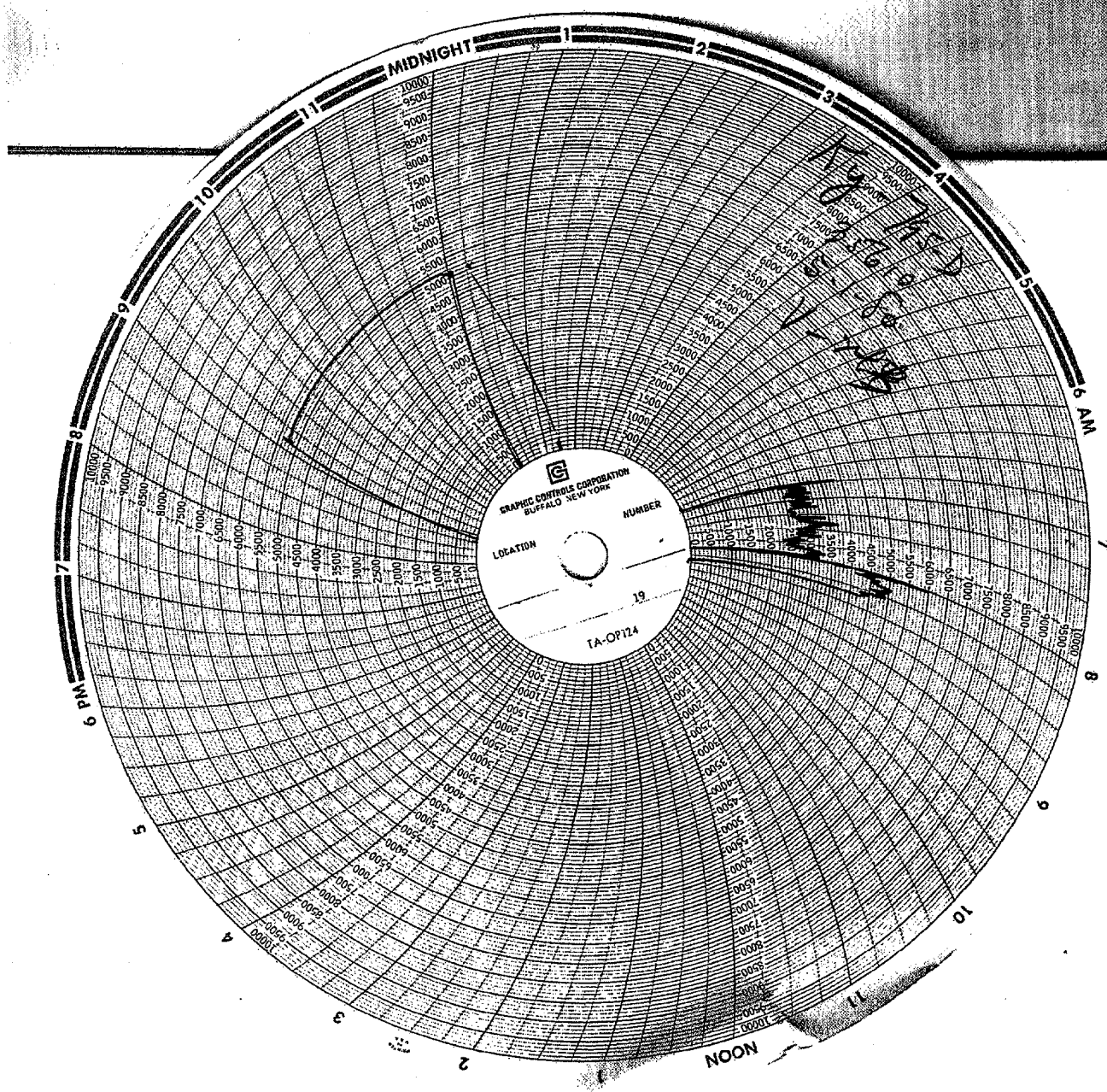
Total Wgt. 4612# 4386

NON-BLEEDING

ITEM	NAME	USE LBS.	N CODE	ACCT. LBS.
203	Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED			
205	2 Weigh in drum & pour in	475	32-D	475
1	3 Dump in & stir 5 min	Lot 70 x 50	YC-2-B	3500
	Record: Start 3:45 PM	24775		
	Fin 5:45 PM	3500		
	75" (1275 G)			
	4 Adj to 78" (1328 G)			
	5 Pump V-203 thru Homog at 2400-2600 psi into V-205			
	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7 Record: V-205 Vol 41 " & adj to 51" (1874 G)			
	8 Inspect Homog strainer & clean if necessary			
	9 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
205	10 Run 10" (514 G) water into V- & start agitator			
SV	11 Pump V-205 thru Homog at 4800-5200 psi into V- 243			
2	Record: Time Start 9:00 PM Total Min 180			
	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. Rinse in using Hot Water			
SP	13 SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (V-244)			
CP	14 Press SV Cam Reset PB set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
3	15 Record levels and set Raw Material Counter #1 as follows:			
	a. 11 LG 80% - preset #1 104 Gal		15-A	208
	16 Set strike flow controllers as follows:			
	a. 3FC10 (N-27-D Controller) in Manual 0.71 0.95 GPM		27-D	394
	b. 3FC20 (N-27-D Water) in Manual Local 5.8 7.7 GPM			296
	c. 3FR10 (N-27-D / Water Ratio) 0.8			
	d. 8FC10 (N-32-D Controller) in Manual 0.90 1.27 GPM		32-D	2675
	e. 8FC20 (N-32-D Water) in Manual Local 5.4 6.2 GPM	4.4		1885
	f. 8FC20 (N-32-D Water) in Remote			
	g. 8FR10 (N-32-D / Water) Ratio 1.0			
SV	17 Operator Step PB			
SP	18 Record Level 2LG 88% if below 35% follow solution make-up procedure for N-27-D			
CP	19 Adj SV to 68" (3495 G)			
	20 Record: pH 10.8 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D) Assume 50%	10	7-D	5
	Siphon N-7-D into SV & Record: pH 11.1			
	21 Operator Step PB			

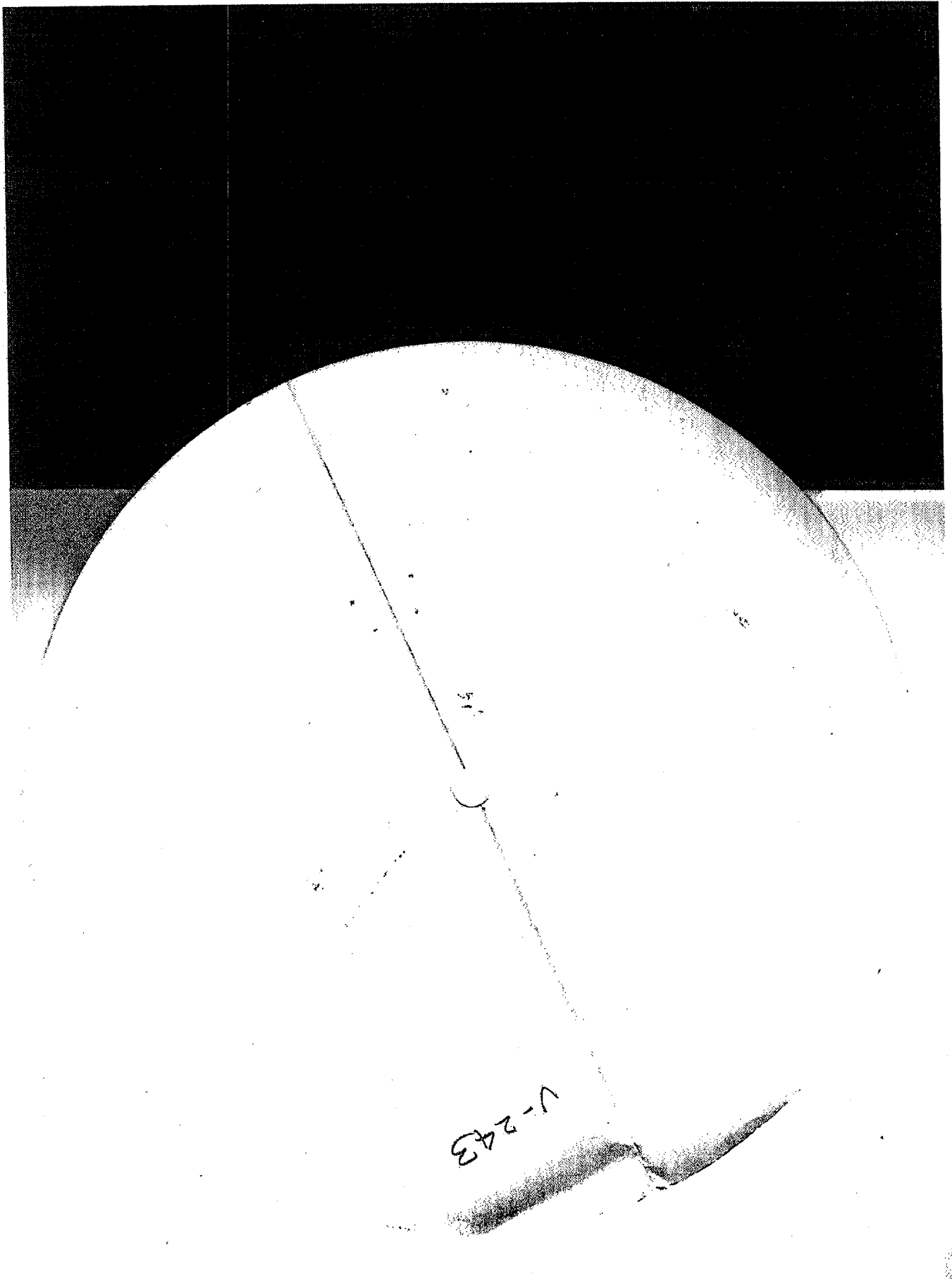
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EQUIPMENT		PAGE 2 CG 03 CODE KY-795-D (H) EST. WGT.		4612 LBS.		USE LBS.	N CODE	ACCT LBS.
SV	21	SP Step 06/39 - After heat up. Record: pH 10.0-10.0						
SP	22	Switch 3FC20, 8FC10, 8FC20, to Auto						
&	23	Operator Step PB						
CP	24	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
5		switch 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:				3:30 AM		
		SP Step						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	9.8	9.0-10.0	4:00			
		14/47 (60 min)	9.8	9.0-10.0	4:30			
		15/48 (2 hrs)	9.75	9.0-10.0	5:30			
		16/49 (3 hrs)	9.7	9.0-10.0	6:30			
		17/50 (Final)	7.1	7.5-8.5	7:15			
		NOTE: If not as specified notify Supervisor & note in log						
		If final pH above 8.5 adj to 7.5-8.5						
		& Record: pH		Assume 77%			27-D	
Drum	28	Weigh into 55 Gal Drum				Assume 50%	56	7-D 28
7	29	Fill with water & stir 2 min						
SV	30	SP Step 17/50 - After checking pH, Operator Step PB						
SP	31	Step 23/53 - Record: pH 3.4 (3.3-3.7)						
&	32	If necessary adj pH to 3.3-3.7 (DOWN ONLY) Record: pH					15-A	
CP	33	Sift in 3 bags				150	128-A	150
8	34	Siphon in N-7-D from S 29 in 10-12 min & stir 5 min						
	35	Record: pH 4.2 (4.0-4.2) & if necessary adj to pH 4.0-4.2						
		& 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						
	36	Operator Step PB						
	37	SP Step 24/54 - Pour in & stir 15 min				22	978-A	22
	38	Operator Step PB						
	39	SP Step 60 - Batch complete						
Pump to V240								
START FINISH OPTR								
TIME		SP STEP		TIME		SP STEP		
11:00 P				11:00 P				126-120
11:00 P				2:00 AM				235
11:00 P				2:10 AM				282-342

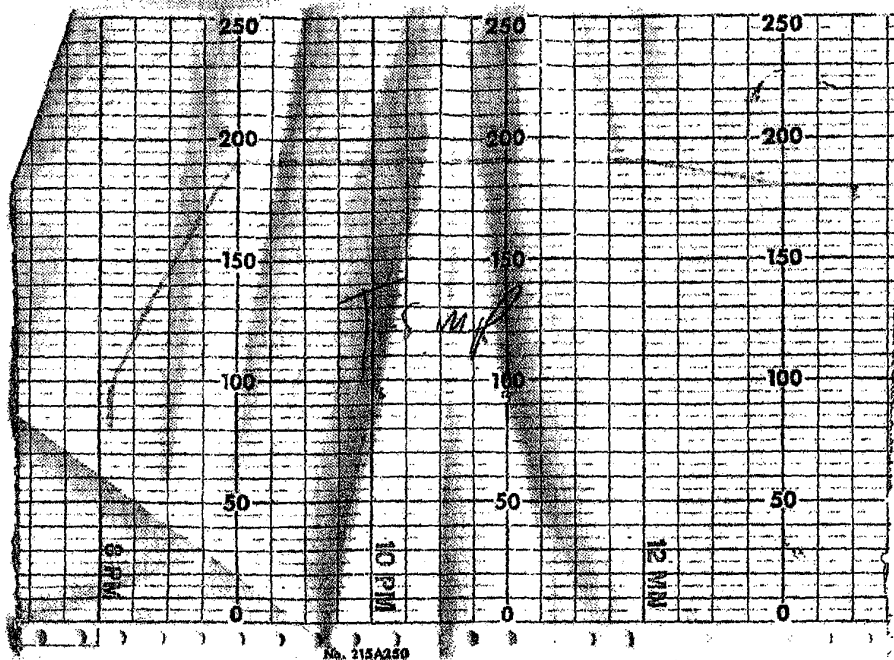


DUP050456697

N32116.01



DUP050456698



DUP050456699

N32116.02

