MAR 24 1980

MAKING INSTRUCTIONS: BATCH UNIT

(243) 244 (Automated) PUNCHED & CHECKED

CG 03 CODE KY-795-D PKG.

MAR 25 35061 MAR 27 1980

1ST. WGT 1110 LB.

STD HRS 8.2 TIME 3 PM

14 YC-2-B 93 4 Lot 24462, 2100#

14 YC-2-B 93 4 Lot 24429, 1400#

14 YC-2-B 93 4 Lot _____, _____#

Total Wgt. 4612#

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	

OK HP JH

MAR 28 1980

Homog #4 - 2nd Pass

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® YELLOW MEDIUM		USE LBS.	N CODE	ACCT LBS.
203 & 205 1	1	Run 60" (992 G) water into V-203. SET AGITATOR ON HIGH SPEED.				
	2	Weigh in drum & pour in		475	32-D	475
	3	Dump in & stir 5 min	Lot 70 x 50	2100	YC-2-B	3500
		Record: Start 1130 PM	24462			
		Fin 1245 AM	24429	1400		
		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 44 " & adj to 51" (1874 G)				
	8	Inspect Homog strainer & clean if necessary				
		DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.				
205 & SV 2	9	Run 10" (514 G) water into V-243 & start agitator				
	10	Pump V-205 thru Homog at 4800-5200 psi into V-243				
		Record: Time Start 2000 PM Total Min 125				
		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. Rinse in using Hot Water				
SP & CP 3	12	SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (V-244)				
	13	Press SV Cam Reset PB set 22 TC in Auto Remote (Temperature is set at 190-194oF)				
	14	Record levels and set Raw Material Counter #1 as follows:				
		a. 11 LG 44 % - preset #1	104 Gal		15-A	208
	15	Set strike flow controllers as follows:				
		a. 3FC10 (N-27-D Controller) in Manual	0.95 GPM		27-D	394
		b. 3FC20 (N-27-D Water) in Manual Local	7.7 GPM			
		c. 3FR10 (N-27-D / Water Ratio)	0.8			
		d. 8FC10 (N-32-D Controller) in Manual	1.27 GPM		32-D	2675
		e. 8FC20 (N-32-D Water) in Manual Local	6.2 GPM			
		f. 8FC20 (N-32-D Water) in Remote				
		g. 8FR10 (N-32-D / Water) Ratio	1.0			
SV SP & CP 4	16	Operator Step PB				
	17	Record Level 2LG 84 % if below 35% follow solution make-up procedure for N-27-D				
	18	Adj SV to 68" (3495 G)				
	19	Record: pH 10.5 Adj to 11.1-11.3 using N-7-D dilute to 5% (10 parts water to 1 part N-7-D)	Assume 50%	30	7-D	15
		Siphon N-7-D into SV & Record: pH 11.2				
	20	Operator Step PB				

REV.

JM

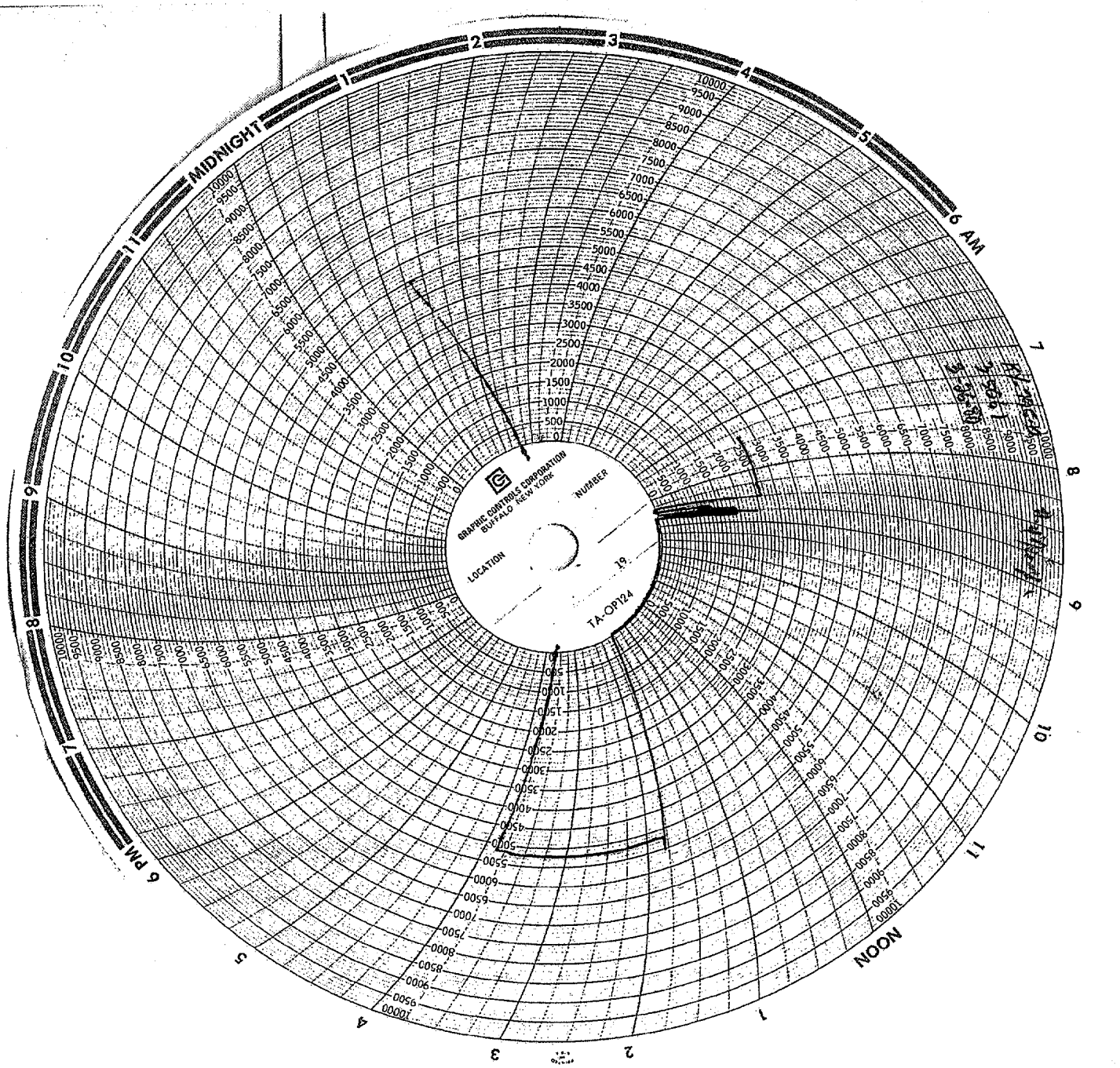
N32469

V-243

EQUIPMENT		PAGE 2 CG 03 CODE KY-795-D (H) EST. WGT. 4612 LBS.	USE LBS.	N CODE	ACC LBS.
SV	21	SP Step 06/39 - After heat up Record: pH 9.9 (9.5-10.0)			
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:			
		SP Step		8:45 PM	
		V-243/V-244 pH Range Time			
		13/46 (30 min) 9.7 9.0-10.0 9:15			
		14/47 (60 min) 9.7 9.0-10.0 9:45			
		15/48 (2 hrs) 9.7 9.0-10.0 10:45			
		16/49 (3 hrs) 9.7 9.0-10.0 11:45			
		17/50 (Final) 6.9 7.5- 8.5 12:30			
		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 3.5 (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 4.1 (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			

START TIME	START SP STEP	FINISH TIME	FINISH SP STEP	OPTR
7:00 AM		7:00 AM		37
3:00 P		11:00 P		335
11 PM		7 AM		120

DUP050461380



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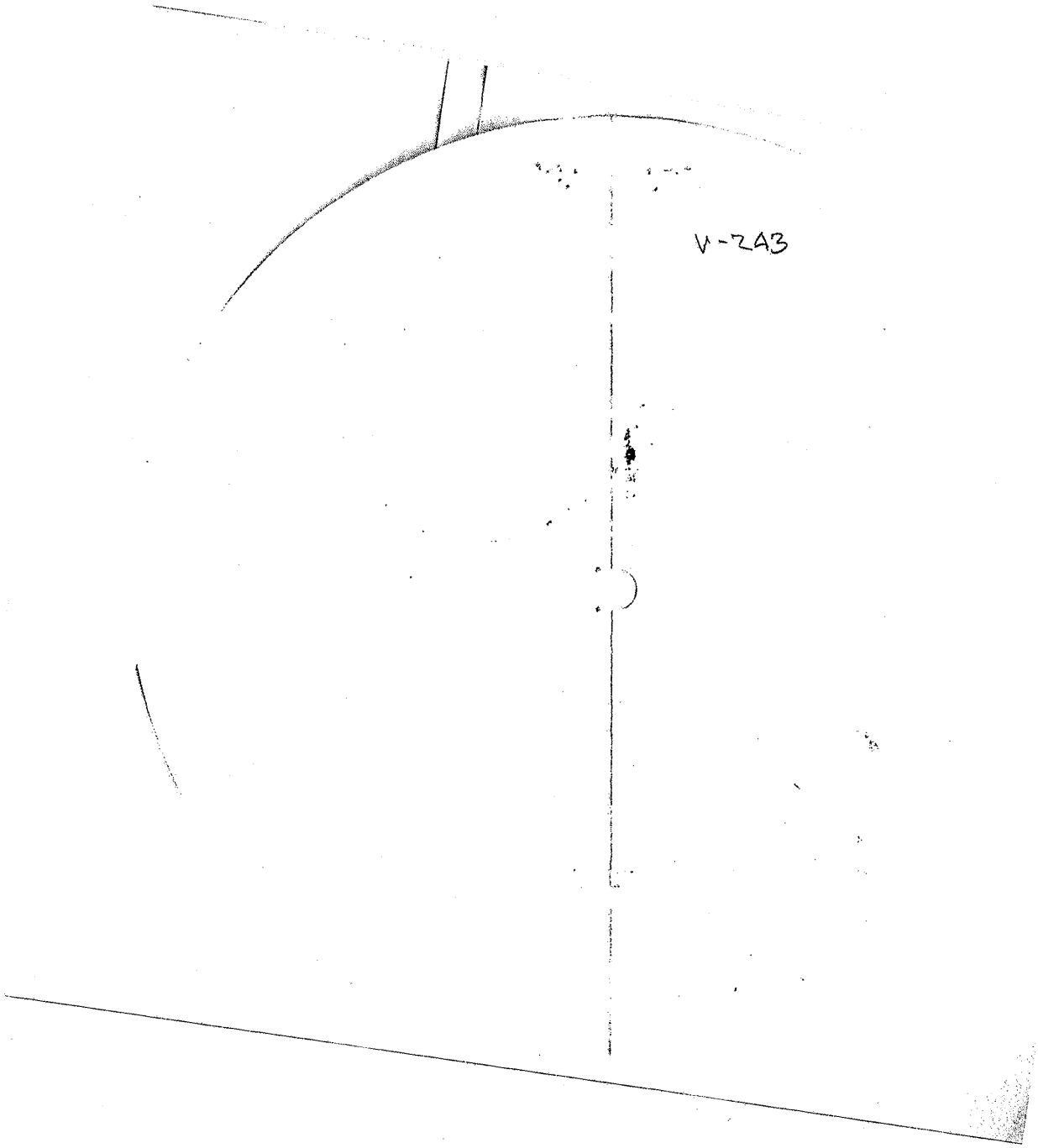

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