

(Automated)

PUNCHED & CHECKED

D.V.

PROCESSES

APPROVED BY

03 ONE KY-795-D PKG

APRIL 24 80 35116

APR 24 1980

OK

FP

TYPED BY
VermW122278

EWK 10-05-76

DCG 10-07-76

MTW 10-11-76

FWP 12-22-78

10 Hrs. B. 2 TIME

14 YC-2-B 93 4 Lot 24072 . 2000 #

14 YC-2-B 93 4 Lot 24076 . 1200 #

14 YC-2-B 93 4 Lot 24776 . 300 #

Total Wgt. 4612#

APR 25

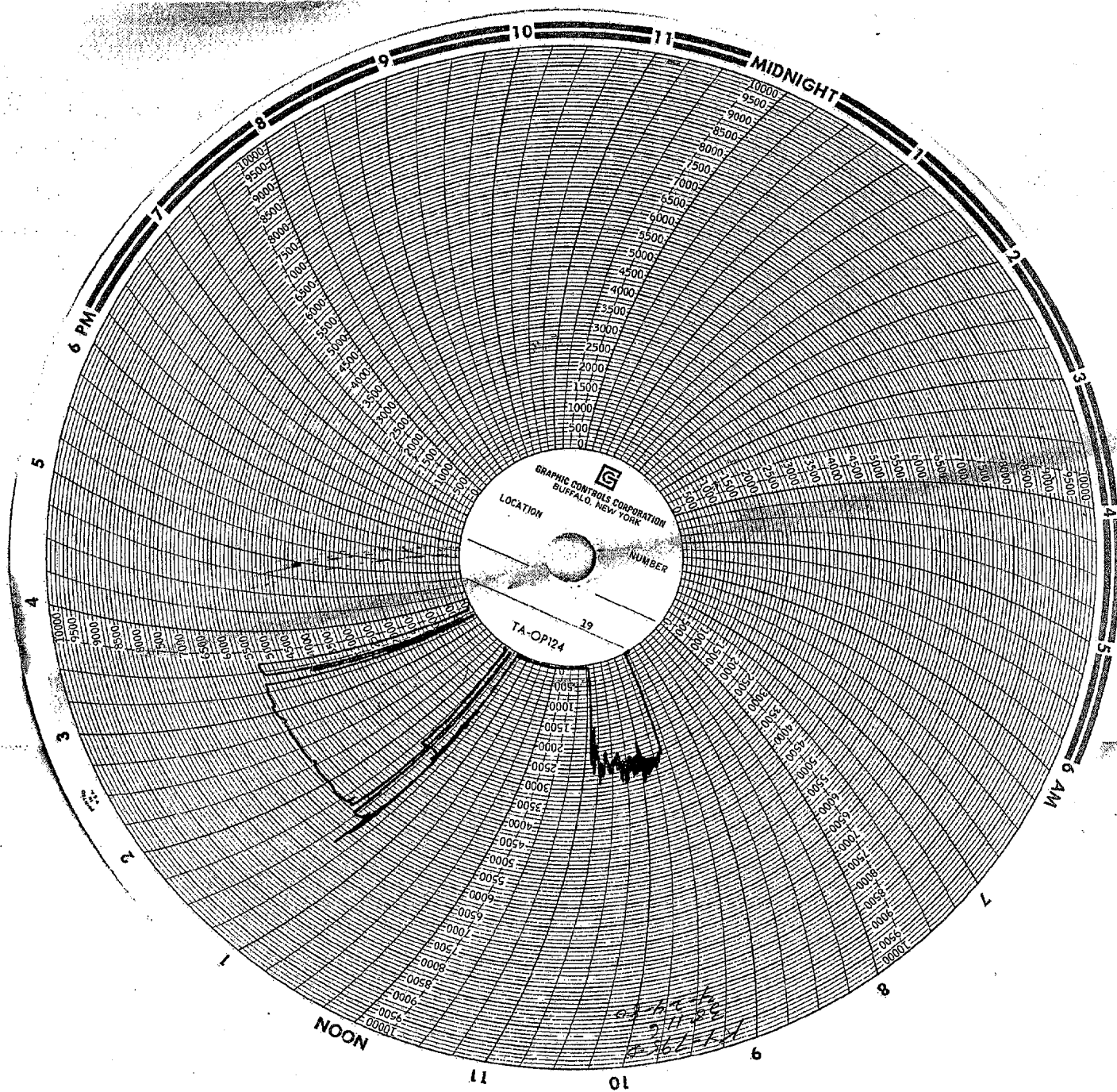
Homog #3 - 224 Pass

NON-BLEEDING

TIME	NAME	KROLOK YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203	1	Run 60" (992 G) water into V-203			
8	2	Weigh in drum & pour in	475	32-D	475
205	3	Dump in & stir 5 min			
1		Record: Start 7:00 AM	Lot	70 x 50	YC-2-B 3500
		Fin 7:15 AM	24072	2000	
		75" (1275 G)	24076	1200	
		Adj to 78" (1328 G)	24776	300	
	4	Pump V-203 thru Homog at 2400-2600 psi into V-205			
	5	When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7	Record: V-205 Vol 48" & adj to 51" (1874 G)			
	8	Inspect Homog strainer & clean if necessary			
		When Homog Run V-203 AGITATOR ON LOW SPEED			
205	9	Run 10" (514 G) water into V-205 & start agitator			
SV	10	Pump V-205 thru Homog at 4800-5200 psi into V-205			
		Record: Time Start 7:50 P Total Min 140			
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. Rinse in using Hot Water			
SP	12	SP Step 01 - Set Formula Selector to position #5 (V-243) or #10 (V-244)			
8					
CP	13	Press SV Cam Reset PB set 22 TC in Auto Remote (Temperature is set at 190-194°F)			
3					
	14	Record levels and set Raw Material Counter #1 as follows:			
		a. 11 LG 52% - 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	16	Operator Step PB			
SP	17	Record Level 2LG 42% if below 35% follow solution make-up procedure for N-27-D			
8					
CP	18	Adj SV to 68" (3495 G)			
4	19	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%		7-D	6
		Siphon N-7-D into SV & Record: pH 11.2			
	20	Operator Step PB			

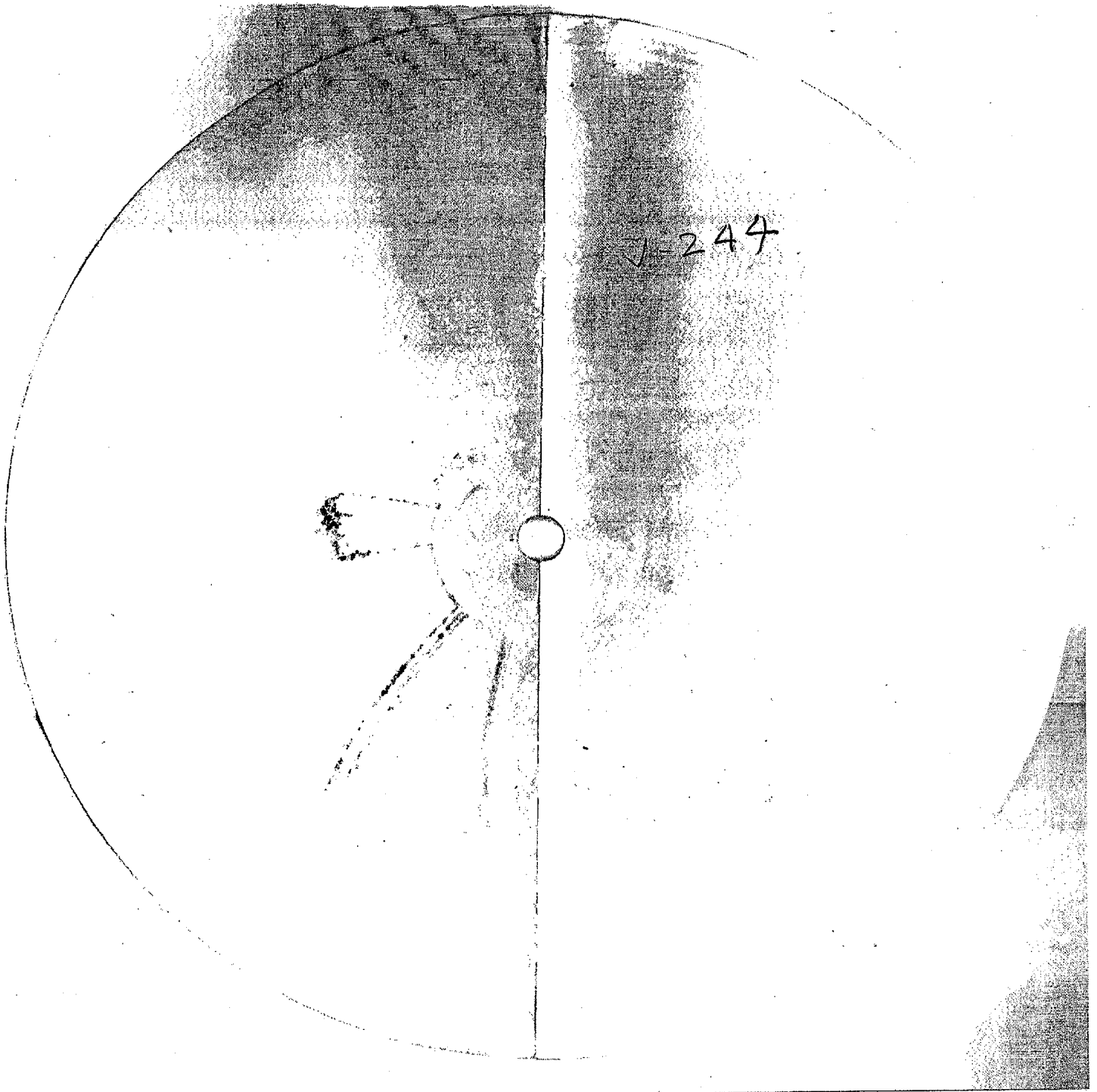
V-244

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 <u>9.7</u> (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 switch 3FC10 to Auto, Operator Step PB						
5	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						
		V-243/V-244	pH	Range	Time			
		13/46 (30 min)	<u>9.5</u>	9.0-10.0	<u>6:50</u>			
		14/47 (60 min)	<u>9.5</u>	9.0-10.0	<u>7:20</u>			
		15/48 (2 hrs)	<u>9.6</u>	9.0-10.0	<u>8:20</u>			
		16/49 (3 hrs)	<u>9.6</u>	9.0-10.0	<u>9:20</u>			
		17/50 (Final)	<u>7.9</u>	7.5- 8.5	<u>10:05</u>			
		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 (3.3-3.7)						
&	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 <u>3.9</u> (4.0-4.2) & if necessary adj to pH 4.0-4.2						
		& Record: pH <u>4.0</u>			Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D)			Assume 50%	10	7-D	5
		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	FINISH	OPTR				
		TIME	TIME	SP STEP				
		<u>9:24</u>	<u>3:00 PM</u>	<u>126-201</u>				
		<u>3:00 PM</u>	<u>10:35 PM</u>	<u>235-323</u>				



N32442.01

DUP050461246





N32442.02

DUP050461248

