

PUNCHED & CHECKED
MAR 13 1980
OR
RP

PROCESSES		APPROVED BY	
() KY-788-D	(J)	EWK	9/28/76
()	()	MTW	9/30/76
()	()	DCG	9/30/76
TYPED BY			
NE 2-18-77			

EST. WGT. MAR 10 34804
960-860 LBS.
STD. HRS. 8.8 TIME 7 A M
14 YC-3-B 98 4 Lot 24417
14 YC-3-B 98 4 Lot 23864
14 YC-3-B 98 4 Lot

HOMO #3 2ND PASS

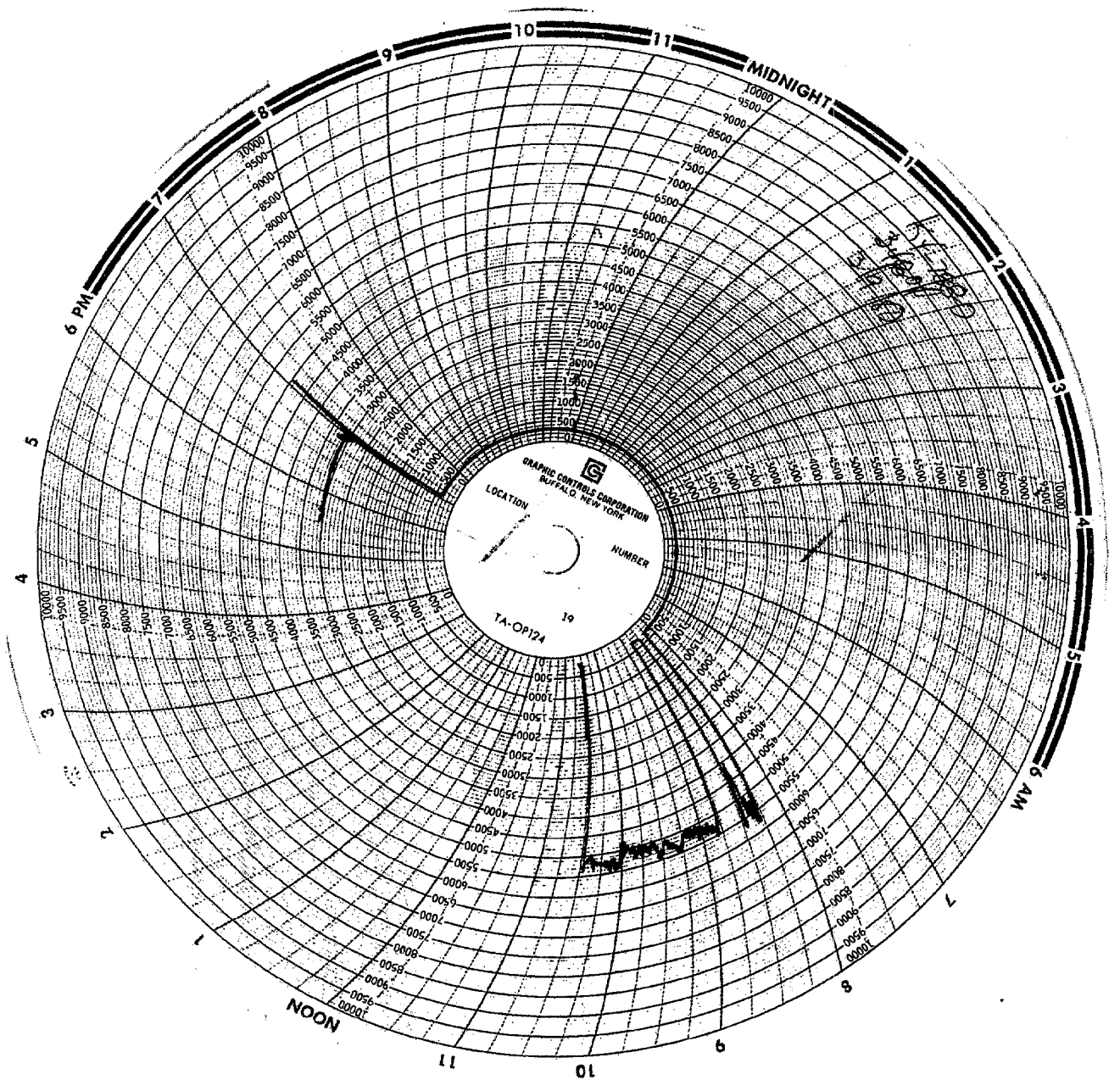
Total Wgt. 9560# 3460

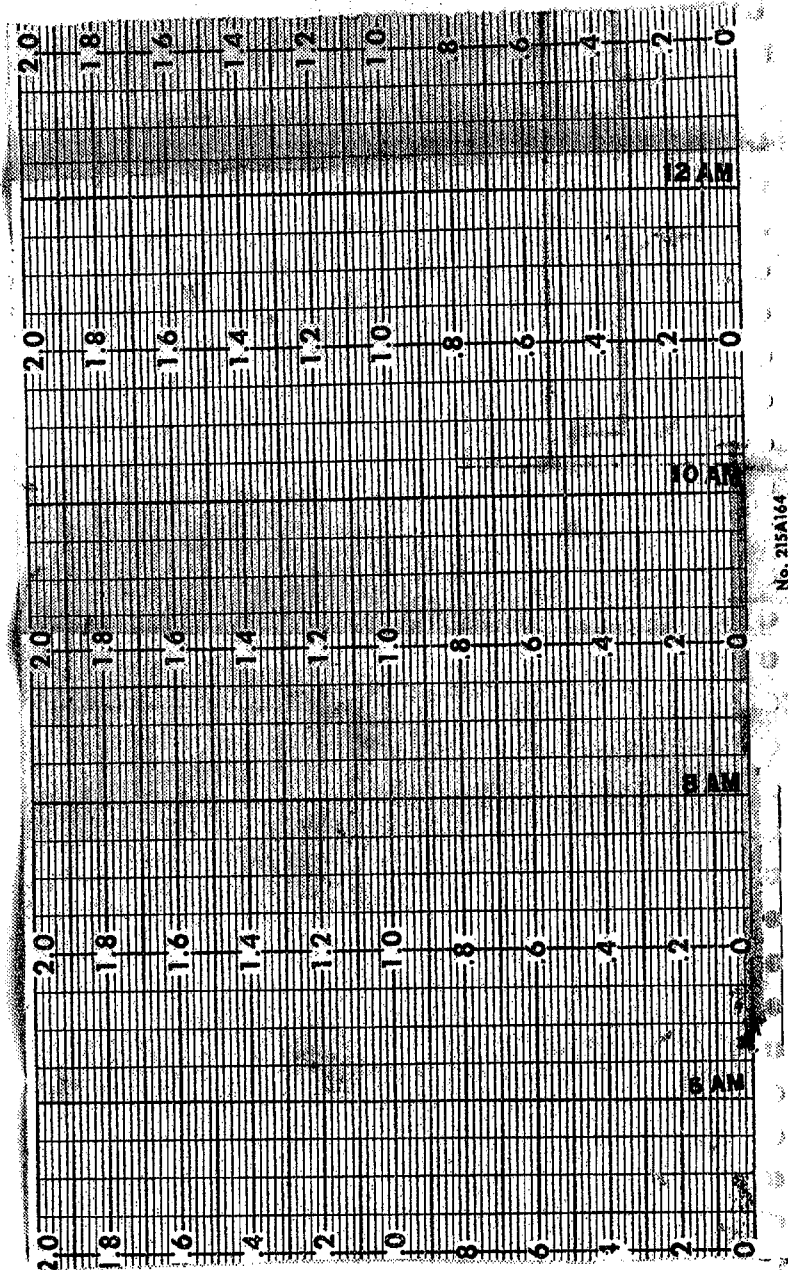
NON-BLEEDING

MENT	NAME	USE LBS.	N CODE	ACCT LBS.
203	60" (9906) "KROLOR" YELLOW - LIGHT			
1	1 Run 23" (360 G) water into V-203. RUN AGITATOR ON HIGH SPEED			
2	2 Weigh in drum & pour in	345	32-D	345
3	3 Dump in & stir 5 min	52 x 50	YC-3-B	2600
	Record: Start 3:30 P.M. Lot 24417	2000		
	Fin 4:30 P.M. 23864	600		
	75" (1275G)			
4	4 Adj to 70" (1200 G) 2400-2600			
5	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205			
6	6 When V-203 MTY washcolor thru Homog at 1800-2200 psi using minimum water 263			
7	7 Record: V-205 Vol 60 " & adi to 60" (2100 G)			
8	8 Inspect homog. strainer & clean if necessary			
9	9 Run 10" (514 G) water into V- 243 & start agitator			
10	10 Pump V-205 thru Homog at 4800-5200 psi into V- 243			
	Record: Time Start 8:40 AM total min 100			
	Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
11	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 #3 (V-243) or #8 (V-244)			
13	13 Press SV Cam Reset PB- set 22 TC in Auto Remote (Temperature is set at 190-194 F)			
14	14 Record levels and set Raw Material Counter #1 as follows			
	a. 11G 44 % - preset #2 208 Gal 15-A 416			
	b. 13G 88 % - preset #6 135 Gal 20-A 135			
15	15 Set strike flow controllers as follows:			
	a. 2FC10 (N-27-D Controller) in Manual 0.54 GPM 27-D 180			
	b. 2FC20 (N-27-D Water) in Manual Local 4.4 GPM			
	c. 2FR10 (N-27-D/Water) Ratio 0.8			
	d. 2FC10 (N-32-D Controller) in Manual 0.72 GPM 32-D 1215			
	e. 2FC20 (N-32-D Water) in Manual Local 3.9 GPM			
	f. 2FC20 (N-32-D Water) in Remote			
	g. 2FR10 (N-32-D/Water) Ratio 1.1			
20	16 Operator Step PB			
243	17 Record Level 21G 55 %. If below 35% follow solution make-up procedure for N-27-D			
SP	18 Adi SV to 47" (2400 G)			
19	19 Record pH 10.0 . Adi to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% 20 7-D 10			
20	20 Operator Step PB			

V-243

ENT	PAGE 2	CG 03	CODE KY-788-D	EST. WGT. 3560	LBS.	USE LBS.	N CODE	ACCT LBS.
21	SP Step 06/39	- After heat up Record: pH 9.5 (9.5-10.0)						
22	Switch 3FC20	8FC10, 8FC20 to Auto						
23	Operator Step PB							
24	SP Step 10/43	- When 3FC20, 8FC10, 8FC20 water flows is limits. 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							
	V-243/V-244	pH	Range	Time	12:55 PM			
	13/46 (30 min)	9.6	9.3-10.0	1:25 PM				
	14/47 (60 min)	9.6	9.3-10.0	1:55 PM				
	15/48 (2 hrs)	9.5	9.3-10.0	2:55 PM				
	16/49 (2 hrs 25 min)	9.5	9.3-10.0	3:20 PM				
	17/50 (Final 3 hrs)	7.1	7.5-8.5	3:55 PM				
	Note: If not as specified notify Supervisor & Note in log							
	If final pH is above 8.5, adj 7.5-8.5							
	& Record: pH Assume 77%							
							27-D	
28	While striking run 30" (234 G) water into V-339							
29	Add in 7-8 min					350	530-A	350
30	Adj to 49" (382 G) at 80-100 °F							
31	Stir 5 min & record pH (9.5-10.5)							
32	Stir 15 min or longer to dissolve for SP Step 26/56							
33	Record Vol 49 " & Calculate 49 " (Vol X 0.78 = 38.2 G)							
34	Set preset #8 to 38.2 G from S 33							
35	Run 40" (440 G) water into V-302							
36	Add & stir 2 min for S 40		Assume 50%			360	7-D	180
37	SP Step 17/50 After checking pH. Operator Step PB							
38	Sift in 2 bags					100	128-A	100
39	SP Step 23/53 Record: pH 3.1 (3.7-4.2)							
40	Run in N-7-D from S 36 in 10-12 min & stir 5 min							
41	Record: pH 8.5 (9.0-9.5) & if necessary adj to pH 9.0-9.5							
	& Record: pH 9.1		Assume 77%				27-D	
	(Dilute 10 parts to 1 part N-7-D)		Assume 50%			24	7-D	12
	Siphon N-7-D into V							
42	Operator Step PB							
43	SP Step 29 - Record: pH 9.2 (9.0-10.0) Time 5:15 PM							
44	Operator Step PB							
45	SP Step 60 - Batch complete							
	Start	Finish	Optr					
	Time	SP Step	Time	SP Step				
	1:00 PM		3:00 PM		409-381			
	3:00 PM		5:15 PM		174-145			





No. 215A164

