

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

V 243.244 (AUTOMATED) C V APR 3 1980 D V
 CG 03 CODE KY-787-D PKG
 → MAR 31 35133
 EST WGT 1090 LBS
 STD HRS 8.9 TIME
 14 YC-2-B 93 4 LOT 24468-24
 LOT
 LOT

PROCESSES	APPROVED BY
() KY-787-D	() EWK 9-22-76
()	() DCG 9-27-76
()	() MTW 9-30-76
()	()
RE TYPED BY	
CJH 2-8-80	

OK
 HP
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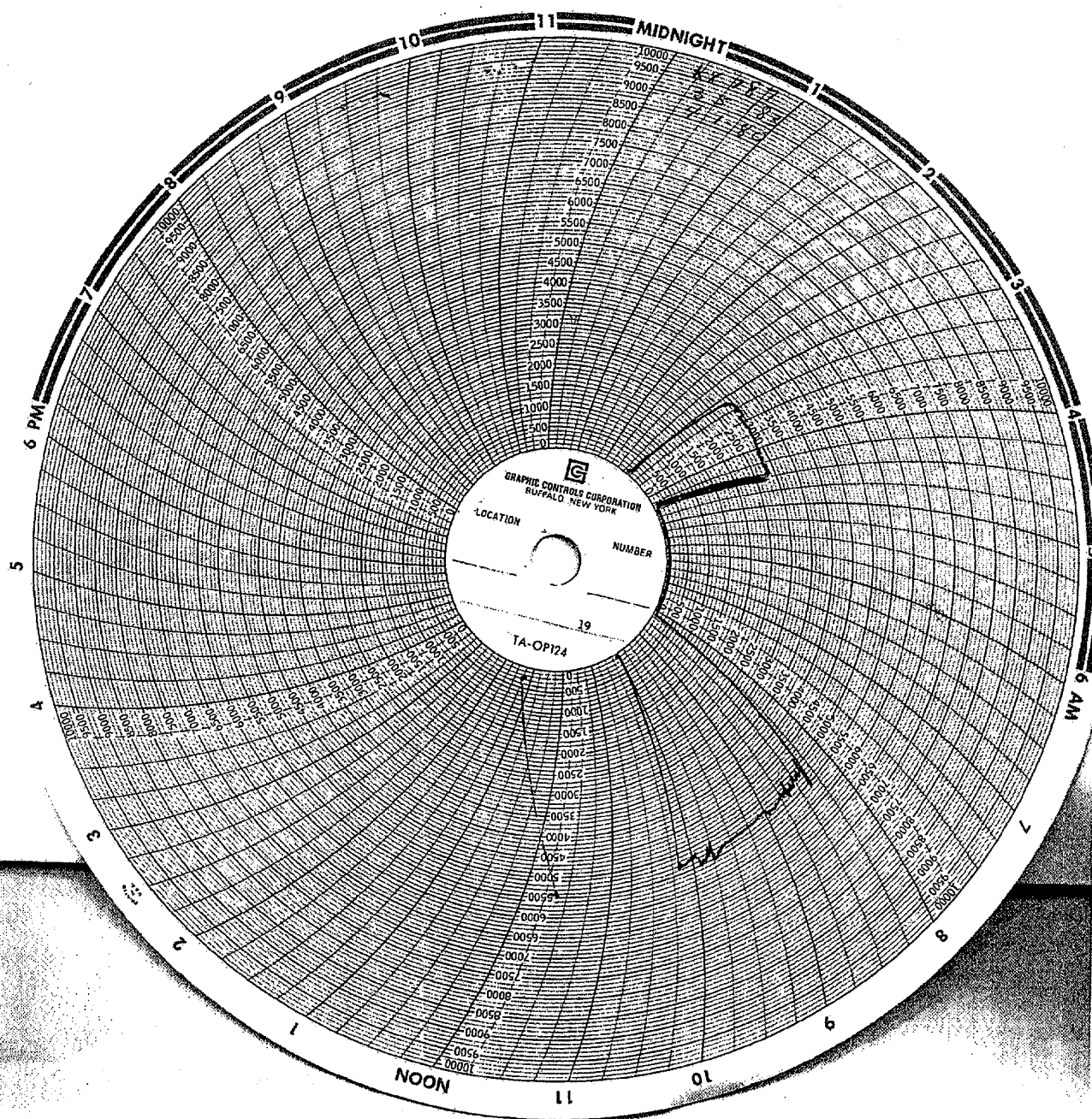
TOTAL WGT 3490#

NON-BLEEDING

IPMENT	NAME: "KROLOR" YELLOW MEDIUM	USE LBS	N CODE	ACCT LBS
203	1 RUN 60" (992 G) WATER INTO V-203. SET AGITATOR ON HIGH SPEED			
&	2 WEIGH IN DRUM & POUR IN	320	32-D	320
205	3 DUMP IN AND STIR 5 MIN	48 X 50	YC-2-B	2400
1	RECORD: START 24468	2400		
	FIN			
	25" (1275 G)			
	4 ADJ TO 70" (1200 G) 2400-2600			
	5 PUMP V-203 THRU HOMOG #3 AT 4800-2200 PSI INTO V-205			
	6 WHEN V-203 MTY, WASH COLOR THRU HOMOG AT 1800-2000 PSI USING MINIMUM WATER			
V-263	7 RECORD V-203 VOL 40" & ADJ TO 60" (2100 G)			
	8 INSPECT HOMOG. STRAINER & CLEAN IF NECESSARY			
	9 DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
&	10 RUN 10" (514 G) WATER INTO SV. START AGITATOR			
SV	11 PUMP V-203 THRU HOMOG AT 4800-5200 PSI INTO V-205			
2	RECORD: TIME START 9:50 PM TOTAL MIN 10.5			
	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
V-263	14 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			
&	17 (V-244)			
CP	13 PRESS SV CAM RESET PB-SET 22TC IN AUTO REMOTE			
3	(TEMPERATURE IS SET AT 190-194F)			
	14 RECORD LEVELS AND SET RAW MATERIALS COUNTER #1 AS FOLLOWS:			
	A. 11LG 55% - PRESET #1 80 GAL 15-A 160			
	B. 13LG 74% - PRESET #6 135 GAL 20-A 135			
	15 SET STRIKE FLOW CONTROLLERS AS FOLLOWS:			
	A. 3FC10 (N-27-D CONTROLLER) IN MANUAL 0.83 GPM 27 275			
	B. 3FC20 (N-27-D WATER) IN MANUAL LOCAL 5.28 GPM			
	C. 3FR10 (N-27-D/WATER RATIO) 0.64			
	D. 3FC10 (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. 8FR10 (N-32-D/WATER RATIO) 0.83			
SV	16 OPERATOR STEP PB			
SP	17 RECORD LEVEL 2 LG 44% IF BELOW 35% FOLLOW SOLUTION			
&	MAKE-UP PROCEDURE FOR N-27-D			
CP	18 ADJ TO 48" (2470 G)			
4	19 RECORD: PH 10.1			
	20 ADJ TO 11.1 - 11.3 USING N-7-D DILUTED TO 5% ASSUME 50% 70 7-D 10			
	(10 PARTS WATER TO 1 PART N-7-D)			
	SIPHON INTO SV. RECORD PH 11.2			
	22 OPERATOR STEP PB			

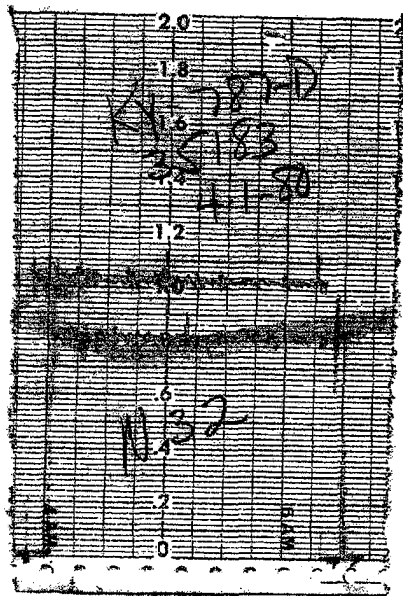
V-243

EQUIPMENT	PAGE 2	CG 03	CODE	KY-787-D	EST. WGT.	3490	LBS.	USE	N	ACCT
								LBS.	CODE	LBS.
SV	22	SP STEP 06/39 - AFTER HEAT UP RECORD: pH 9.8 (9.5-10.0)								
SP	23	SWITCH 3FC20, 8FC10, 8FC20 TO AUTO								
&	24	OPERATOR STEP PB								
CP	25	SP STEP 10/43 - WHEN 3FC20, 8FC10, 8FC20 WATER FLOWS IN LIMITS								
5	26	SWITCH 3FC10 TO AUTO OPERATOR STEP PB								
	27	SP STEP 11/44 - WHEN 3FC10, 3FC20 FLOWS IN LIMITS, SWITCH								
	28	3FC20 TO REMOTE								
	29	OPERATOR STEP PB								
	30	DURING STRIKE, RECORD pH & TIME AS FOLLOWS:								
		SP STEP								
		V-243/V-244	pH	" RANGE	TIME	2:25 A.M.				
		13/46 (30 MIN)	9.7	9.0-10.0	2:55 A.M.					
		14/47 (60 MIN)	9.7	9.0-10.0	3:55 A.M.					
		15/48 (2 HRS)	9.7	9.0-10.0	4:55 A.M.					
		16/49 (2 HRS 25 MIN)	9.7	9.0-10.0	5:20 A.M.					
		17/50 (3 HRS FINAL)	8.2	7.5-8.5	5:25 A.M.					
		NOTE: IF NOT AS SPECIFIED NOTIFY SUPERVISOR & NOTE IN LOG								
		IF FINAL pH IS ABOVE 8.5, ADJ pH TO 7.5-8.5 &								
		RECORD: pH				ASSUME 77%			27-D	
339	29	WHILE STRIKING, RUN 30" (234 G) WATER INTO V-339								
6	30	ADD IN 7-8 MIN					350		530-A	350
	31	ADJ TO 49" (382 G) AT 80 - 100°F								
	32	STIR 5 MIN & RECORD pH 10.2 (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								
302	36	ADD 30" (360 G) WATER TO V-302								
7	37	ADD & STIR 2 MIN FOR S 41				ASSUME 50%	160		7-D	80
243	38	SP STEP 17/50 - AFTER CHECKING pH, OPERATOR STEP PB								
	39	SLIT IN 2 BAGS					100		128-A	100
SP	40	SP STEP 23/53 - RECORD pH 4.1 (3.7-4.2)								
&	41	RUN IN N-7-D FROM S 37 IN 10-12 MIN & STIR 5 MIN								
CP	42	RECORD: pH 9.3 (9.0-9.5) & IF NECESSARY ADJ pH 9.0-9.5								
8		& RECORD: pH				ASSUME 77%			27-D	
		DILUTE 10 PARTS WATER TO 1 PART N-7-D				ASSUME 50%			7-D	
		SLURRY N-7 INTO SV								
	43	OPERATOR STEP PB								
	44	SP STEP 29/58 RECORD: pH 9.2 (9.0-10.0) TIME 6:15 A.M.								
	45	OPERATOR STEP PB								
	46	SP STEP 60 - BATCH COMPLETE								
		START				FINISH				
		TIME	SP STEP	TIME	SP STEP	OPTR				
		3:00 PM		11:00 PM		237-320				
		11:00 PM		6:15 AM		391.282				



N32169.01

DUP050456910



N32169.02

DUP050456911

