PUNCHED & CHECKED

APR - 7 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244, 246, 247 (262) C.V. D.V.

PROCESSES		APPROVED BY
( ) KY-907-D	(E)	EWK 12/12/77
( ) Alternate	( )	DCG 12/14/77
( )	( )	
( )	( )	
TYPED BY		
FJ 3/1/78		

CG 03 CODE KY-907-D PKG.

→ MAR 31 35175 MAR-31

EST. WGT. 1080 LBS.

STD. HRS. TIME 3 PM OK FP

14 YC-2-B 93 4 Lot 24777, 2400 # Homog #3 - 1ST Pass

14 YC-2-B 93 4 Lot _____, _____# " #4 - 2ND PASS

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

Total Wgt. 3480# (Req.)

NON-BLEEDING

QUIPMENT		NAME: (9206) KROLOR® YELLOW - MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1	Run 33" (560 G) water into V-203. SET AGITATOR ON HIGH SPEED			
	2	Pour in	320	32-D	320
	3	Dump in Lot 24777	48 x 50 2400	YC-2-B	2400
		Record: Start 6:30 P.M. Fin 7:30 P.M.			
		75" (1275 G)			
	4	Adj to ~~70~~" (~~1200~~ G) 2400-2600			
	5	Pump V-203 thru Homog #3 at ~~1800-2200~~ psi into V-205			
	6	When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7	Record: V-205 Vol 50 " & adj to 60" (2100 G)			
	8	Inspect Homog strainer & clean if necessary			
		FLUSH HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
SV & 205 2	9	Run 5" 10" (514 G) water into V-262. Install Temp chart & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into SV 262			
		Record: Time Start 12:30 PM Total Min 100			
		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 & pump thru Homog at 4800-5200 psi			
349 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ±1000# water into V-384 & heat to 110-120°F			
	14	Weigh into V-384 & pump to V-349	1840	32-D	1840
	15	Run ±1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 17" (805 G) & stir 15 min or longer			
	17	Record: °Be' 1.080 (11.0±0.2) (1.079-1.082) g/ml			
SV 4	18	When S 11 Homog complete, adj SV to ~~17~~" (2470 G)			
	19	Record: ph 12.7 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
		Siphon into SV & Record: pH 11.3			
	20	Heat to 190-194°F in 55-65 min & Record: HT ____°F & Rec °F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 39" (1070 G) water into V-343			
	22	Meter in from V-386 M 27, 930 #/Gal 29 Gal		27-D	275
	23	Stir 15 min or longer			
	24	Record: °Be' 1.018 (2.8±0.1) (1.017-1.018) g/ml			

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EQUIPMENT		PAGE 2 CG 03 CODE ky-907-D (E) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACC LBS.
SV 6	25	When S 20 heating complete Record: pH 10.0 (9.5-10.0)			
	26	Set V-343 acid pump at 82 setting (±150min)			
	27	Set V-349 silicate pump at 72 setting (± 120min)			
	28	Immediately meter in V-343&349, Maintain SV at 190-194 °F during strike			
	29	Record: Start Finish Minutes V-343 5:54 PM 9:30 PM 160 V-349 7:50 PM 9:30 PM 120			

Record:	Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
at 20 min	6:10 PM	(35)	(14) 14	9.8	9.3-10.0
40 min	6:30 PM	(30)	(11) 11	9.8	9.3-10.0
1 hrs	6:50 PM	(24)	(9) 9	9.8	9.3-10.0
2 hrs	7:50 PM	(8)	(0) 0	9.9	9.3-10.0
Finish	8:30 PM	(0)	(0)	9.1	7.5-8.5

Note: (1) If pH Not as specified notify Supervisor & Note in log (2) If final pH is above 8.5 adj to 7.5-8.5 & Record: pH = 9.1

	30	Sift in (Assume 78%)	125 / 50	27-D / 128-A	20 / 50
357 7	31	Run 11" (80 G) water into V-357 & heat to 135-140 °F			
	32	Dump in & stir to dissolve for S 60	160	15-A	160
302 8	33	Run 17" (208 G) water into V-302			
	34	Add & stir 2 min for S 62 (Assume 50%)	100	7-D	50
PT 9	35	During strike pump into PT	318	169-A	318
	36	Pump in	36	155-A	36
	37	Pump in	36	160-A	36
	38	Stir 10 min with lightning mixer for S 42			
356 10	39	During Strike, Run 14 20" (244G) water into V-356			
	40	Turn on steam			
	41	Adj to 26" (317G) at ~~178-182 °F~~ 85°C			
	42	Pump PT mixture from S38 thru undersurface Distributor AFAP			
	43	Rinse PT with hot water from hot water mixer & pump in			
	44	Shut off pump 82°C			
	45	Stir 30 min at ~~178-182~~ °F for S 54			
	46	Do not shut off agitator			
SV 11	47	When V-349 MTY, rinse in with minimum water then set pump to zero setting			
	48	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	49	Heat to 198-200 °F in 5-10 min			
	50	Close water line & discarge valves at stearate pump			
	51	Open V-356 discharge valves to stearate pump inlet			
	52	Open water valve at stearate pump & run water thru Homog at 2900-3100 PSI to sewer			
	53	While Homog water at 2900-3100PSI, open Homog Discharge valve to SV & close valve to sewer			
	54	Immediately open stearate pump discharge valve turn on pump & Homog V-356 to SV at 2800-3100 PSI Maintain SV at 198-200°F			
	55	While Homog V-356 to SV, shut off water valve at stearate pump ASAP			

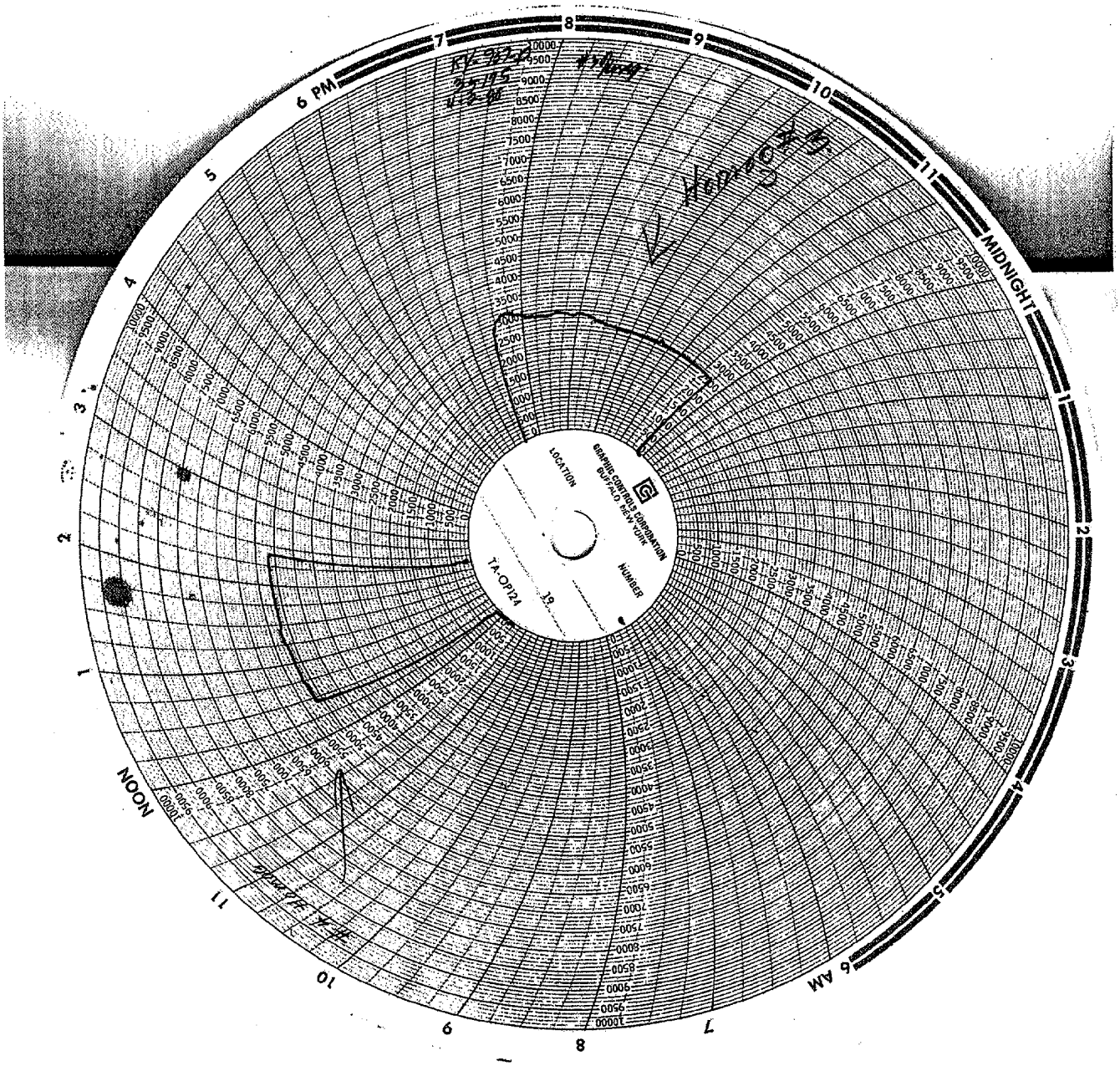
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EQUIPMENT		PAGE 3 CG 03 CODE KY-907-D (E) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 11 Con't	56	When Homog complete, Rince in V356 with hot water from hot water mixer			
	57	When S56 complete, turn off Homog & stearate pump			
	58	Stir 5 min at 198-200°F			
	59	Shut off steam			
	60	Run in V-357 from S32 and stir 5 min			
		Record: pH 3.1 (3.3-3.7)			
	61	If necessary, adj pH to 3.3-3.7 (Downward only) and Record: pH		15-A	
	62	Run in N-7-D from S34 in 4-6 min and stir 5 min			
	63	Record: pH 5.3 (4.2-4.4) and if necessary, adj to pH 4.2-4.4 & Record: pH 4.4 Assume 78%	15	27-D	12
		(Dilute 10 parts water to 1 part N-7-D Assume 50%		7-D	
		Siphon N-7-D into SV			
	64	Do not stop agitator			

START	FIN	QTR
7 A	3 P	12-27
11:00 F	7:00 AM	235 - 30
7:00 AM	3:00 PM	223-409
3:00 PM	10:30 PM	27

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N32150.01

DUP050456843

N32150.02

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