

DEC 17 1979

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

PROCESSES		APPROVED BY
() KO-786-D	(P)	EWK 9-21-76
()	()	DCG 9-21-76
()	()	MTW 10-1-76
TYPED BY		
JIC 11-16-76		

CG 04 CODE KO-786-D PKG.

DEC 19 33402

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

01 YC-10-B 93 4 32901 4000 # Bag 2
 01 YC-10-B 93 4 33051 100 # Bag
 01 YC-10-B 93 4

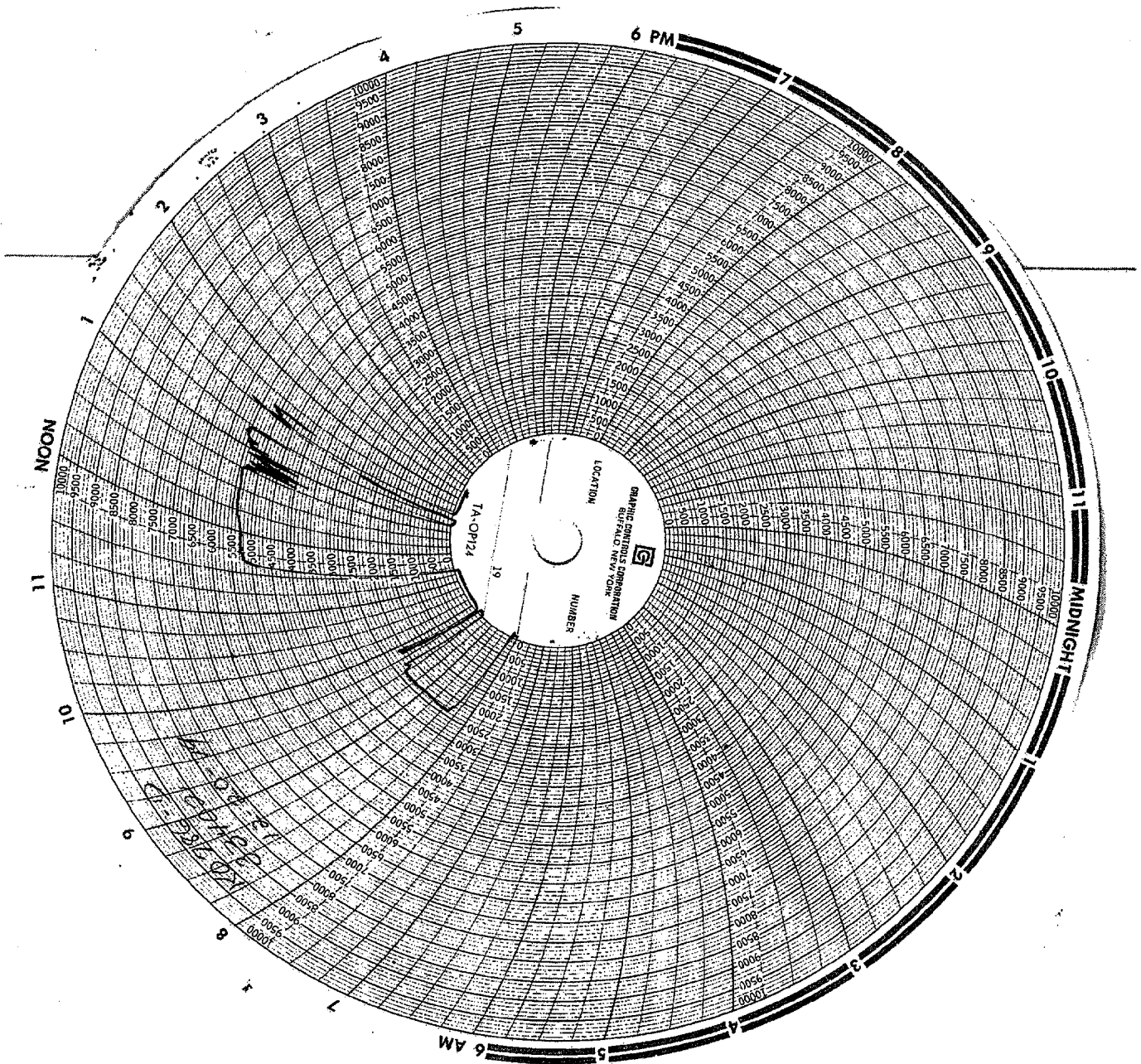
Total Weight 4962# (Req. .)

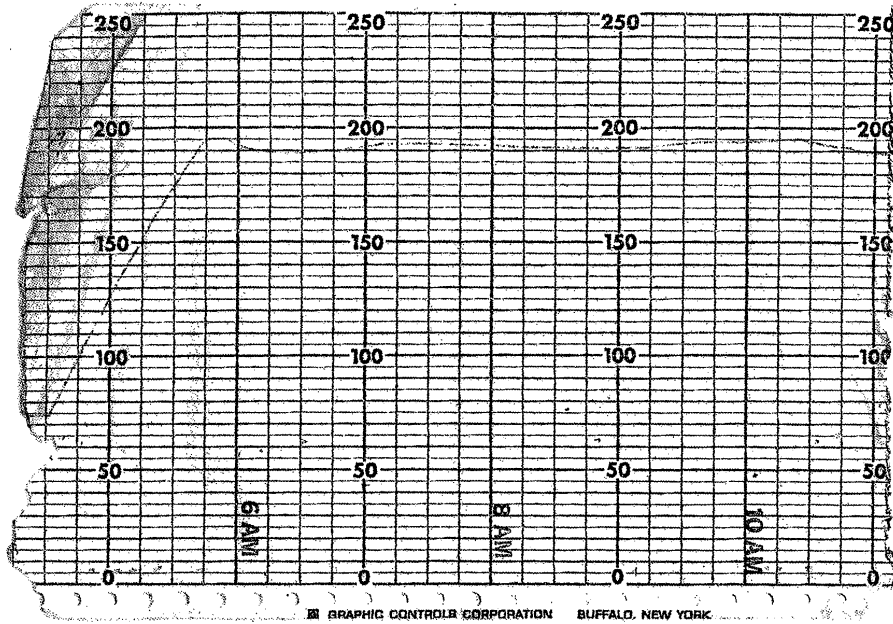
NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1 Run 60" (990 G) water in V-211 and add Assume 50% 2 Weigh in drum and pour in V-211 3 Dump in and stir 5 minutes LOT Record: Start 7:30 PM 32901 Fin 7:30 PM 33051 75" (12756) 4 Adjust to 80" (1370 G) 5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208 6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water 7 Record: V-208 Vol 42" and adjust to 50" (1840 G) 8 Inspect homog strainer and clean if necessary	30 270 82 x 50 4000 100	7-D 32-D YC-10-B	15 270 4100
208 & SV 2	9 Run 15" (771 G) water into V-247 and start agitator and install temperature chart 10 Pump V-208 thru Homog at 4800-5200 psi into SV Record: Time Start 11:20 AM Total Minutes 120 Note: If homog pressure falls below 4800 psi, 3-Way Valve will recirculate slurry to V-208 11 When V-208 MTY, run in 5" (240 G) water and 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 and heat to 110-120°F 14 Weigh into V-384 and pump to V-349 15 Run ±1000# water into V-384 and pump to V-349 16 Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer 17 Record: 10.9 ± 0.2 (1.078-1.081)	2400	32-D	2400
SV 4	18 When S 9 Homog complete, adjust to 66" (3400 G) in SV 19 Record: pH 11.0 and adjust to 10.4-10.8 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon N-7-D into SV and Record: pH 20 Heat to 190-194°F in 55-65 minutes & Record: HT F and Rec F Note: Strike must be started immediately on completion of heating		7-D	
343 & 386 5	21 While heating SV, run 5" (1400 G) water into V-343 22 Meter in from V-386 M 02 #/Gal 9.81 Gal 36.2 23 Stir 15 minutes or longer 24 Record: 10.8 (2.8 ± 0.1) (1.017-1.019)		27-D	355

V-247

EQUIPMENT	PAGE	CG 04	CODE	K0-786-D (R)	EST. WGT.	4962	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete. Record: pH <u>10.1</u> (9.6-10.2)								
	26	Set V-343 acid pump at 72 setting (± 25 minutes)								
	27	Set V-349 silicate pump at 66 setting (± 180 minutes)								
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike								
	29	Record: Start <u>7:15 P.</u> Finish <u>8:25 P.</u> Minutes <u>225</u>								
		V-343 <u>7:15 P.</u> V-349 <u>7:30 P.</u> Minutes <u>185</u>								
		Record:	Time	V-343 Inches	V-349 Inches	SV pH	Normal pH			
		at 20 min	<u>7:35 P.</u>	(47) <u>7.7</u>	(20) <u>2.0</u>	<u>9.8</u>	9.3-10.0			
		40 min	<u>7:55 P.</u>	(43) <u>7.3</u>	(17) <u>1.7</u>	<u>9.8</u>	9.3-10.0			
		1 hr	<u>8:15 P.</u>	(38) <u>3.8</u>	(15) <u>1.5</u>	<u>9.8</u>	9.3-10.0			
		2 hrs	<u>8:15 P.</u>	(24) <u>2.4</u>	(7) <u>.7</u>	<u>9.8</u>	9.3-10.0			
		3 hrs	<u>7:15 P.</u>	(10) <u>1.0</u>	(0) <u>.1</u>	<u>9.8</u>	9.3-10.0			
		Finish	<u>8:10 P.</u>	(0)		<u>8.0</u>	7.5-8.5			
		Note: If pH drops below 9.3 in 1st hour, stop pumps and see supervisor. If final pH is above 8.5, adjust to (7.5-8.5) and Record: pH <u>Assume 77%</u>								
									27-D	
357 7	30	Run 21" (150 G) water into V-357 and heat to 135-140°F								
	31	Dump in and stir to dissolve								
								300	15-A	300
302 8	32	Add 42" (514 G) water to V-302								
	33	Add and stir 2 minutes Assume 50%								
								150	7-D	75
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump to zero setting								
	35	When V-343 MTY, rinse in with minimum water, then turn off pump motor								
	36	TURN OFF STEAM								
	37	Run in V-357 from S 31 and stir 5 minutes								
	38	Record: pH <u>3.1</u> (3.3-3.7)								
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH <u>15-A</u>								
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes								
	41	Record: pH <u>4.2</u> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH <u>4.1</u> Assume 77%								
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%								
		Siphon N-7-D into SV								
	42	Stop agitator								
		START	FINISH	OPTR						
		<u>11:00 P.</u>	<u>7:00 A.</u>	<u>235-301</u>						
		<u>7:00 AM</u>	<u>7:00 PM</u>	<u>409</u>						
		<u>3:PM</u>	<u>4:40 P.M.</u>	<u>201-27</u>						





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