

V. 246 247

DEC 17 1979
C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 04 CODE K0-786-D PKG.

DEC 19 33403

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

7 A M

01 YC-10-B 93 4 32903 4000 # Bay 3
 01 YC-10-B 93 4 33051 100 # Bay 1
 01 YC-10-B 93 4

PROCESSES		APPROVED BY
() K0-786-D	(P)	EWK 9-21-76
()	()	DCG 9-21-76
()	()	MTW 10-1-76
TYPED BY		
JIC 11-16-76		

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 Record: Start 1100 32903 4000 Fin 100 33051 100 25" (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 41" 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- and start agitator and install temperature chart 10 Pump V-208 thru Homog at 4800-5200 psi into SV Record: Time Start 2:45A Total Minutes 125 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: 1080 (10.9 ±0.2) (1.078 - 1.081) 9/mL	2400	32-D	2400
SV 4	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV 19 Record: pH 10.9 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 192°F and Rec 19.6°F Note: Strike must be started immediately on completion of heating		7-D	
349 & 386 5	21 While heating SV, run 51" (1400 G) water into V-343 22 Meter in from V-386 M 82 #/Gal 9.91 Gal 36.2 23 Stir 15 minutes or longer 24 Record: 1018 (2.8 ±0.1) 1.017 - 1.019 9/mL		27-D	355

OK
H

Homog #2

J.M.

V-246

EQUIPMENT	PAGE	CG	04	CODE	K0-786-D (8)	EST. WGT.	4962	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S. 20 heating complete. Record: pH 10.0 (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 Finish Minutes									
		V-343 9:53 2:00 245									
		V-349 1:00 PM 1:55 PM 190									
		Record: Time V-343 V-349 SV Normal									
		Inches Inches pH pH									
		at 20 min 10:10 (47) (20) 9.8 9.3-10.0									
		40 min 10:35 (43) (17) 9.8 9.3-10.0									
		1 hr 10:55 (38) (15) 9.8 9.3-10.0									
		2 hrs 11:35 (24) (7) 9.8 9.3-10.0									
		3 hrs 12:55 (10) (0) 9.8 9.3-10.0									
		Finish 1:40 (0) 3 9.8 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 Assume 77%								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 3.7 (3.3-3.7)								15-A	
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH									
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes									
	41	Record: pH 4.2 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH 7.2 Assume 77%								27-D	3
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%								7-D	
		Siphon N-7-D into SV.									
	42	Stop agitator									
		START FINISH OPTR									
		11:00 PM 7:00 AM 235-301									
		7:00 AM 2:35 PM 909									

