

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

C.V.

D.V.

CG 03 CODE KY-787-D PKG.

→ FEB 26 34563

EST. WGT. 1090 990 LBS.

STD. HRS. 10.6 TIME

14 YC-2-B 93 4 Lot 24064.400 #

14 YC-2-B 93 4 Lot 24170.2000 #

14 YC-2-B 93 4 Lot #

PROCESSES		APPROVED BY
() KY-787-D	()	
() Alternate	()	
()	()	FWK 9/22/76
()	()	DCG 9/22/76
TYPED BY		MTW 9/30/76
NE 2/12/77		

PUNCHED & CHECKED

FEB 23 1977

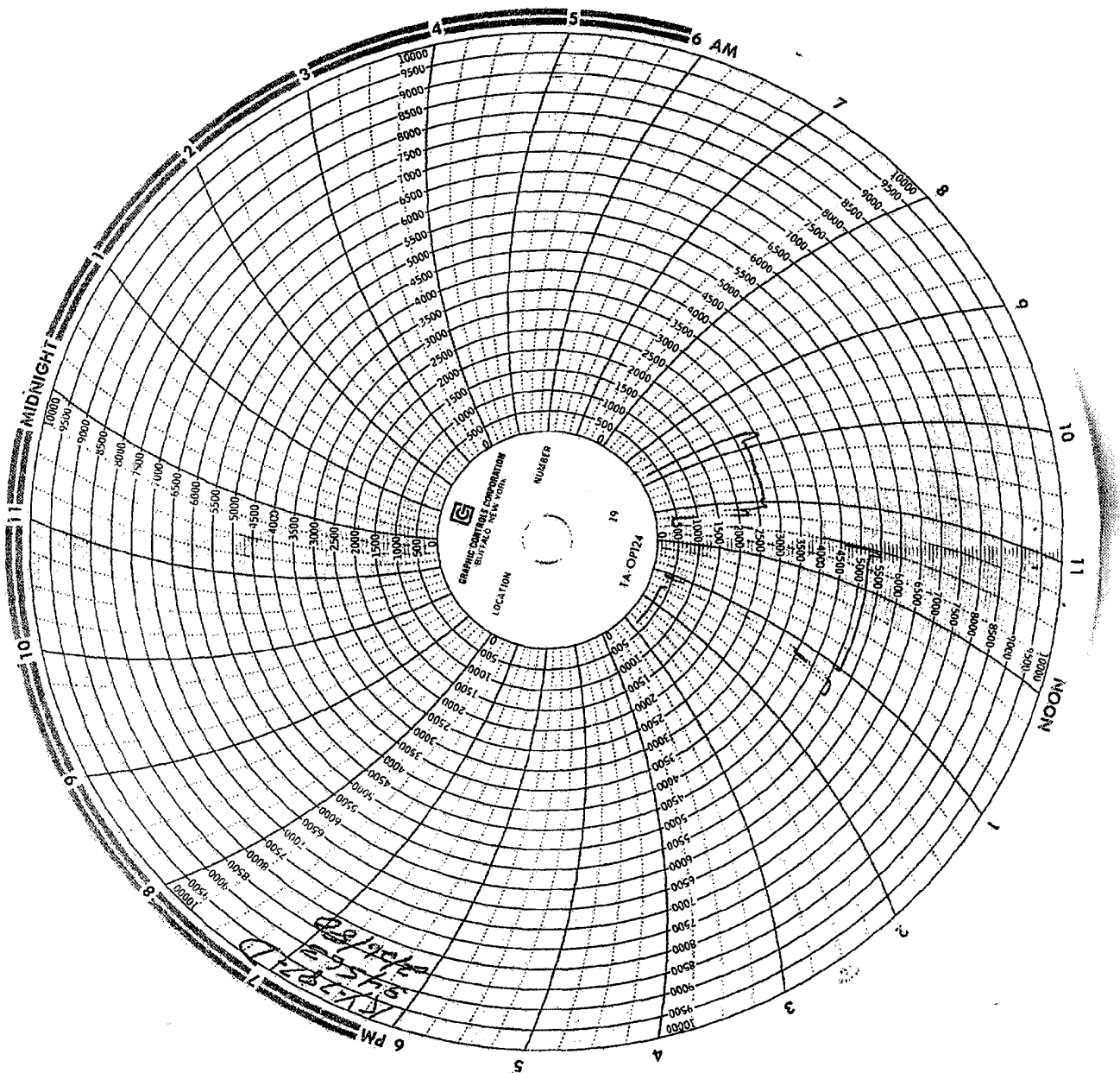
Total Wgt. 3390 # Req()

NON-BLEEDING

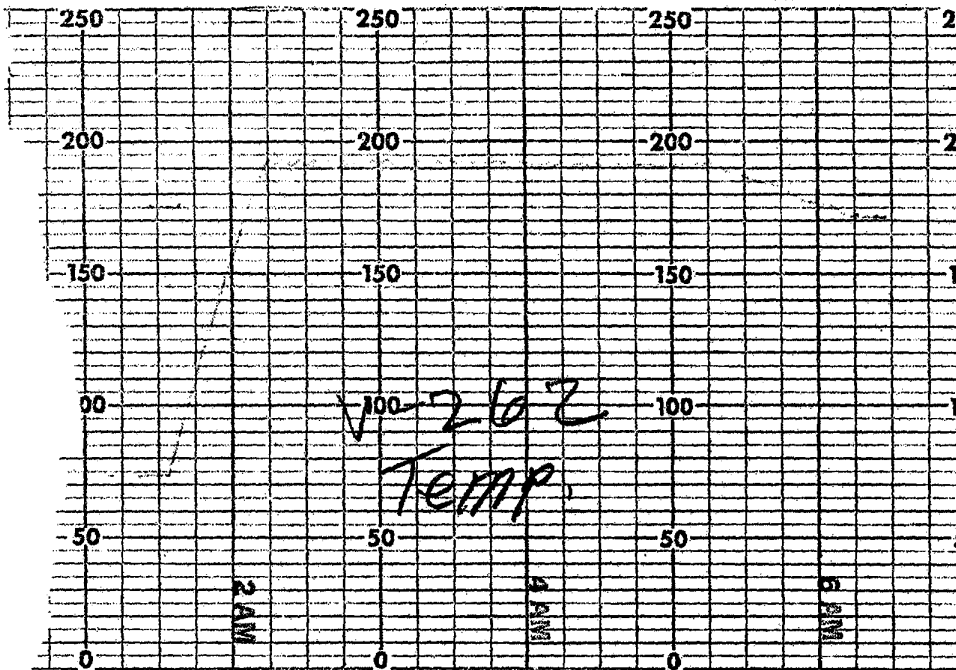
EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	"KROLOR" YELLOW-MEDIUM 1 Run 33" (560 G) water into V-203. Set agitator on high speed. 2 Weigh in drum & pour in 3 Dump in & stir 5 min Record: Start 8:10 AM 400 Fin 7:15 AM 2000 75" (12756) 4 Adj to 70" (1200 G) 2400 - 2600 5 Pump V-203 thru Homog # 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. 60 " & adj to 60" (2100 G) 8 Inspect Homog strainer & clean if Necessary 9 During homogs, run V-203 agitator on low speed.	320 48 x 50 24064 24170	32-D YC-2-B	320 2400
SV & 205 2	9 Run 5" (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 11:30 AM Total Min 90 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 110-120F 14 Weigh into V-384 & Pump to V-349 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 1.081 (1.095 ± 0.2) (1.077 - 1.082)	1840	32-D	1840
SV 4	18 When S 18 Homog complete, Adj SV to 25 " (2470 G) 19 Record: pH 10.4 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 Parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.1 20 Heat to 190-194 F in 55-65 min & Record: HT 186F & Rec 192F Note: Strike must be started immediately on completion of heating	18	7-D	9
343 & 386 5	21 While heating SV, run 39" (1070 G) water into V-343 22 Meter in from V-386 M 17, 9.11 #/Gal 29.7 Gal 23 Stir 15 min or longer 24 Record: Be 1.018 (2.8 ± 0.1) (1.017 - 1.018) g/mL		27-D	275

V-262

EQUIPMENT	PAGE 2	CG03	CODE KY-787-D (R)	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete Record: pH <u>10.05</u> (9.5-10.0)						
	26	Set V-343 acid pump at 82 setting (± 150 min)						
	27	Set V-349 silicate pump at 72 setting (± 120 min)						
	28	Immediately meter in V-343 & 349, Maintain SV at 190-193F during strike						
	29	Record: Start Finish Minutes						
		V-343	<u>4:30</u>	<u>7:20P</u>	<u>170</u>			
		V-349	<u>4:10</u>	<u>6:35P</u>	<u>125</u>			
		Record:	Time	V-343	V-349	SV	Normal	
				in	in	pH	pH	
		at 20 min	<u>4:50</u>	(35)+	(14)+	<u>9.9</u>	9.3-10.0	
		40 min	<u>5:10</u>	(30)31	(11)	<u>9.9</u>	9.3-10.0	
		1 hr	<u>5:30</u>	(24)25+	(9)	<u>9.9</u>	9.3-10.0	
		2 hrs	<u>6:30</u>	(8)11-	(0)+	<u>9.9</u>	9.3-10.0	
		Finish	<u>7:20</u>	0		<u>7.5</u>	7.5-8.5	
		Note: If pH drops below 9.0 in 1st hr, stop pumps & see Supv.						
		If final pH is above 8.5 adj to 7.5-8.5 & Record: pH						
		Assume 77 %						
							27-D	
330	30	Run 20" (392 G) water into V-330 & heat to 80-100 °F						
7	31	Add in 7-8 min						
	32	Stir 5 min & Record: pH <u>10.1</u> (9.5-10.5)						
	33	Stir 20 min or longer to dissolve for S 46						
357	34	Run 11" (80 G) water into V-357 & heat to 135-140 °F						
8	35	Dump in & stir to dissolve for S-42						
						160	15-A	160
302	36	Run 30" (360 G) water into V-302						
9	37	Add & stir 2 min for S44						
					Assume 50%	180	7-D	90
SV 10	38	When V-349 MTY, Rinse in with minimum water then set pump to zero setting						
	39	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	40	Turn off steam						
	41	Sift in 2 bags						
	42	Run in V-357 from S 35 & stir 5 min						
	43	Record: pH <u>3.5</u> (3.7-4.2)						
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
	45	Record: pH <u>9.5</u> (9.0-9.5) & if necessary adj to pH 9.0-9.5						
		& Record: pH						
		(Dilute 10 parts water to 1 part N-7-D)						
		Siphon N-7 into SV						
	46	Run in V-330 thru 20 mesh screen & stir 20 min						
313	47	Run 10" (128 G) water into V-313 & dump in						
11	48	Stir 5 min to dissolve for S 49						
						135	20-A	135
SV 12	49	Run V-313 into SV in 15-20 min						
	50	Stir 15 min						
	51	Record: pH <u>9.45</u> (9.0-10.0)						
	52	Stop agitator <u>Do not stop V-262</u>						
		START	FINISH	OPTR				
		<u>7:00 AM</u>	<u>3:00 PM</u>	<u>144</u>				
		<u>3100 P</u>	<u>8:40 PM</u>	<u>235</u>				
		Step	V-262 (20 RPM) V-243, 244, 246, 247					
		9	5"	10"				
		18	25"	48"				



4-262



GRAP