14 1980

8 [illegible]
14 [illegible]
10 [illegible]
20 [illegible]
30 [illegible]

← DO NOT ERASE

MAKING INSTRUCTIONS BATCH UNIT

S.V. 246 (247) C.V. D.V.

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

CG 04 CODE KO-786-D
18 [illegible]

PUNCHED & CHECKED
APR 23 1980

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 7 A M

01 YC-10-B 93 4 35018 500#
01 YC-10-B 93 4 33920 1750#
01 YC-10-B 93 4 34713 1850#

Homog #2

APR 1980

Total Weight 4962# (Req. [illegible])

NON-BLEEDING

EQUIPMENT		NAME "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run 50" (990 G) water in V-211 and add Assume 50%	30	7-D	15
	2	Weigh in drum and pour in V-211	270	32-D	270
	3	Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
		Record: Start 7:30 P.M.			
		Fin 10:30 P.M.			
		30" (1020 G)			
	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			
		Turning Homog Run V-211 Agitator on low speed			
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 2:40 PM Total Minutes 145			
		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	✓2400	32-D	2400
	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: ~~°Be~~ 1.078 ~~(10.9 ±0.2)~~ (1.078 - 1.081) g/ml			
SV 4	18	When S 11 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%		7-D	
		Siphon N-7-D into SV and Record: pH			
	20	Heat to 190-194°F in 55-65 minutes & Record: HT 187 F and Rec 104 F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 51" (1400 G) water into V-343			
	22	Meter in from V-386 M 29 #/Gal 9.12 Gal 38.9		27-D	355
	23	Stir 15 minutes or longer			
	24	Record: ~~°Be~~ 1.017 ~~(2.8 ±0.1)~~ (1.017 - 1.019) g/ml			

WATER AND COLOR IN V-22-D + N-7-D TO 90

N32488

V-247

EQUIPMENT		PAGE 2 CG 04 CODE KO-786-D (1) EST WGT 4962 LBS	USE LBS	R CODE	ACC 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 (±225 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 7:30			
		V-349 10:35P 185			

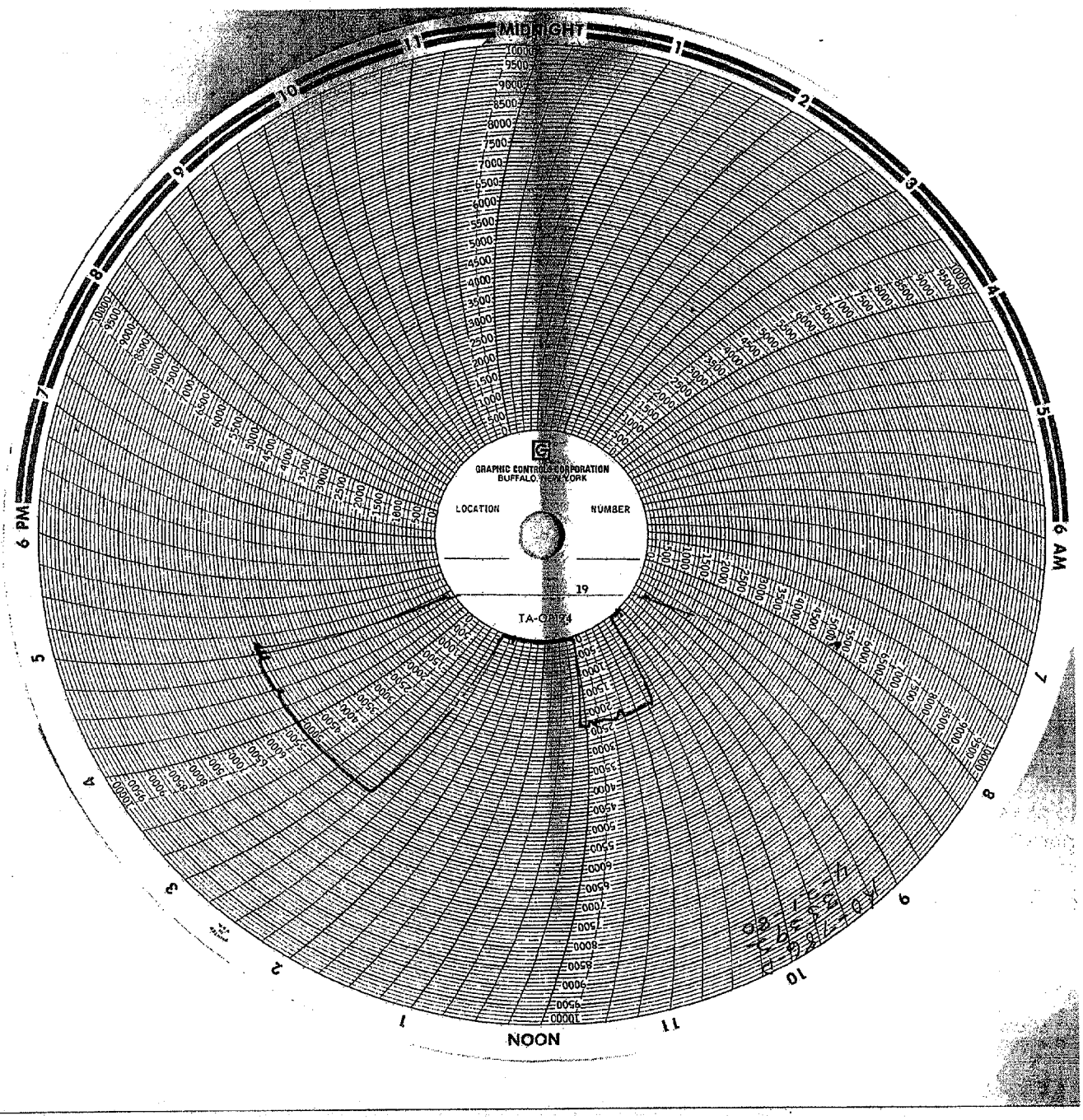
Record:	Time	V-343	V-349	SV pH	Normal pH
	7:30	53 inches	22 inches		
at 20 min	7:50	(47) 48+	(20)	9.6	9.3-10.0
40 min	8:10	(43) 44+	(17) +	9.6	9.3-10.0
1 hr	8:30	(38) 39+	(15) +	9.6	9.3-10.0
2 hrs	9:30	(24) 27-	(7) 8	9.6	9.3-10.0
3 hrs	10:30	(10) 12+	(0) +	9.65	9.3-10.0
Finish	11:25	(0) —	—	7.0	7.5-8.5

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 _____

EQUIPMENT			USE LBS	R CODE	ACC LBS
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 3.0 (3.3-3.7)			
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH _____		15-A	
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes			
	41	Record: pH 4.1 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH _____ Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV			
	42	Stop agitator			

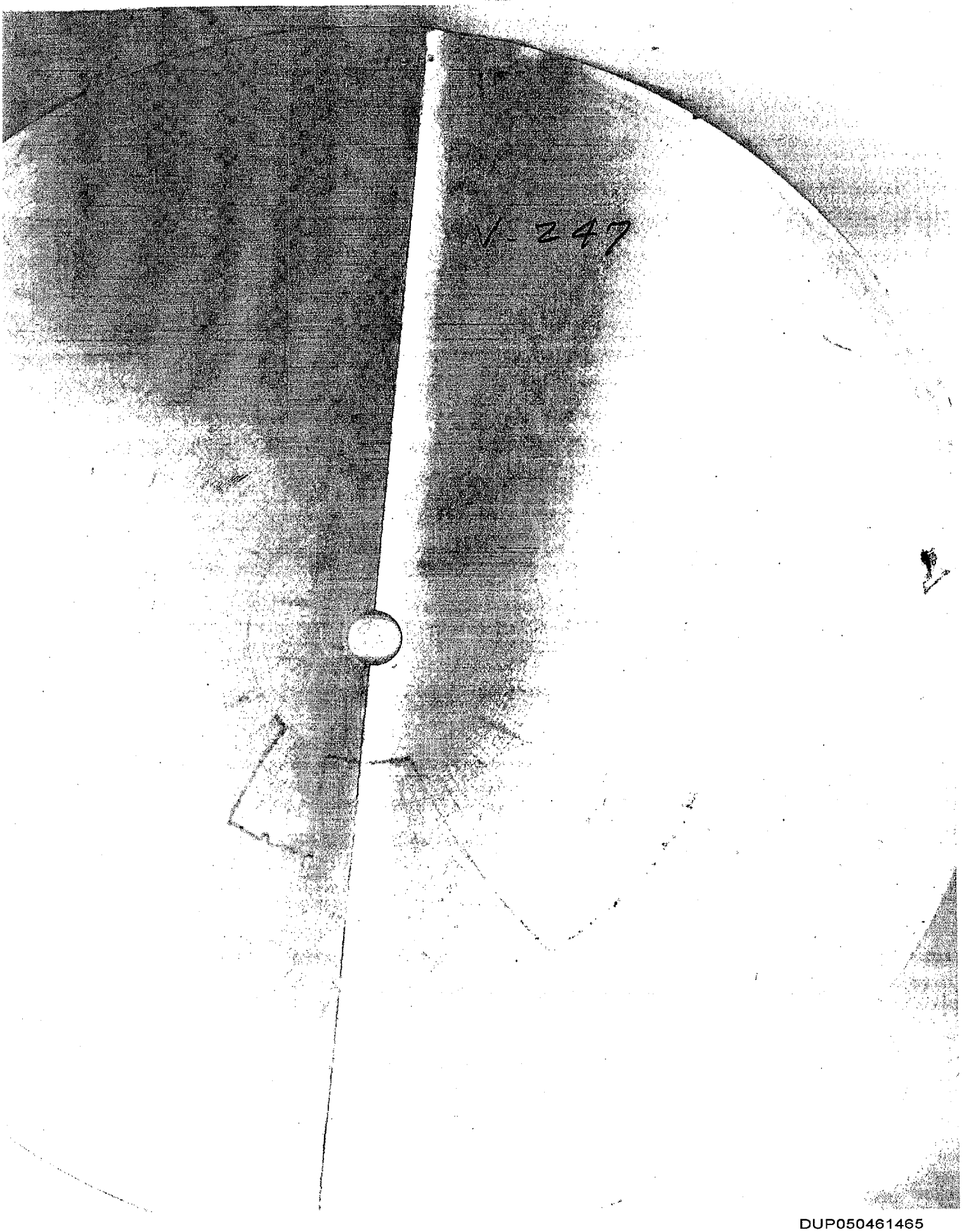
START	FINISH	OPTR
11:30 A.M.	3 P.M.	54-201
3:00 P	11:00 P	235-144
11 PM		282-438

DUP050461463



N32488.01

DUP050461464



DUP050461465