DEC 28 1979

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 246 C.V. D.V.

ØG 04 CODE KO-786-D PKG. _____

JAN-2 33575

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 7 A M

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

OK FP

01 YC-10-B 93 4 33362, 1850#
01 YC-10-B 93 4 33351, 1200#
01 YC-10-B 93 4 33355, 1050#

JW Homog #2

Total Weight 4962# (Req. 0508)

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%	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 8:15 A.M. 33362	1850		
		Fin 10:A.M. 33351	1200		
		75" (1275G) 33355	1050		
	4	Adjust to ~~80" (1370 G)~~	4100		
	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 38 " and adjust to 50" (1840 G)			
	8	Inspect homog strainer and clean if necessary			
208 & SV 2	9	Run 15" (771 G) water into V-246 and start agitator and install temperature chart			
	10	Pump V-208 thru Homog at 4800-5200 psi into SV			
		Record: Time Start 9:10 AM 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'~~ 1.079 (~~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 10.8 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 192 F and Rec 199 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 1 #/Gal 9.70 Gal 36.6 71.41 497		27-D	355
	23	Stir 15 minutes or longer			
	24	Record: ~~°Be'~~ 1.018 (~~2.8 ±0.1~~) 1.017 - 1.019 g/mL			

SG

V-246

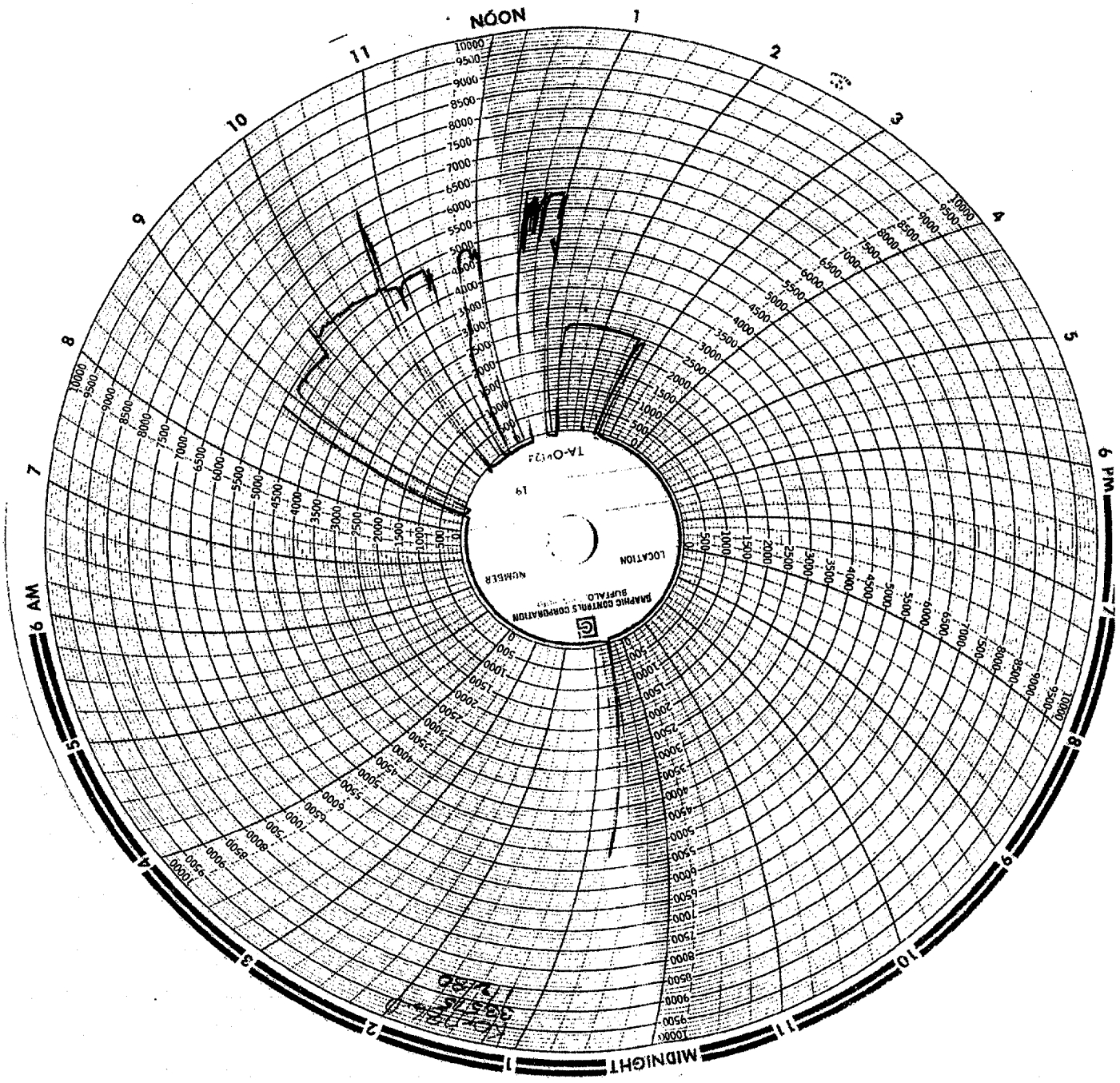
EQUIPMENT		PAGE 2 CG 04 CODE K0-786-D (R) EST. WGT. 4962 LBS.	USE LBS.	N CODE	A... L...
SV 6	25	When S 20 heating complete, Record: pH 7.6 (9.6-10.2)			
	26	Set V-343 acid pump at 72 setting (±225 minutes)			
	27	Set V-349 silicate pump at 66 setting (±180 minutes)			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike			
	29	Record: Start / Finish / Minutes V-343: 1:35 PM / 5:30 P / 235 V-349: 1:35 PM / 4:40 P / 185			

Record:	Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
at 20 min	1:55 PM	(47) 47	(20) 20	9.6	9.3-10.0
40 min	2:15	(43) 43	(17) 17	9.6	9.3-10.0
1 hr	2:35	(38) 39	(15) 15	9.6	9.3-10.0
2 hrs	3:35	(24) 26+	(7) 8	9.75	9.3-10.0
3 hrs	4:35	(10) 12	(0)	9.8	9.3-10.0
Finish	5:20 PM	(0)		6.5	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~~ DRUMS	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 3.2 (3.3-3.7)			
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH ~~in~~		15-A	
	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 ____ 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
3:00 P	11:00 P	235-301
7:00 AM	3:00 PM	320-414
3:00 P	6:15 PM	235-259

DUP050095114



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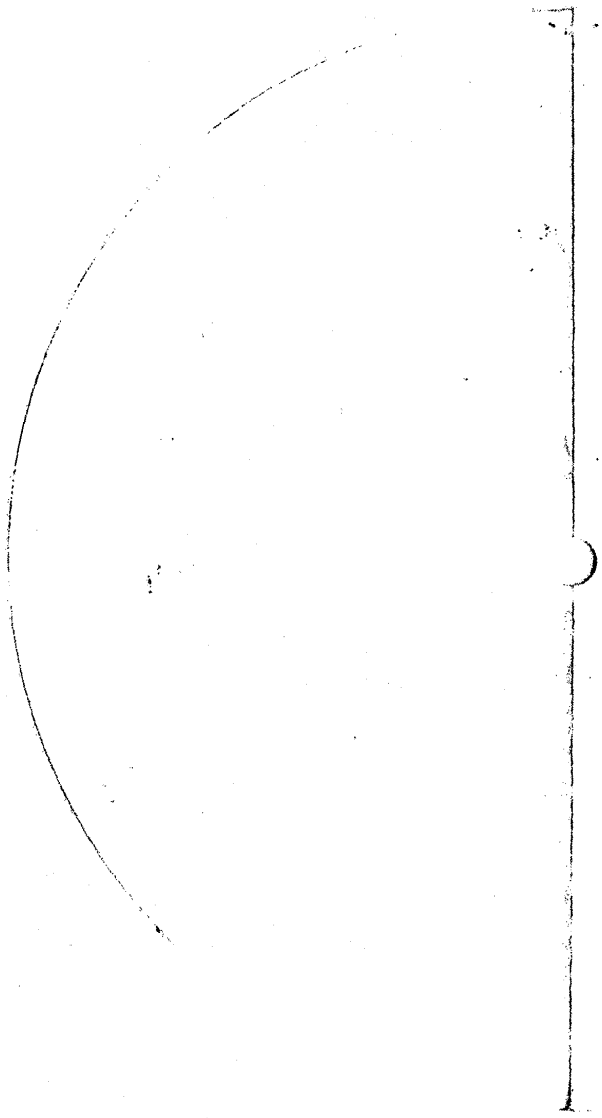

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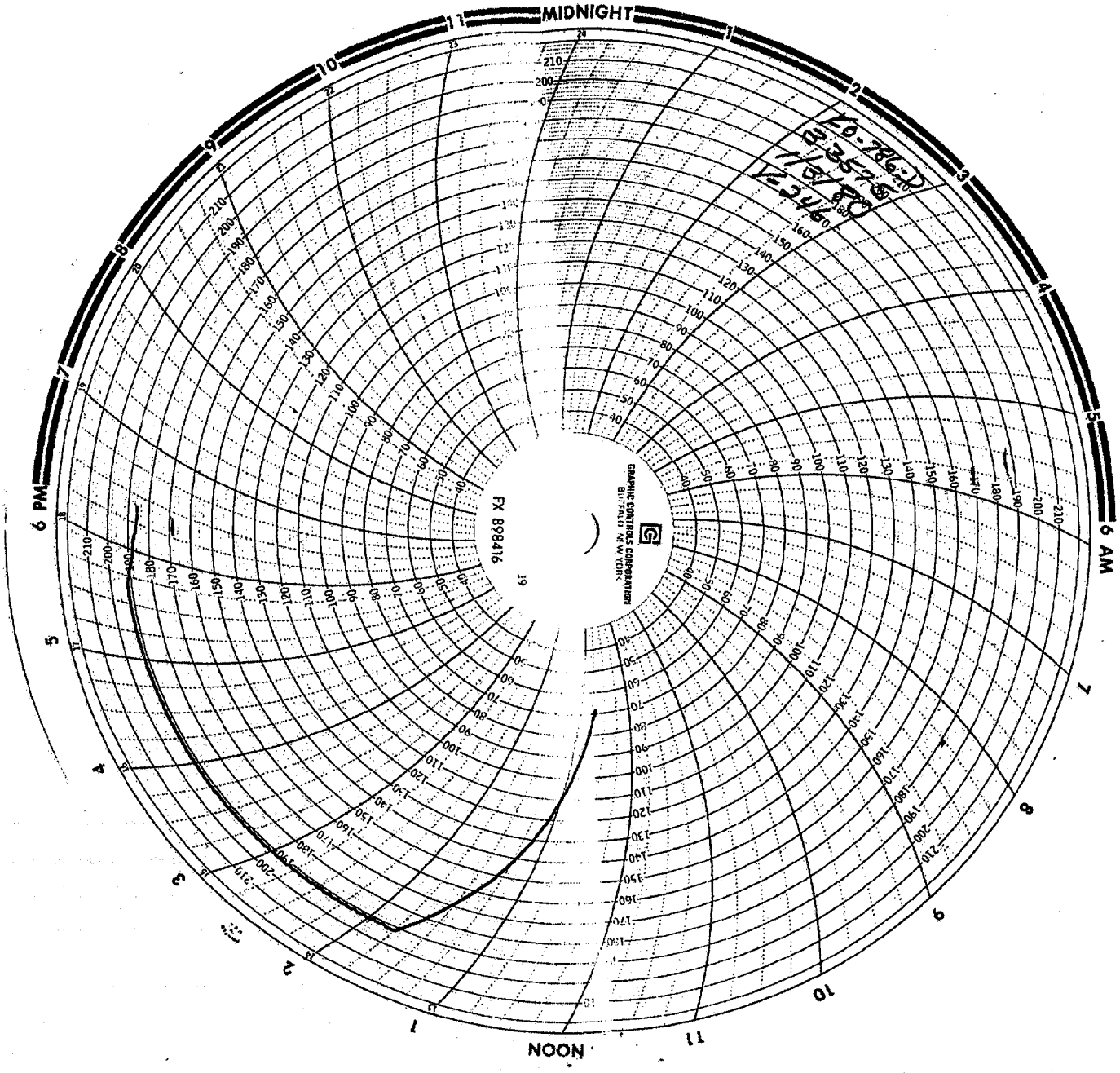

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