

APR 14 1980

APR 21 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V.

C.V.

D.V.

06 04 CODE KO-786-D PKG.

APR 18 35395

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 7 P.M.

01 YC-10-B 93 4 33479 150#
 01 YC-10-B 93 4 35019 300#
 01 YC-10-B 93 4 35018 500#

01 YC-10-B 93 34410 1700#
 01 YC-10-B 93 34717 1450#

Total Weight 4962# (Req.)

Homog #2

NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
211 & 208	Run 80" (990 G) water in V-211 and add. Assume 50% Weigh in drum and pour in V-211 Dump in and stir 5 minutes Record: Start 12:45 Am 33479 Fin 2:08 Am 35019 75" (1275 G) 35018 Adjust to 80" (1370 G) 34410 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water Record: V-208 Vol 4" and adjust to 50" (1840 G) Inspect homog strainer and clean if necessary DRAINING HOMOG, RUN V-211 AGITATOR ON LOW-SPEED	30 270 82 x 50 120 300 500 1700 1450	7-D 32-D YC-10-B 11 11 11 11	15 270 4100
208 & SV 2	Run 15" (771 G) water into V-208 and start agitator and install temperature chart Pump V-208 thru Homog at 4800-5200 psi into SV Record: Time Start 7:00 AM Total Minutes 14.5 Note: If homog pressure falls below 4800 psi, 3-Way valve will recirculate slurry to V-208 When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384 3	While Homog, run 6" (284 G) water into V-349 Run 1000# water into V-384 and heat to 110-120°F Weigh into V-384 and pump to V-349 Run 1000# water into V-384 and pump to V-349 Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer Record: 1.081 (10.0-0.2) (1.078-1.081) 8/m.e.	2400	32-D	2400
SV 4	When S 11 Homog complete, adjust to 66" (3400 G) in SV 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% Siphon N-7-D into SV and Record: pH Heat to 190-194°F in 55-65 minutes & Record: HT 192°F and Rec 192°F Note: Strike must be started immediately on completion of heating		7-D	
343 & 386 5	While heating SV, run 51" (1400 G) water into V-343 Meter in from V-386 M 29 #/Gal 9.12 Gal 38.9 Stir 15 minutes or longer Record: 1.018 (2.8-0.1) (1.017-1.019) 8/m.e.		27-D	355

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EQUIPMENT	PAGE	2	CG 04	CODE	K0-786-D (H)	EST. WGT.	4962	LBS.	USE	N	ACCT.
									LBS.	CODE	LBS.
SV 6	25	When S 20 heating complete, Record: pH 9.8 (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				240				
			V-349				190				
		Record:	Time	V-343	V-349	SV	Normal				
				5.3 inches	2.2 inches	pH	pH				
		at 20 min	12:14 PM	(47)	(20)	9.9	9.3-10.0			Cut-N-32	
		40 min	1:05 PM	(43) 44	(17)	9.8	9.3-10.0			← TO 65	
		1 hr	1:25 PM	(38) 39+	(15) 15	9.8	9.3-10.0				
		2 hrs	2:25 PM	(24) 28-	(7) 7	9.9	9.3-10.0				
		3 hrs	3:25 PM	(10) 17	(0) 7	10.0	9.3-10.0				
		Finish	4:10 PM	(0) 0	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	
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									
								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 3.1 (3.3-3.7)									
	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 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							
		7:00 AM	3:00 PM	235-32							
		3:00 PM	6:10 PM	301-381							

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