

MAKING INSTRUCTIONS: BATCH UNIT

V. 246, (247)

C.V.

D.V.

OG 04 CODE KO-786-D PKG.

L DEC 22 33459

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

01 YC-10-B 93 4 33063

01 YC-10-B 93 4 32901

01 YC-10-B 93 4 32903

550

1050

1400

YC-10-B, 33051, 1100

PROCESSES		APPROVED BY
() KO-786-D	(P)	EWK 9-21-76
()	()	DCG 9-21-76
()	()	MTW 10-1-76
TYPED BY		
116-11-16-76		

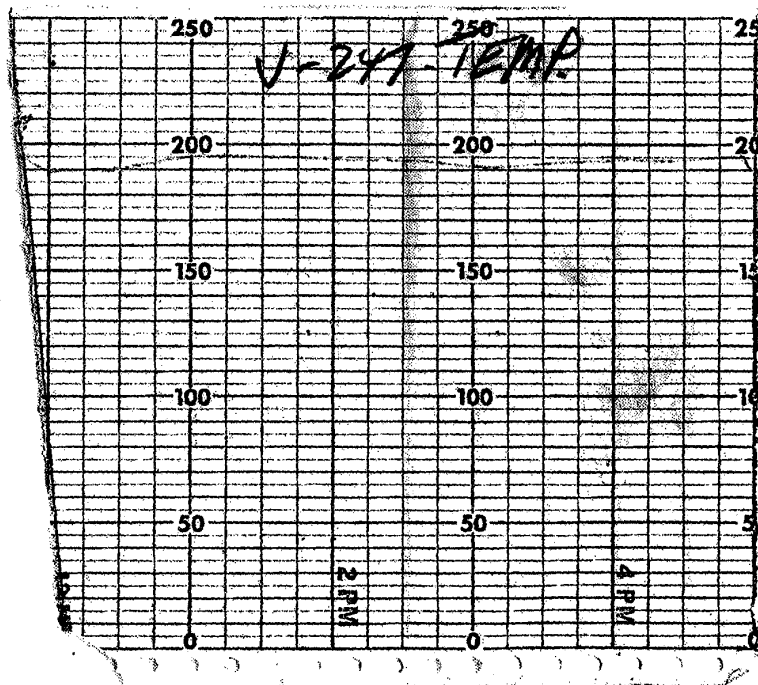
Total Weight 4962# (Req. _____)

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	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
208	3 Dump in and stir 5 minutes	82 x 50	YC-10-B	4100
1	Record: Start 3:30 P.M. 33063	550		
	Fin 3:44 P.M. 32901	1050		
	25" (1275 G) 32903	1400		
	Adjust to 30" (1370 G) 33051	1100		
	4 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	5 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-208 Vol 43 " and adjust to 50" (1840 G)			
	8 Inspect homog strainer and clean if necessary			
208	9 Run 15" (771 G) water into V-247 and start agitator and			
&	install temperature chart			
SV	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start 7:20 A 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	12 While Homog, run 6" (284 G) water into V-349			
&	13 Run ±1000# water into V-384 and heat to 110-120°F			
384	14 Weigh into V-384 and pump to V-349	2400	32-D	2400
3	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: Sp 1.080 (10.9 ± 0.2) 1.078-1.081			
	6/mL			
SV	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	19 Record: pH 11.8 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 194 F and Rec 125 F			
	Note: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 51" (1400 G) water into V-343			
&	22 Meter in from V-386 M 3.3 #/Gal 9.85 Gal 355.9		27-D	355
386	23 Stir 15 minutes or longer			
5	24 Record: Sp 1.018 (2.8 ± 0.1) 1.017-1.019			
	6/mL			

V-247

EQUIPMENT	PAGE	CG	04	CODE	K0-786-D (K)	EST. WGT.	4962	LBS.	USE LBS.	N CODE	ACCY. LBS.
SV 6	25	When S. 20 heating complete. Record: pH 9.9 (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 1:25 4:10 PM 235									
		V-349 1:25 3:20 PM 185									
	Record:	Time V-343 V-349 SV Normal									
		at 20 min 2:05 (47) + (20) 9.75 9.3-10.0									
		40 min 12:05 (43) + (17) + 9.8 9.3-10.0									
		1 hr 1:15 PM (38) 39 (15) 9.8 9.3-10.0									
		2 hrs 5:15 PM (24) 25 + (7) 8- 9.8 9.3-10.0									
		3 hrs 3:15 PM (10) 1 + (0) 0 9.7 9.3-10.0									
		Finish 4:00 PM (0) 0 0 0 8.1 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 3.6 (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									
12-23		7:00 A 3:00 PM 235									
12-26		7:00 A 3:00 P 235									
		3: PM 5:30 PM 223									



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