MAKING INSTRUCTIONS: BATCH UNIT

.V. ~~243, 244, 246, 247~~, 262 C.V. D.V.

CG 03 CODE KY-795-D PKG.

→ MAR-6 34738

EST. WGT. ~~1178~~ 1228 LBS.

STD. HRS. 11.1 TIME 7 P M

PUNCHED & CHECKED

MAR 12 1980 OK

PROCESSES		APPROVED BY
( ) KY-795-D	(I)	EWK 10/5/76
( ) ALTERNATE	( )	DCG 10/7/76
( )	( )	MTW 10/11/76
( )	( )	
TYPED BY		
NE 3/3/77		

14 YC-2-B 93 4 Lot 24474, 2000
14 YC-2-B 93 4 Lot 24477, 1650
14 YC-2-B 93 4 Lot _____, _____

Homog # 3 - 1st Pass
" # 4 - 2nd "

Total Wgt. 4878#

NON-BLEEDING

QUIPMENT		NAME: 60" (990G) "KROLOR" YELLOW - MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203	1	Run ~~26" (418 G)~~ water in V-203. SET AGITATOR ON HIGH SPEED			
&	2	Weigh in drum & pour in	500	32-D	500
205	3	Dump in & stir 5 min Lot 73	~~74~~x50	YC-2-B	~~3700~~
1		Record: Start 7:P.M. 24474	2000		3650
		Fin 9:P.M. 24477	1650		
		75" (1275G)	3650		
	4	Adj to ~~78" (1328 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 42" & adj to 51" (1874 G)			
	8	Inspect homog. strainer & clean if necessary			
		DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
SV	9	Run 5 "(514 G) water into V- 262 install temp charts & start agitator			
&	10	Pump V-205 thru Homog at 4800-5200 psi into SV			
205		Record: Time Start 5:35A Total Min 150			
2		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	12	While Homog, run 6" (284 G) water into V-349			
&	13	Run ± 1000# water into V-384 & heat to 110-120°F			
384	14	Weigh into V-384 & pump to V-349	2830	32-D	2830
3	15	Run ±1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 29" (1372 G) & stir 15 min or longer			
	17	Record: Be' 1.072 g/mL ~~(9.85 ± 0.2)~~ (1.070 - 1.073)			
SV	18	When S 11/Homog complete, adj. to 25 " (3495 G)			
4	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%	50	7-D	15
		Siphon into SV & Record: pH 11.3			
	20	Heat to 190-194°F in 55-65 min & Record: HT 192 °F & Rec 192 °F			
		Note: Strike must be started immediately on completion of heating			
343	21	While heating SV, run 69" (1898 G) water into V-343			
&	22	Meter in from V-386 M 20, 9.19 #/Gal 45.3 Gal		27-D	416
386	23	Stir 15 min or longer			
5	24	Record: Be' 1.014 g/mL ~~(2.3 ± 0.1)~~ (1.014-1.015)			
SV	25	When S 20/heating complete Record: pH 10.0 (9.5-10.0)			
6	26	Set V-343 acid pump at 96 setting (±225 min)			
	27	Set V-349 Silicate pump at 82 setting (± 180 min)			
	28	Immediately meter in V-343 & V-349. Maintain SV at			

13829 REV.

DUP05009366S

V-262

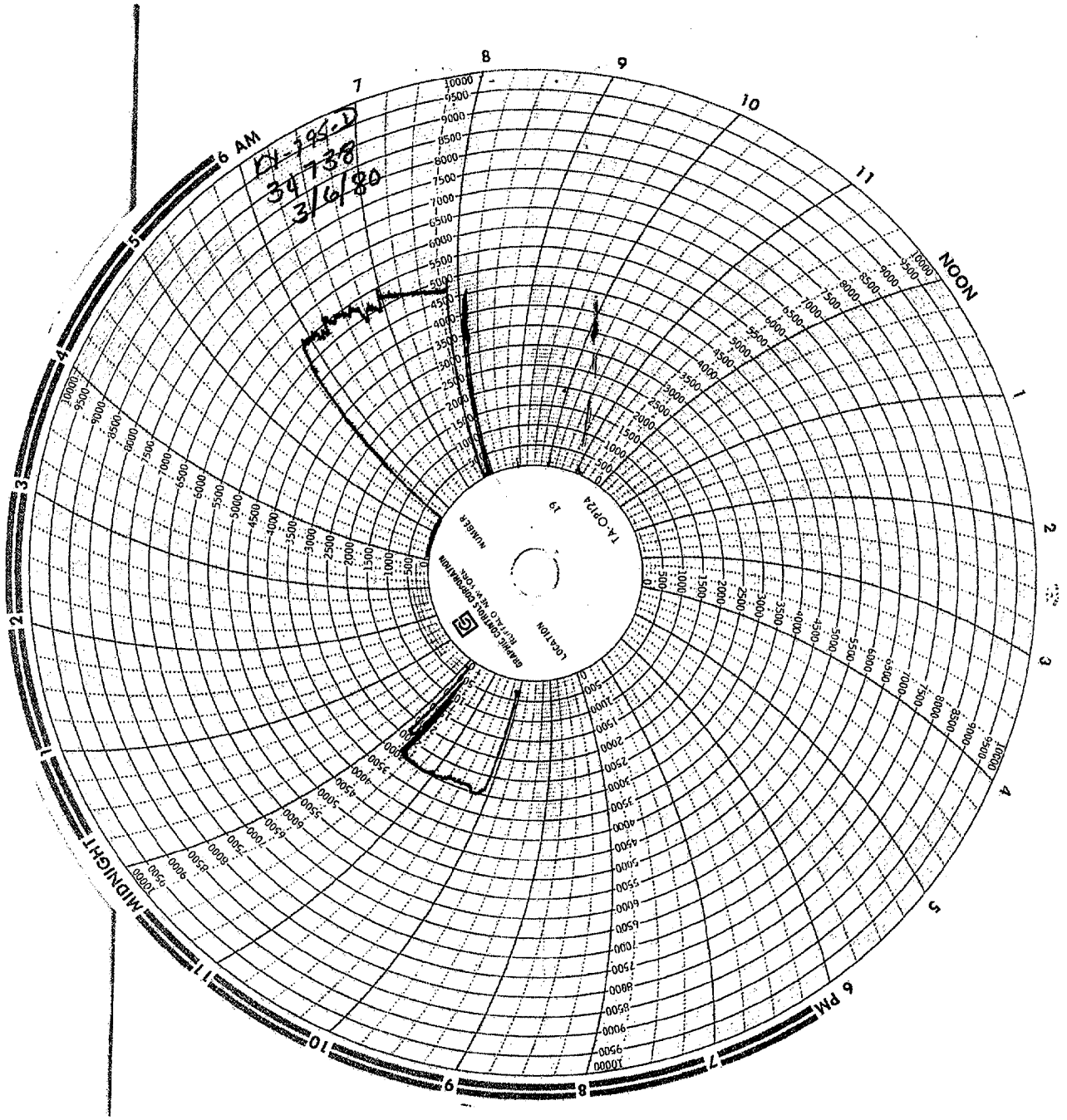
EQUIPMENT		PAGE 2 CG 03 CODE KY-795-D(I) ALT TEST. WGT. 4878 LBS.	USE DES.	NEXT CODE	ACCT. LBS.
SV 6 Cont.	29	Record: Start Finish Minutes			
		V-343 12:15 Pm 5:40 PM 325			
		V-349 12:15 Pm 4:30 PM 255			
		Record: Time V-343 in V-349 in SV pH Normal pH			
		at 20 min 12:35 Pm (64) (26) 9.8 9.0-10.0			
		40 mins 12:55 Pm (58) (23) 9.8 9.0-10.0			
		1 hr 1:15 Pm (51) (19) 9.8 9.0-10.0			
		2 hrs 3:15 Pm (33) 46 (10) 13 10.0 9.0-10.0			
		3 hrs 4:15 Pm (14) 26 (0) 3 10.0 9.0-10.0			
		Finish 5:1 Pm (0) 12 — 8.0 7.5-8.5			
		Note: If pH drops below 9.0 in 1st. hr. stop pumps & see Supv. If pH. above 8.5 at final adj to 7.5-8.5			
		Record: pH Assume 77%		27-D	
357 7	30	Run 15" (108 G) water into V-357 & heat to 135-140°F			
	31	Dump in & stir to dissolve for S 38	220	15-A	220
Drum 8	32	Weigh into 55 Gal Drum Assume 50%	60	7-D	30
	33	Fill with water & stir 2 min for S 40			
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	~~300~~		~~200~~
	37	Sift in ~~3 bags~~	~~150~~	128-A	~~150~~
	38	Run in V-357 from S 31 & stir 5 min			
	39	Record: pH 3.4 (3.3-3.7) & if necessary adj (down only) to 3.3-3.7 & Record: pH		15-A	
		Note: Dissolve extra N-15-A in water at 135-140°F in drum. Use ± 40 Gal water to 50# N-15-A. Stir SV 5 min after each addition.			
	40	Siphon in N-7-D from S 33 in 4-6 min & stir 5 min			
	41	Record: pH 3.7 (4.0-4.2) & if necessary adj to pH 4.0-4.2 & Record: pH 4.0 Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	10	7-D	5
		Siphon N-7-D into SV			
	42	Pour in & Stir 15 min	45	978-A	45
	43	Stop agitator			

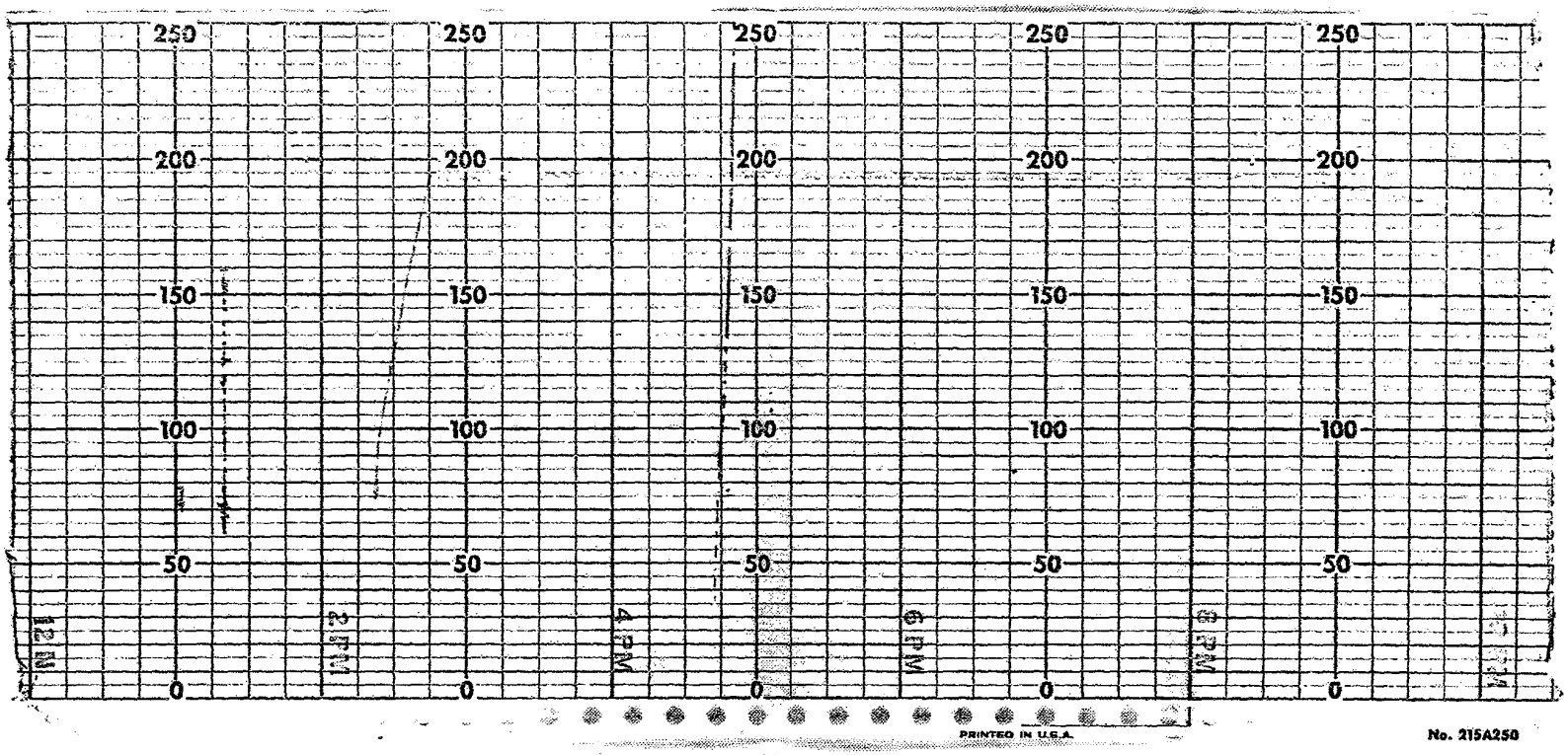
Start	Fin	Optr
11:00 P	7:00 AM	235-373
3:00 PM	7:00 PM	145-237

Step	V-262 (20 RPM)	V-243, 244, 247
9	5"	10"
18	35"	68"

STRIKE STARTED 1:20 PM DUE TO ACID

STRIKE STARTED AGAIN AT 2:20 PM


DI-194-D
34738
3/6/80
6 AM
NOON
6 PM
MIDNIGHT
TA-OP12A
LOCATION
NUMBER
GRAPHIC CONTROLS CORPORATION
BUFFALO 42, N.Y. U.S.A.



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