

MAKING INSTRUCTIONS: BATCH UNIT

V. 246, 247

C.V.

D.V.

OG 04 CODE KO-786-D PKG.

DEC 29 33570

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 7A M

01 YC-10-B 93 4 33358 1000#
01 YC-10-B 93 4 33355 1200#
01 YC-10-B 93 4 33362 1900#

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			

Total Weight 4962# (Req. 0505)

NON-BLEEDING

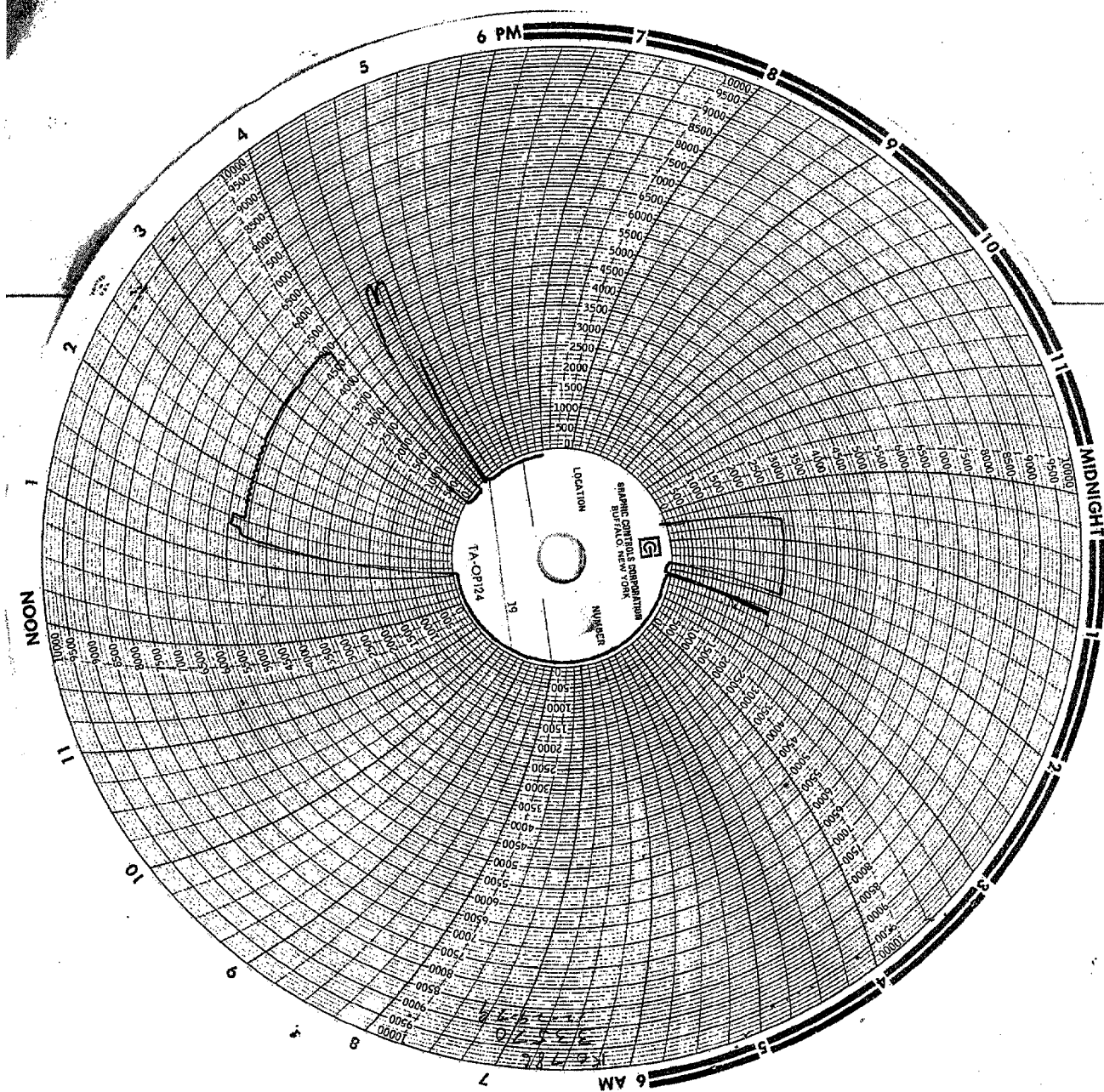
EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1 Run 60" (990 G) water in V-211 and add Assume 50%	30	7-D	15
	2 Weigh in drum and pour in V-211	270	32-D	270
	3 Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
	Record: Start 9:30 A.M. 33358	1000		
	Fin 11: A.M. 33355	1200		
	75" (12756) 33362	1900		
	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 50" 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 11:30 Total Minutes 190			
	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" 1.081 (10.9 ±0.2) 1.078-1.081			
SV 4	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
	19 Record: pH 10.5 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 186 F and Rec 190 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 83 #/Gal 9.88 Gal 35.9		27-D	355
	23 Stir 15 minutes or longer			
	24 Record: "Be" 1.017 (2.8 ±0.1) 1.017-1.019			

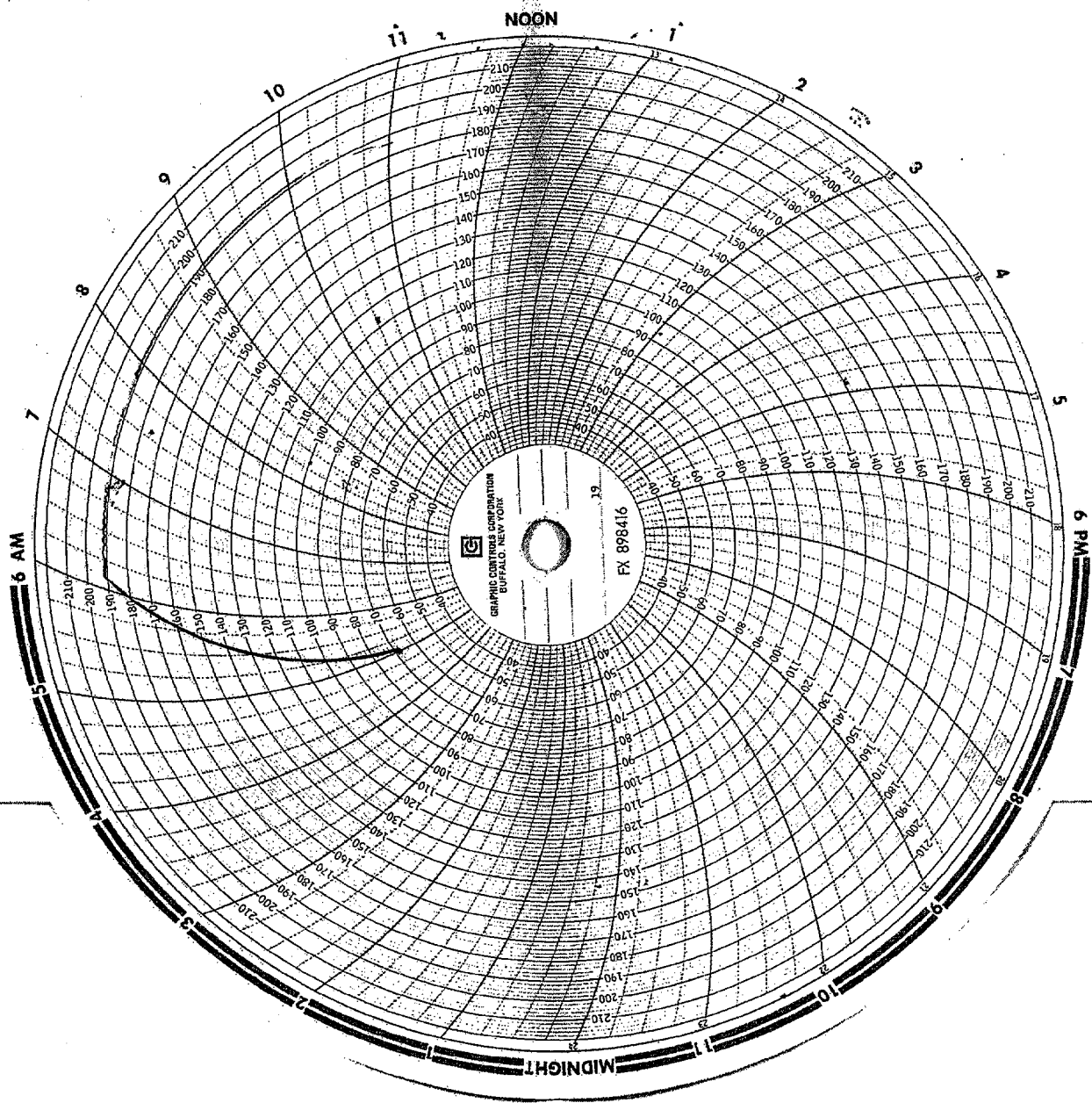
9/ml

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EQUIPMENT	PAGE	CG 04	CODE	K0-786-D (M)	EST WGT.	4962	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete. Record: pH 9.6 (9.6-10.2)								
	26	Set V-343 acid pump at 72 setting (± 25 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	6:00 AM	10:00 AM	240				
			V-349	6:00 AM	9:10 AM	190				
		Record:	Time	V-343	V-349	SV	Normal			
				Inches	Inches	pH	pH			
		at 20 min	6:20	(47) 48	(20) 21	9.5	9.3-10.0			
		40 min	6:40	(43) 44	(17) 18+	9.5	9.3-10.0			
		1 hr	7:00	(38) 39	(15) 16+	9.5	9.3-10.0			
		2 hrs	8:00	(24) 26	(7) 7	9.6	9.3-10.0			
		3 hrs	9:00	(10) 14	(0) 1	9.6	9.3-10.0			
		Finish	9:45	(0) 0	0	7.8	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
		Assume 50%								
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 3.3 (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								15-A
	41	Record: pH 4.0 (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%								27-D
										7-D
		Siphon N-7-D into SV								
	42	Stop agitator								
		START	FINISH	OPTR						
		11:30 AM	2:00 PM	126						
		7:00 AM	11:00 AM	244-37						







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