S.V. 243, 244, 246, 247, 262 C.V. MAR - 31980 D.V.

CG 03 CODE KY-787-D PKG.

→ FEB 29 34630

EST. WGT. 1090 990 LBS.

STD. HRS. 10.6 TIME 7P M

14 YC-2-B 93 4 Lot 24066, 2000 #

14 YC-2-B 93 4 Lot 24480, 400 #

14 YC-2-B 93 4 Lot _____, _____ #

3390

Total Wgt. 3490# Req( )

OK FP F3 Homog 1st PASS

PROCESSES		APPROVED BY
( ) KY-787-D	(R)	
( ) Alternate	( )	
( )	( )	EWK 9/22/76
( )	( )	DCG 9/22/76
TYPED BY		MTW 9/30/76
NE 2/12/77		

NON-BLEEDING

EQUIPMENT		NAME: "KROLOR" YELLOW-MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & ~~205~~ 1	1	Run ~~39" (560 G)~~ water into V-203. SET AGITATOR ON HIGH SPEED			
	2	Weigh in drum & pour in	320	32-D	320
	3	Dump in & stir 5 min Lot	48 x 50	YC-2-B	2400
		Record: Start 11.00 24066 2000			
		Fin 12.00 24480 400			
V-263		75" (1275 G)	2400		
	4	Adj to ~~70" (1200 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 minimun water V-263			
	7	Record: V-205 Vol_____" & adj to 60" (2100 G)			
	8	Inspect Homog strainer & clean if Necessary			
		DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
SV V-263 & ~~205~~ 2	9	Run 2 " (514 G) water into V-262 Install temp chart & start agitator			
	10	Pump V-~~205~~ thru Homog at 4800-5200 psi into SV-262			
		Record: Time Start 5:40 Am Total Min 105			
		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 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ± 1000# water into V-384 & heat to 110-120F			
	14	Weigh into V-384 & Pump to V-349	1840	32-D	1840
	15	Run ± 1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 17" (805 G) & stir 15 min or longer			
	17	Record: Be' 1.081 ~~(10.95 ± 0.2)~~ (1.079 - 1.082) g/mL			
SV 4	18	When S 11 Homog complete, Adj SV to 24 " (2470 G)			
	19	Record: pH 10.8 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 Parts water to 1 part N-7-D) Assume 50%	25	7-D	13
		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 & 386 5	21	While heating SV, run 39" (1070 G) water into V-343			
	22	Meter in from V-386 M 19, 919 #/Gal 29.9 Gal		27-D	275
	23	Stir 15 min or longer			
	24	Record: Be' 1.016 ~~(2.8±0.1)~~ (1.013 - 1.018) g/mL			

13829 REV.

N 2631

V-262

EQUIPMENT		PAGE 2 CG 03 CODE KY-787-D (R) EST. WGT. 3490 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete Record: pH 9.9 (9.5-10.0)			
	26	Set V-343 acid pump at 82 setting (± 150 min)			
	27	Set V-349 silicate pump at 72 setting (±120 min)			
	28	Immediately meter in V-343 & 349, Maintain SV at 190-193F during strike			
	29	Record: Start / Finish / Minutes V-343: 11 20 AM / 2:30 PM / 190 V-349: 1:30 PM / 130			

Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	11:40	(35) 36	(14) 14	9.8	9.3-10.0
40 min	12	(30) 32	(11) 11	9.8	9.3-10.0
1 hr	12:20	(24) 26	(9) 9	9.8	9.3-10.0
2 hrs	1:20	(8) 10	(0) 1	9.8	9.3-10.0
Finish	1:50	0		7.7	7.5-8.5

Note: If pH drops below 9.0 in 1st hr, stop pumps & see Supv.
If final pH is above 8.5 adj to 7.5-8.5 & Record: pH
Assume 77 % — 27-D

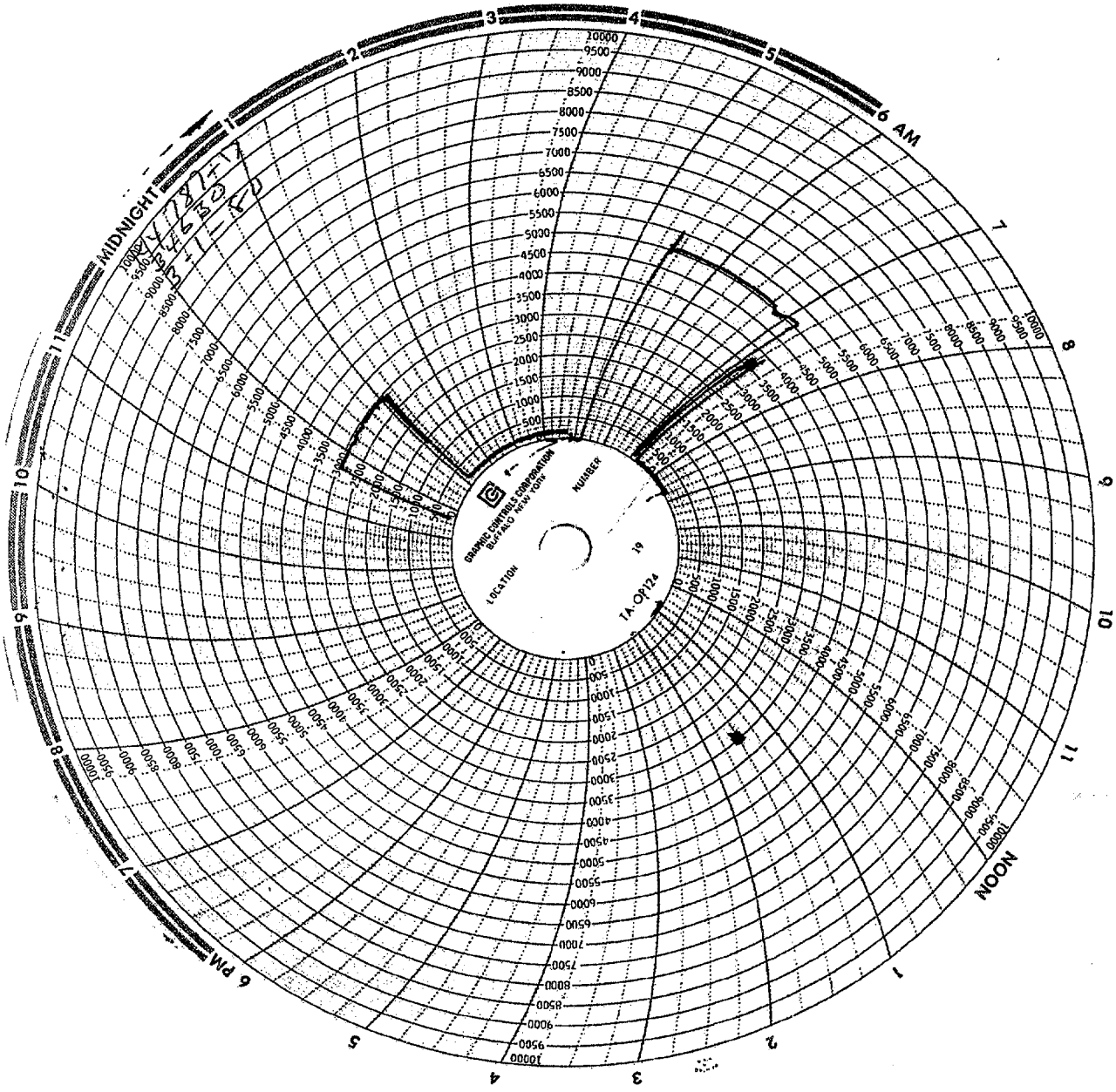
EQUIPMENT			USE LBS.	N CODE	ACCT. LBS.
330 7	30	Run 20" (392 G) water into V-330 & heat to 80-100 °F			
	31	Add in 7-8 min	350	530-A	350
	32	Stir 5 min & Record: pH ____ (9.5-10.5)			
	33	Stir 20 min or longer to dissolve for S 46			
357 8	34	Run 11" (80 G) water into V-357 & heat to 135-140 °F			
	35	Dump in & stir to dissolve for S-42	160	15-A	160
302 9	36	Run 30" (360 G) water into V-302			
	37	Add & stir 2 min for S44 Assume 50%	180	7-D	90
SV 10	38	When V-349 MTY, Rinse in with minimum water then set pump to zero setting			
	39	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	40	Turn off steam			
	41	Sift in 2 bags	100	128-A	100
	42	Run in V-357 from S 35 & stir 5 min			
	43	Record: pH 3.5 (3.7-4.2)			
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min			
	45	Record: pH 9.5 (9.0-9.5) & if necessary adj to pH 9.0-9.5 & Record: pH ____ Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7 into SV			
	46	Run in V-330 thru 20 mesh screen & stir 20 min			
313 11	47	Run 10" (128 G) water into V-313 & dump in	135	20-A	135
	48	Stir 5 min to dissolve for S 49			
SV 12	49	Run V-313 into SV in 15-20 min			
	50	Stir 15 min			
	51	Record: pH 9.5 (9.0-10.0)			
	52	Stop agitator DO NOT STOP V-262.			

START	FINISH	OPTR
7A	3	120-201
3:00P	4:00P	235-259

Step	V-262 (20 RPM)	V-243, 244, 246, 247
9	5"	10"
18	25"	48"

K 13830 REV.

DUP050093814



DUP050093815

250
200
150
100
50
0
4 MA
6 MA
8 MA
10 MA
GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK