

S.V. 243, 244, 245

C.V.

MAKING INSTRUCTIONS: BATCH UNIT
D.V.

CG 03

CODE KY-795-D

PUNCHED & CHECKED

LOT

JUN 12

36097

JUN 13 1980

PROCESSES

APPROVED BY

EST'D WGT 938

LBS

STANDARD HRS. 11.1

TIME

11P

() KY-795-D (1) FWP 5/8/80

() (3/4 N-32-D STRIKE TO

() IMPROVE GLOSS)

() (30 MIN LONGER STRIKE TIL

() STRIKE LINE IS REPLACED)

TYPED BY: FWP 5/8/80

COMPONENT CONSUMPTION

CG	CODE	LOT	PQ	LBS
14	YC002B	82204-3	93	3700
14	YC002B		93	
14	YC002B		93	

CG	CODE	LOT	PQ	LBS
14	YC002B		93	
14	YC002B		93	
14	YC002B		93	

Use re-ground YC-2-B AS PER WAREHOUSE REQUEST.

TOTAL EST'D WGT 4638

(Reg 3451)

NON-BLEEDING

EQUIP	NAME	USE LBS	N- CODE	ACCT LBS
	"KROLOR" YELLOW MEDIUM			
203 & 205	1 RUN 60" (990 G) WATER IN V-203. SET AGITATOR ON HIGH SPEED.			
	2 WEIGH IN DRUM & POUR IN	500	32-D	500
	3 DUMP IN AND STIR 5 MIN	74X50	YC-2-B	3700
	RECORD: START 11:42 AM			
	FIN 1:30 PM			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-203 THRU HOMOG AT 2400-2600 PSI INTO V-205			
	6 WHEN V-203 MT, WASH COLOR THRU HOMOG WITH MIN OF HOT WATER AT 2400-2600 PSI INTO V-205			
	7 RECORD: V-205 VOL " & ADJ TO 51" (1874 G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
205	9 RUN " (514 G) WATER INTO V-205 & START AGITATOR			
SV	10 PUMP V-205 THRU HOMOG AT 4800-5200 PSI INTO SV.			
	RECORD: TIME START 3:15P TOTAL MINUTES 140			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-205			
	11 WHEN V-205 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
349 & 384	12 WHILE HOMOG, RUN 6" (284 G) WATER INTO V-349			
	13 RUN 1000# WATER INTO V-384 & HEAT TO 110-120°F			
	14 WEIGH INTO V-384 & PUMP TO V-349	2000	32-D	2000
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 29" (1372 G) & STIR 15 MIN			
	17 RECORD DENSITY: 1.051 G/ML (1.049-1.051)			
SV	18 WHEN S-11 HOMOG COMPLETE, ADJ SV TO " (2496 G)			
	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%	20	7-D	10
	SIPHON N-7-D INTO SV & RECORD: PH 11.1			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT 190 *F			
	& RECORD: 190 *F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

21 WHILE HEATING SV, RUN 69" (1898 G) WATER INTO V-343
 22 METER IN FROM V-386 M. 1.026#/GAL, 28.7 GAL
 23 STIR 15 MIN OR LONGER
 24 RECORD: DENSITY 1.011 G/ML (1.010-1.012)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.1
 26 SET V-343 ACID PUMP AT 82 SETTING (265 MIN)
 27 SET V-349 SILICATE PUMP AT 70 SETTING (210 MIN)
 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE.

RECORD:	START	FINISH	MINUTES
V-343	8:40P		2:50
V-349			2:15
TIME	V-343	V-349	SV
	INCHES	INCHES	PH
AT 20 MIN	9:00P (65) 65	(26) 25	10.0 (9.0-10.0)
40 MIN	9:20P (59) 59	(23) 23	10.0 (9.0-10.0)
1 HR	9:40P (54) 54	(21) 20	9.9 (9.0-10.0)
2 HRS	10:40P (38) ---	(12) ---	--- (9.0-10.0)
3 HRS	11:40P (22) ---	(4) ---	--- (9.0-10.0)
3 1/2 HRS	12:10A (15) ---	(0) ---	--- (9.0-10.0)
FINISH	12:31A (0) ---	---	--- (7.5-8.5)

NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP PUMPS & SEE SUPV. IF FINAL PH IS ABOVE 8.5, ADJ TO 7.5-8.5 & RECORD: PH
 ASSUME 77%

V-262 ALITATOR STOPPED ABOUT 10:10 P. MOTOR BURNED OUT

30 RUN 15" (108 G) WATER INTO V-343 & HEAT TO 135-140°F
 31 DUMP IN & STIR TO DISSOLVE FOR S-38

32 WEIGH INTO 55 GAL DRUM
 33 FILL WITH WATER & STIR 2 MIN FOR S-40

34 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER
 SET PUMP TO ZERO SETTING
 35 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR
 36 TURN OFF STEAM
 37 SEPT IN
 38 RUN IN V-386 FROM S 31 & STIR 5 MIN
 39 RECORD: PH 3.5 (3.3-3.7) & IF NECESSARY ADJ (DOWN ONLY) TO 3.3-3.7 & RECORD: PH
 NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140°F IN DRUM, USE 30 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 4.2 (4.0-4.2) & IF NECESSARY ADJ TO PH 4.0-4.2 & RECORD: PH
 DILUTE N-7-D 10 TO 1 WITH WATER
 SIPHON N-7-D INTO SV
 42 POUR IN STIR 15 MIN
 43 STOP AGITATOR

START	FINISH	OPERATOR
3:00P	11:20P	259-120
6-16-80 7:00A	11:00PM	235-323
STEP	V-262 (20 RPM)	V-243, 244
9	5"	10"
18	25"	50"

V-244

VOLUME

94"

V-349

V-343

402 H/11
164"

48"

FINISH PUMPING

V-262

TO

V-244

3:50/4/11

1 1/2
3

V-244

4 - 240 - 25

After Reheating P.H. 9.8

V-343
START 8:40 AM - 48"
20 9:00 - 43 43
40 9:20 - 38 39
1 hr 9:40 - 32 35
2 " 10:40 - 16 22
3 " 11:40 - X

V-349

16"
13 13 9.8
11 11 9.8
9 7 9.7
X 0 9.7

48
16
32

N-32 Finish
10:45A

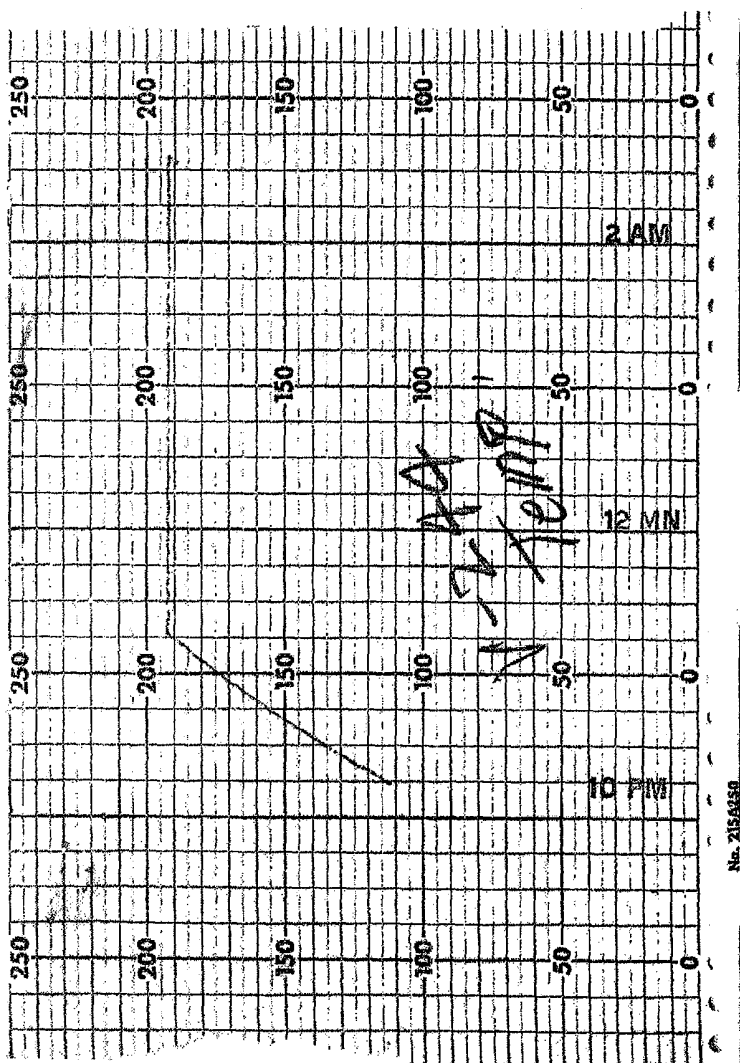
N-27 Finish
11:55 AM
280 MIN.

215 MIN

11-5-73

CODES	D.V.	N-2005	S.N.	6	9
KY-295		YC-2	243		
KO-289		YC-16	247		
KO-289		YC-16	245		
RT-261	OK	922/904 255/P2	903		20
BT-465		8600	210		
3YE's				15	
RT-201	OK	#142m 2656	280		
GP-501		8101	264		
2YE's				15	
				30	20
CARDS MISSING — KY-295 + RT-233 — NO NOTICE GIVEN					
ICE ORDERED —					

CARDS MISSING —	KY-795 + RT-233 —	NO NOTICE GIVEN
ICE ORDERED —		



DUP050456473

N32072.03

