

PUNCHED & CHECKED

APR 3 1980

MAKING INSTRUCTIONS BATCH UNIT

SV 245, 247

MARK

CV

D.V.1

CA 04 Core KO-786-D PKG.

APR 1 1980 0514Z

EST WGT 862 LBS

STD WGT 10.5 TIME

01 YC-10-B 93 4 33485 500#
01 YC-10-B 93 4 34407 550#
01 YC-10-B 93 4 33488 700#

OK
IP

PROCESSED	APPROVED BY
KO-786-D (P)	FW 3-21-76
	DCG 9-21-76
	MTF 10-1-76
TYPED BY	
HC 11-16-76	

Total Weight 4962# (Req.)

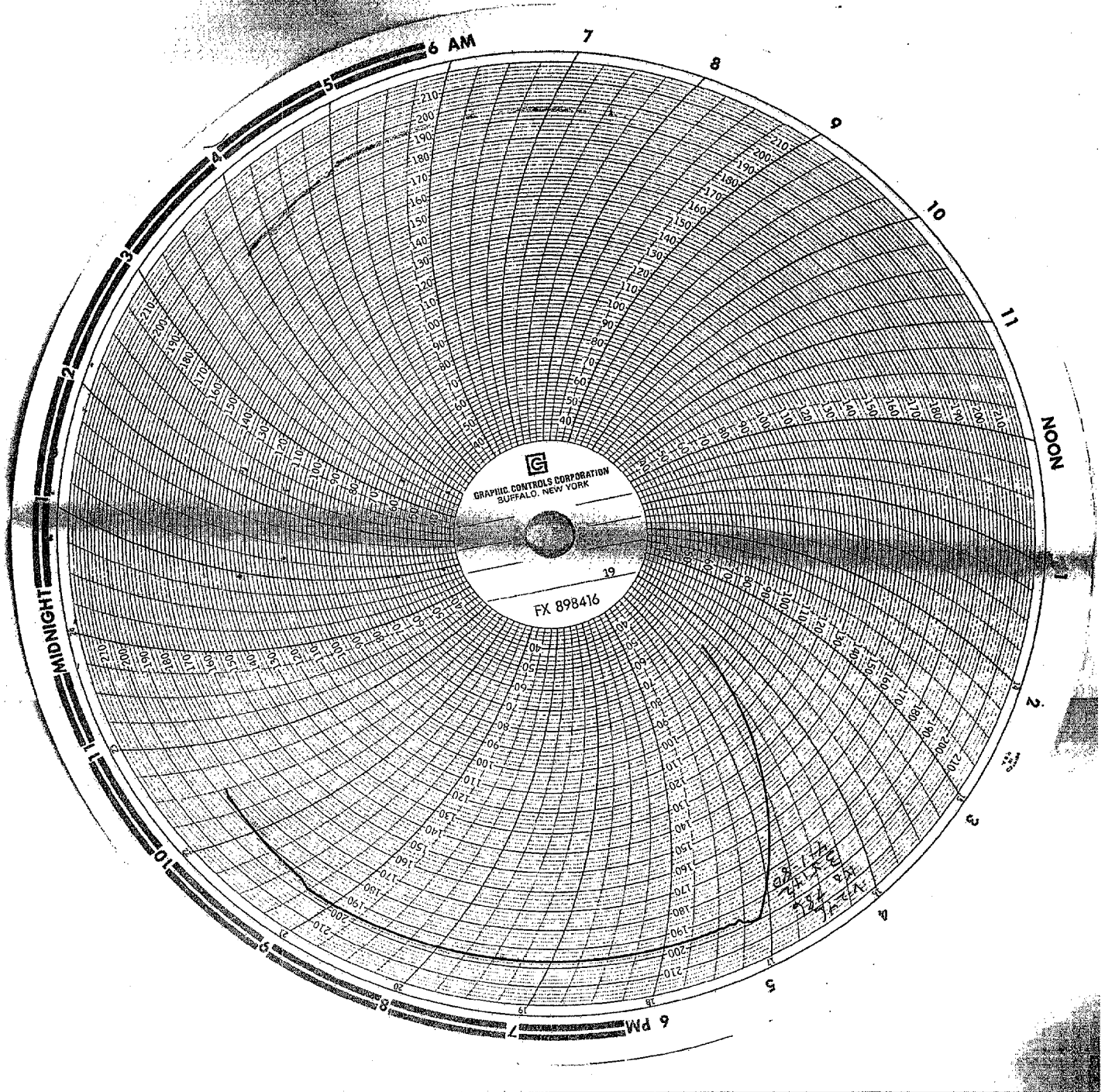
NONBLEEDING

EQUIPMENT	NAME	SET AGITATOR ON HIGH SPEED	USE LBS	IN CODE	ASOT
211	Run 60" (990 G) water in V-211 and add	Assume 50%	20	7-D	33
208	weigh in drum and pour in V-211		276	52-D	323
	Pump in and stir 5 minutes		32 x 50	YC-10-B	4100
	Record: Start 5:04 AM	53485	500		
	Fin. 7:20 AM	33407	520		
	2" (120 G)	33488	700		
	Pump to 84" (1370 G)	34811	1350		
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208				
	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water				
	Record: V-208 Vol 10" and adjust to 50% (1640 G)				
	Inspect homog strainer and clean if necessary				
	DRIVING HOMOG. RUN AGITATOR ON LOW SPEED				
208	Run 15" (771 G) water into V-208 and start agitator and				
	install temperature chart				
SV	Pump V-208 thru Homog at 4800-5200 psi into SV				
2	Record: Time Start 7:45 AM / Total Minutes 120				
	Note: If homog pressure falls below 4800 psi, 3 way valve will recirculate slurry to V-208				
	When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi				
343	While Homog run 6" (284 G) water into V-343				
384	Run 1000# water into V-384 and heat to 110-120°F				
384	weigh into V-384 and pump to V-343		2400	32-D	2400
3	Run 1000# water into V-384 and pump to V-343				
	Adjust V-343 to 22" (1040 G) & stir 15 minutes or longer				
	Record: 8:22 1078 (1078-1081)				
	3/min				
SV	When S-11 Homog complete, adjust to 66" (3400 G) in SV				
4	Record: pH 7.0 and adjust to 10.4-10.6 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				
	Heat to 190-194°F in 55-65 minutes & Record: HT 192°F and Rec 175 F				
	Note: Strike must be started immediately on completion of heating				
343	While heating SV, run 51" (1400 G) water into V-343				
386	Water in from V-386 MTC #Gal 118 Gal 33.7			27-D	365
386	Stir 15 minutes or longer				
5	Record: 8:52 1019 (1017-1019)				
	3/min				

N32508

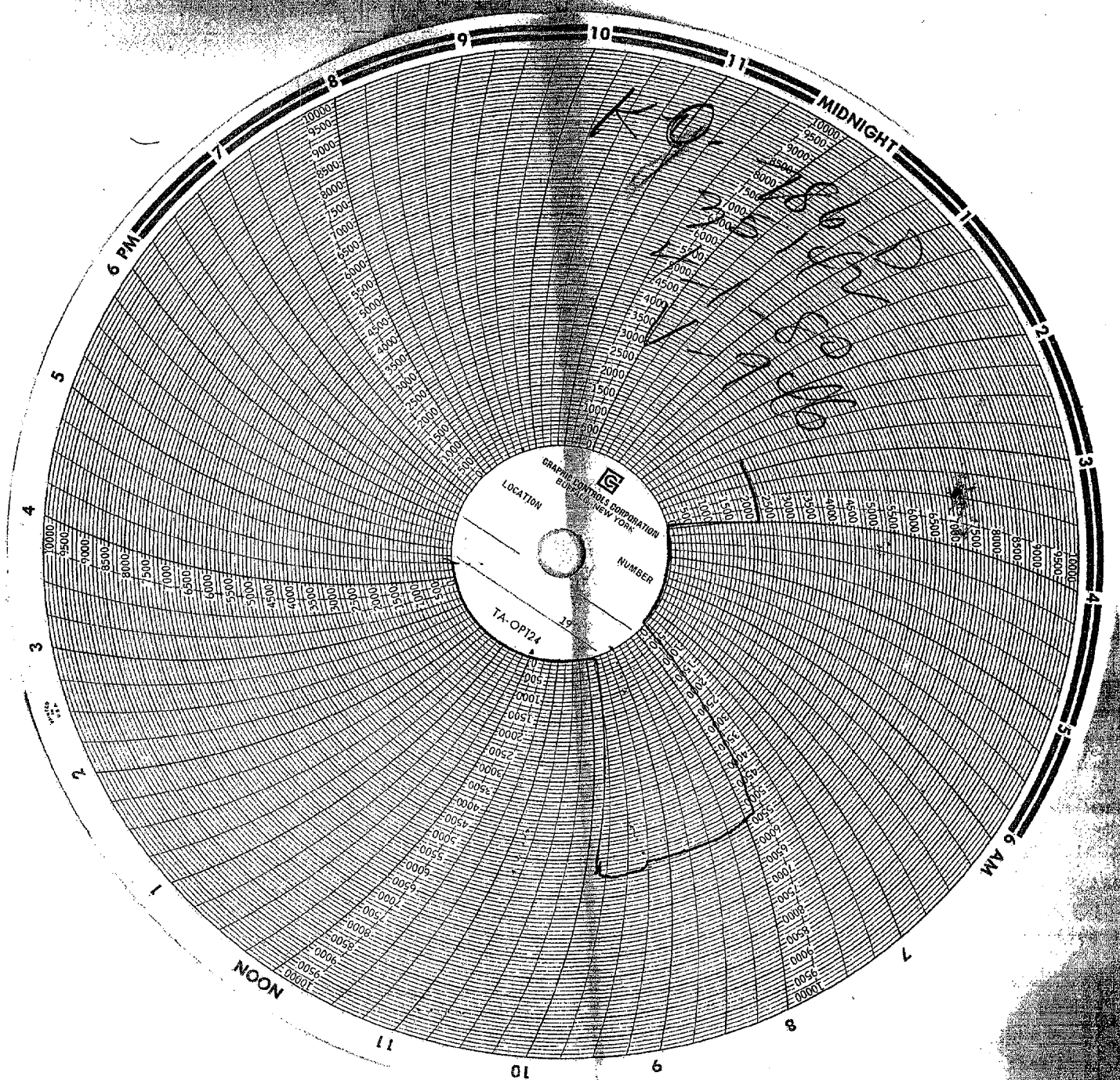
V-246

EQUIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	2	04	K0-786-D (R)	4962				
	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 9:20 PM	1:20 AM	240			
			V-349 9:20 PM	12:30 P.M.	190			
		Record:	Time	V-343	V-349	SV	Normal	
				Inches	Inches	pH	pH	
		at 20 min	9:40 PM	(47)	(20)	9.8	9.3-10.0	
		40 min	10:00	(43)	(17)	9.8	9.3-10.0	
		1 hr	10:20	(38)	(15)	9.8	9.3-10.0	
		2 hrs	11:20	(24)	(7)	9.9	9.3-10.0	
		3 hrs	12:20	(10)	(0)	9.8	9.3-10.0	
		Finish	1:05 AM	(0)		7.6	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 4.0 (3.3-3.7)						
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH 3.9						
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes						
	41	Record: pH 4.2 (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%						
		Siphon N-7-D into SV						
	42	Stop agitator						
		START	FINISH	OPTR				
		3:00 PM	11:00 PM	337				
		11:00 PM	2:40 A.M.	381.282				



N32508.01

DUP050461535



N32508.02

DUP050461536