

S.V. 243, 244, 246, 247, (262)

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

CG 03 CODE KY-788-D

PKG.

PUNCHED & CHECKED

D.V.

→ FEB 23 34504
EST. WGT. 960-860 LBS.

FEB 26 1980

OIR

KP

STD. HRS. 11.2 TIME 5 PM

14 YC-3-B 93 4 Lot 24410, 2000#
 14 YC-3-B 93 4 Lot 23864, 300#
 14 YC-3-B 93 4 Lot 24403, 300#

PROCESSES		APPROVED BY
() KY-788-D	(K)	
() ALTERNATE	()	
()	()	EWK 9/22/76
()	()	DCG 9/27/76
TYPED BY		MTW 9/30/76
NE 2/24/77		

Total Wgt. 3560# 3460

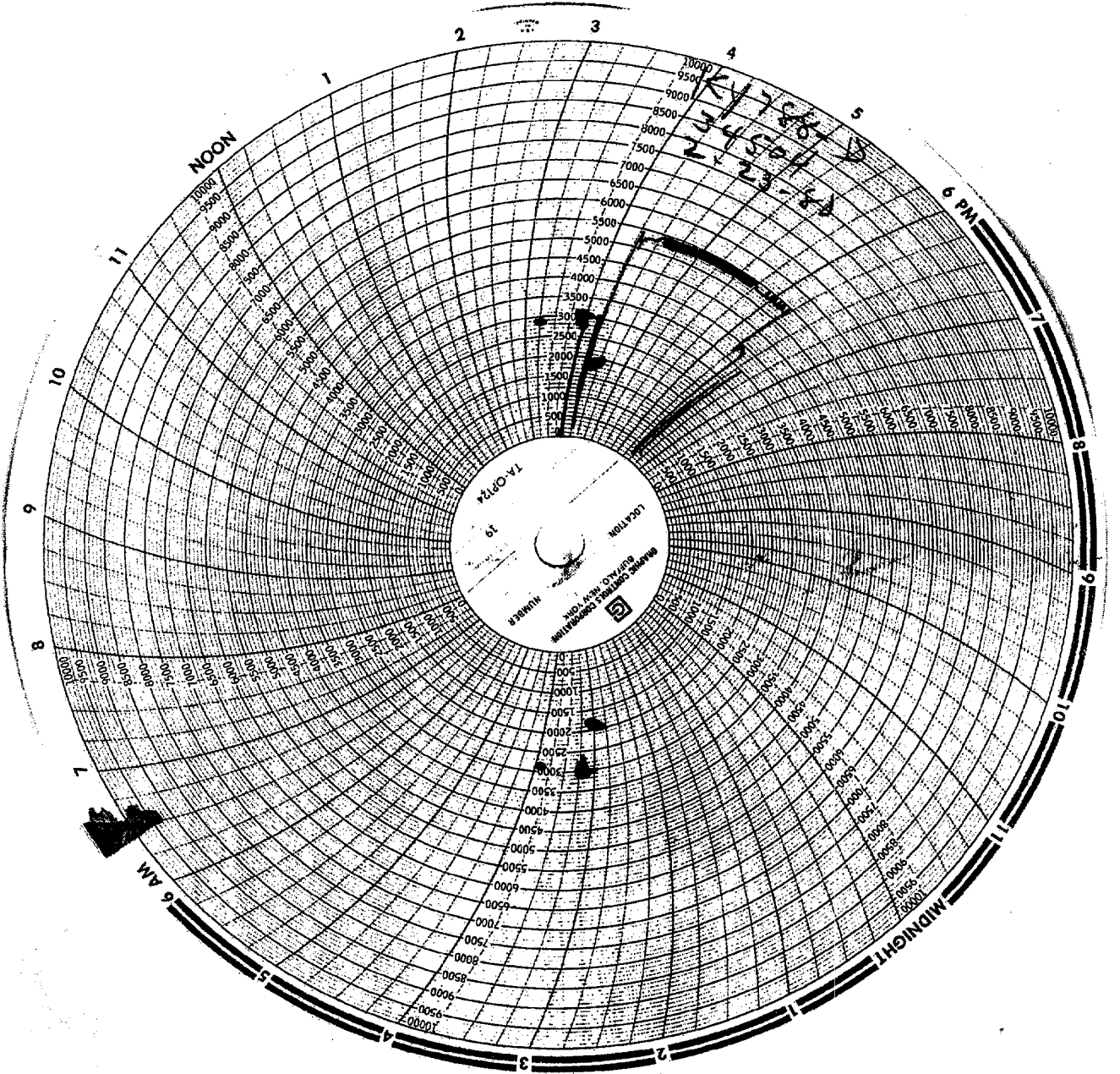
NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203 & 205	6" "KROLOR" YELLOW - LIGHT			
1	1 Run 55" (300 G) water into V-203 with agitator on high speed.	345	32-D	345
	2 Weigh in drum & pour in			
	3 Dump in & stir 5 min	52 x 50	YC-3-B	2600
	Record: start 24410 24410	2000		
	Fin 23864 23864	300		
	24403 24403	300		
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog 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 56 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
SV	9 Run 9" (214 G) into V-203 install temp chart & start agitator			
205	10 Pump V-205 thru Homog at 4800-5200 psi into SV 2600			
2	Record: Time Start 10:55 PM Total Min 135			
	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	12 While Homog, run 6" (284 G) water into V-349			
3	13 Run ± 1000# water into V-384 & heat to 110-120 °F			
	14 Weigh into V-384 & pump to V-349	1215	32-D	1215
	15 Run ± 1000# water into V-384 & pump to V-349			
	16 Adj V-349 to 14" (662 G) & Stir 15 min or longer	14		
	17 Record: Bt 1.066 (8.95 ± 0.2) (1.063-1.066)			
	9/mL			
SV	18 When S 11 Homog complete, adj SV to 24 " (2420 G)			
4	19 Record: pH 10.4 & adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.1		7-D	8
	20 Heat to 190-194F in 55-65 min & Record: HT F & Rec F			
	Note: Strike must be started immediately on completion of heating			
343 & 386	21 While heating SV, run 31" (850 G) water into V-343			
5	22 Meter in from V-386 M 19, 9.19 #/Gal 19.6 Gal		27-D	180
	23 Stir 15 min or longer			
	24 Record: Bt 10.15 (2.35 ± 0.1) (1.014-1.016)			
	8/mL			

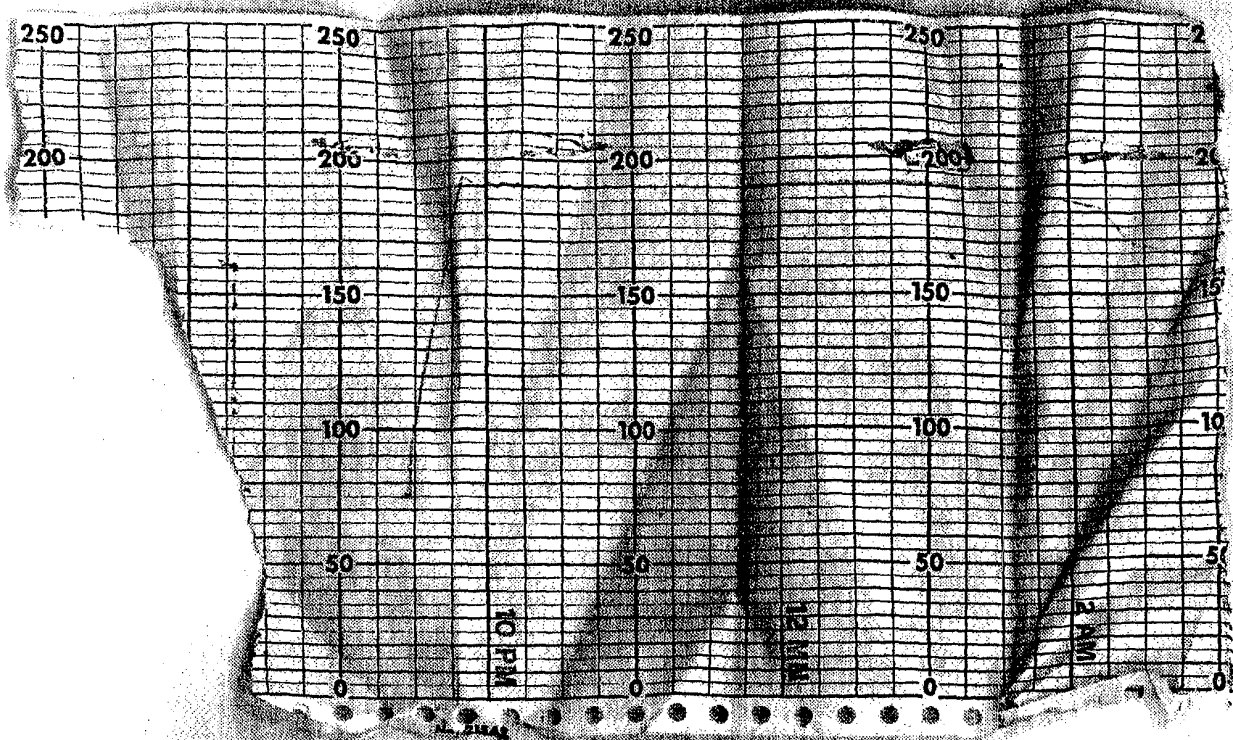
N 27562

262

EQUIPMENT	PAGE 2	CODE KY-788-D	EST. WGT.	3560	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete Record: pH <u>7.8</u> (9.5-10.0)						
	26	Set V-343 acid pump at 56 setting (± 180 min)						
	27	Set V-349 silicate pump at 49 setting (± 145 min)						
	28	Immediately meter in V-343 & V-349. Maintain SV at 100-194F during strike						
SV	29	Record: Start Finish Minutes						
		V-343 <u>1:15A</u> <u>9:30A</u> <u>215</u>						
		V-349 <u>3:30A</u> <u>160</u>						
		Record: Time V-343 V-349 SV Normal						
		at 20 min <u>1:35A</u> (28) <u>(22)</u> <u>9.6</u> 9.3-10.0						
		40 min <u>1:55A</u> (24) <u>(20)</u> <u>9.6</u> 9.3-10.0						
		1 hr <u>2:15A</u> (21) <u>(28)</u> <u>9.6</u> 9.3-10.0						
		2 hrs <u>3:15A</u> (10) <u>(18)</u> <u>9.6</u> 9.3-10.0						
		Finish <u>3:15A</u> (0) <u>(20)</u> <u>8.0</u> 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	
330	26	Run 20" (392 G) water into V-330 & heat to 80-100 °F						
7	31	Add in 7-8 min			350	530-A	350	
	32	Stir 5 min & Record: pH <u>10.2</u> (9.5-10.5)						
	33	Stir 20 min or longer to dissolve for S 46						
357	34	Run 29" (210 G) water into V-357 & heat to 135-140°F						
8	35	pump in & stir to dissolve for S 42			415	15-A	415	
302	36	Run 30" (360 G) water into V-302						
9	37	Add & stir 2 min for S 44 Assume 50%			360	7-D	180	
SV	38	When V-349 MTX, rinse in with minimum water then set pump						
10		at zero setting						
	39	When V-343 MTY, rinse in with minimum water then turn off						
		pump motor						
	40	Turn off steam						
	41	Shift in 2 bags			100	128-A	100	
	42	Run in V-357 from S 35 & stir 5 min						
	43	Record: pH <u>3.4</u> (3.7-4.2)						
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
	45	Record: pH <u>7.4</u> (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-D into SV						
	46	Run in V-330 thru 20 mesh screen & stir 20 min						
323	47	Run 10" (128 G) water into V-313 & dump in			135	20-A	135	
11	48	Stir 5 min to dissolve for S 49						
SV	49	Run V-313 into SV in 15-20 min						
12	50	Stir 15 min						
	51	Record: pH <u>9.2</u> (9.0-10.0)						
	52	Stop agitator Do Not stop - V-262.						
		START FINISH OPTR						
		<u>3 PM</u> <u>6:30A</u> <u>282438</u>						
		<u>11:00A</u> <u>6:30A</u> <u>27</u>						
		Step V-262 (20 RPM) V-243, 244, 246, 247						
		9 5" 10"						
		18 24" 47"						



262



DUP050094792