

V. 246 247

C.W.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

OG 04 CODE KO-786-D PKG.

DEC 20 33428

12/21/79

OK

KF

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

7 A.M.

PROCESSES		APPROVED BY	
()	KO-786-D	(P)	EWK 9-21-76
()		()	DCG 9-21-76
()		()	MTW 10-1-76
TYPED BY			
JIC 11-16-76			

01 YC-10-B 93 4 33059 700 # Bay 3 5BMS ①
 01 YC-10-B 93 4 33057 400 # Bay 2 6BMS ②
 01 YC-10-B 93 4 32895 3000 # Bay 2

32829

32901 Total Weight 4962# (Req. 0489)

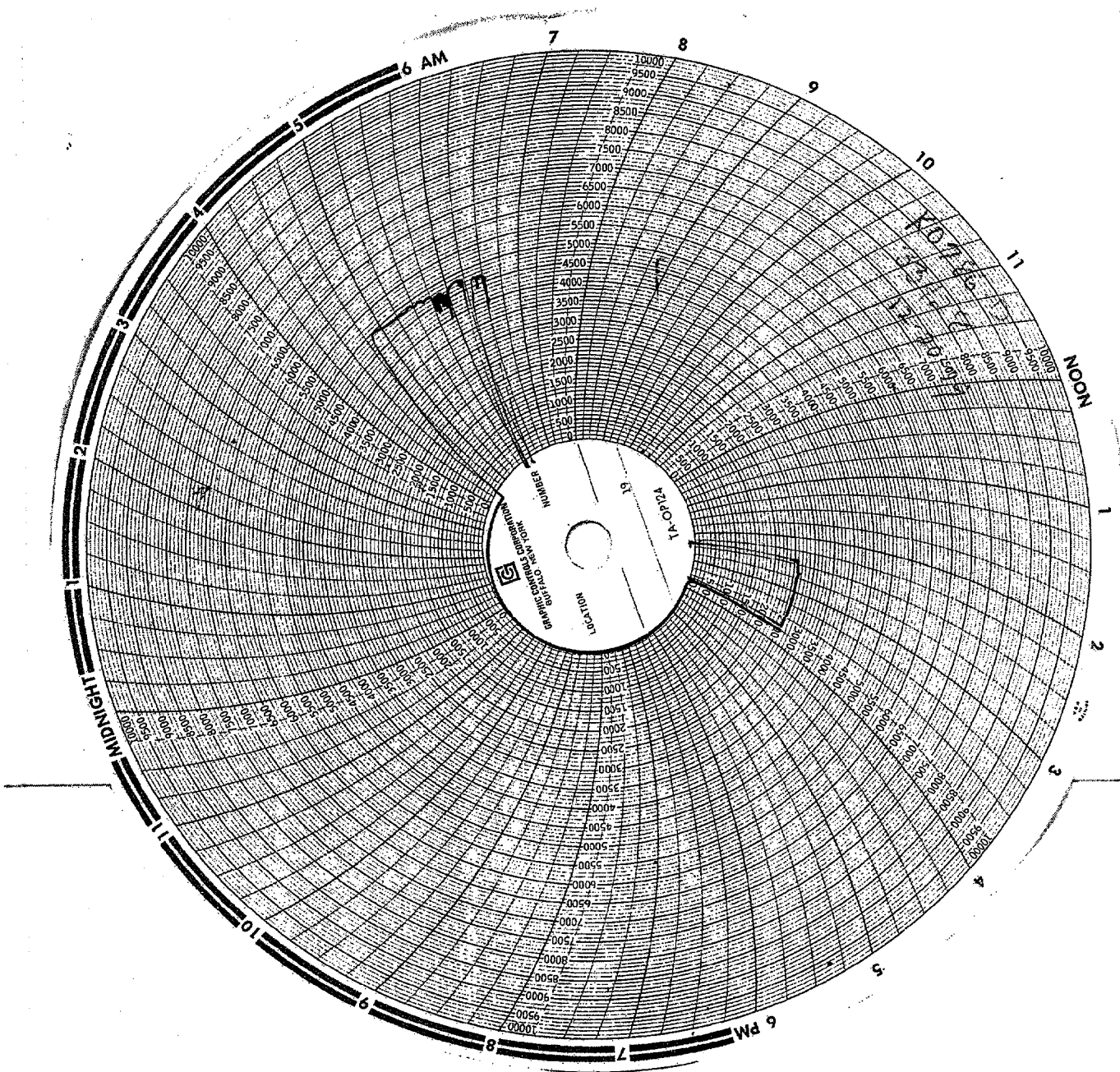
NON-BLEEDING

W/MENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 60" (990 G) water in V-211 and add Assume 50%	20 38	7-D	1670
8	2 Weigh in drum and pour in V-211	270	32-D	270
208	3 Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
1	Record: Start 11:50 AM 32835 60 3,000			
	Fin 11:55 PM 33059 5 250			
	75" (12756) 33057 6 300			
	4 Adjust to 80" (1370 G) 32823 2 100			
	5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208 32901-9 450			
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-208 Vol 42" and adjust to 50" (1840 G)			
	8 Inspect homog strainer and clean if necessary			
208	9 Run 15" (771 G) water into V-247 and start agitator and install temperature chart			
SV	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start 4:55 AM Total Minutes 100			
	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	12 While Homog, run 6" (284 G) water into V-349			
8	13 Run ±1000# water into V-384 and heat to 110-120°F			
384	14 Weigh into V-384 and pump to V-349	2400	32-D	2400
3	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: 8e 1.080 (10.9 ±0.2) 1.078-1.081			
SV	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	19 Record: pH 10.7 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 187°F and Rec 197°F			
	Note: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 51" (1400 G) water into V-343			
8	22 Meter in from V-386 M 32 #/Gal 1.81/Gal	362	27-D	355
386	23 Stir 15 minutes or longer			
5	24 Record: 8e 1.019 (2.8 ±0.1) 1.017-1.019			

8/mL

V-247

QUIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACTY. LBS.
SV	2	04	K0-786-D (8)	4962				
6	25	When S 20 heating complete, Record: pH <u>9.8</u> (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	10:10	2:10 P	240			
		V-349	10:10	1:25 P	195			
		Record:	Time	V-343	V-349	SV	Normal	
			10:10	54 Inches	22 Inches	pH	pH	
		at 20 min	10:30	(47) 49	(20) -	9.6	9.3-10.0	
		40 min	10:50	(43) 44+	(17) +	9.6	9.3-10.0	
		1 hr	11:10	(38) 40	(15) -	9.6	9.3-10.0	
		2 hrs	12:10	(24) 26	(7) 8+	9.6	9.3-10.0	
		3 hrs	1:10	(10) 12+	(0) 1+	9.6	9.3-10.0	
		Finish	2:10	(0)		3	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	30	Run 21" (150 G) water into V-357 and heat to 135-140°F						
7	31	Dump in and stir to dissolve						
						300	15-A	300
302	32	Add 42" (514 G) water to V-302						
8	33	Add and stir 2 minutes Assume 50%						
						150	7-D	75
SV	34	When V-349 MTY, rinse in with minimum water then set pump to zero setting						
9	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 <u>2.7</u> (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						
	41	Record: pH <u>4.4</u> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH <u>4.2</u> Assume 77%						
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%						
						6	27-D	5
		Siphon N-7-D into SV						
	42	Stop agitator						
		START	FINISH	OPTR				
		7:00 AM	5:00 PM	407				
		11:00 PM	11:00 AM	245-144				
		7:00 A	2:50 PM	235-342				



V-247

