MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244, 246, 247, 262 C.V. D.V.

CG 03 CODE KY-788-D PKG.

→ FEB 13 34376

EST. WGT. 960 LBS.

STD. HRS. 11.2 TIME 11A M

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		

14 YC-3-B 93 4 Lot , #

14 YC-3-B 93 4 Lot 23859, 2600 #

14 YC-3-B 93 4 Lot , #

OK / HP

Total Wgt. 3560#

NON-BLEEDING

EQUIPMENT		NAME: "KROLOR" YELLOW - LIGHT	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	✓1	Run 60" (992 G) water into V-203			
	✓2	Weigh in drum & pour in	345	32-D	345
	✓3	Dump in & stir 5 min Lot	52 x 50	YC-3-B	2600
		Record: start 4:PM. 23859	2600		
		Fin 5:18 PM			
		75" (1275G)			
	✓4	Adj to ~~70" (1200 G)~~			
	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 " & adj to 60" (2100 G)~~			
	8	~~Inspect Homog strainer & clean if necessary~~			
SV & 205 2	9	Run 5" (514 G) into V-262 install temp chart & start agitator			
	10	Pump V-203 thru Homog at ~~4800-5200~~ 3200-5000 psi into SV 262			
		Record: Time Start 2:05 AM Total Min 93			
		Note: If homog pressure falls below 3200 psi ~~3 way valve~~ will recirculate slurry to V-203			
	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 110-120 °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			
	17	Record: Be' 1.063 ~~(8.95 ± 0.2)~~ (1.063 - 1.066) g/mL			
SV 4	18	When S 11 Homog complete, adj SV to 24 " (2420 G)			
	19	Record: pH 10.1 & adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
		Siphon into SV & Record: pH 11.1			
	20	Heat to 190-194F in 55-65 min & Record: HT 192 F & Rec 194 F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 31" (850 G) water into V-343			
	22	Meter in from V-386 M 18, 9826 #/Gal 18.3 Gal		27-D	180
	23	Stir 15 min or longer			
	24	Record: Be' 1.014 ~~(2.35±0.1)~~ (1.014 - 1.016) g/mL			

MTW

N 264

V-262

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EQUIPMENT			USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete Record: pH 9.6 (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 190-194F during strike			
SV	29	Record: Start / Finish / Minutes V-343 9:30 AM / 12:49 P.M. / 199 V-349 11:30 AM / 11:58 P.M. / 148			

Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	9:50 A	(28) +	(12)	9.7	9.3-10.0
40 min	10:10 A	(24) +	(10) +	9.7	9.3-10.0
1 hr	10:30 A	(21) +	(8) +	9.8	9.3-10.0
2 hrs	11:30 A	(10) "	(3) +	9.8	9.3-10.0
Finish	12:30 P	(0)	(0)	9.2	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 8.0 Assume 77%	30	27-D 23
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 10.1 (9.5-10.5)		
	33	Stir 20 min or longer to dissolve for S 46		
357 8	34	Run 29" (210 G) water into V-357 & heat to 135-140°F		
	35	Pump in & stir to dissolve for S 42	415	15-A 415
302 9	36	Run 30" (360 G) water into V-302		
	37	Add & stir 2 min for S 44 Assume 50%	360	7-D 180
SV 10	38	When V-349 MTY, rinse in with minimum water then set pump at 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% Siphon N-7-D into SV		7-D
	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.		

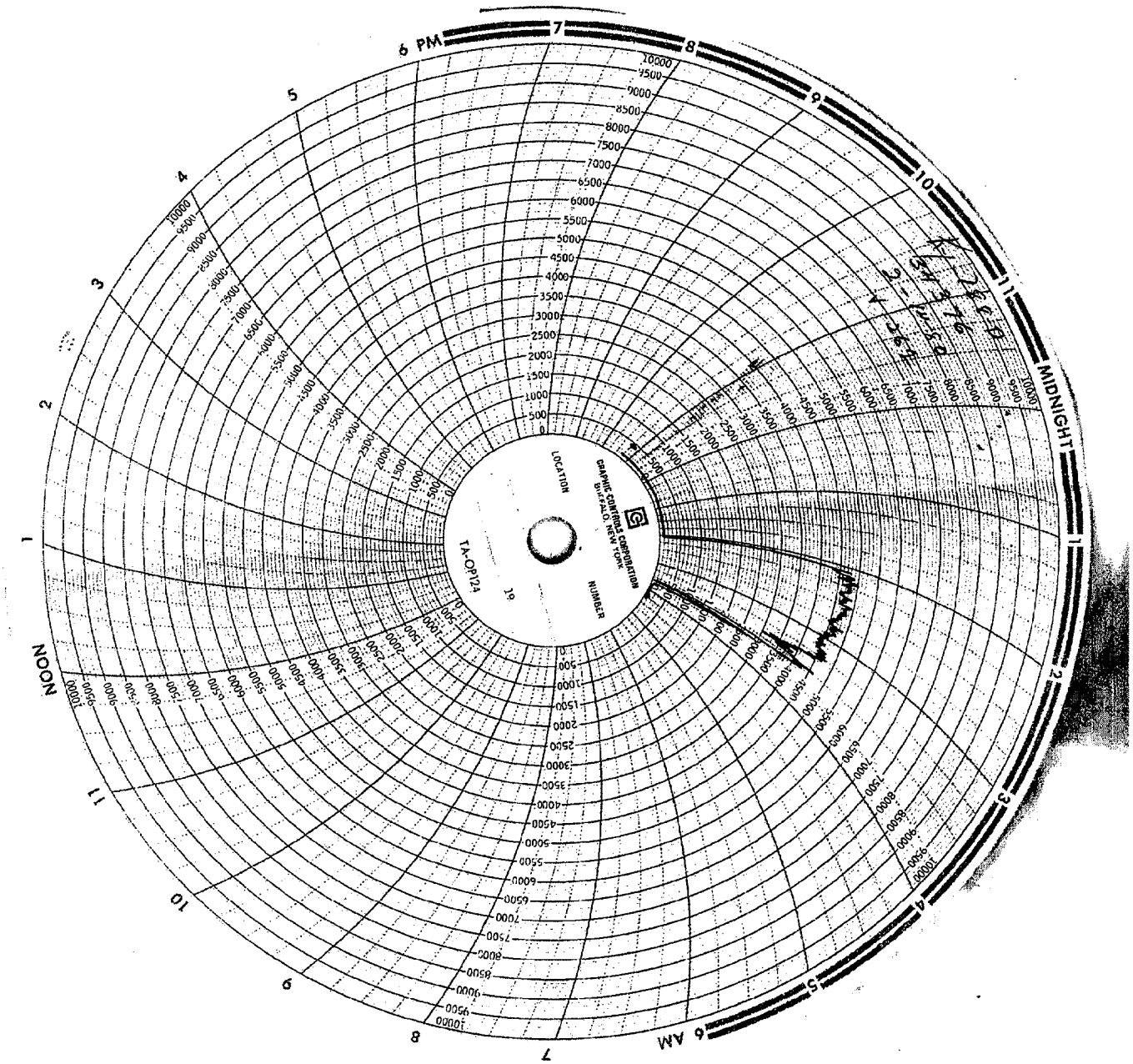
START	FINISH	OPTR
2:00 AM / 7 A.M. / 3 P.M.	7 AM / 3 P.M. / 5 P.M.	45-144 / 54-323 / 101

Step	V-262 (20 RPM)	V-243, 244, 246, 247
9	5"	10"
18	24"	47"

K 13830 REV.

DUP050094192

DUP050094193



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