MAKING INSTRUCTIONS: BATCH UNIT

S.V. ~~243, 244, 246, 247~~ 262 — YC-3-B — D.V.

CG 03 CODE KY-908-D PKG.

→ APRIL 35308

EST. WGT. 949 LBS.

PUNCHED & CHECKED

PROCESSES		APPROVED BY
( ) KY-908-D	(E)	EWK 12/12/77
( ) Alternate	( )	DCG 12/14/77
( )	( )	MW 12/19/77
( )	( )	
TYPED BY		
rj 2/8/77		

STD. HRS. TIME 5P M APR 10 1980 CK

14 YC-3-B 93 4 Lot 24696, 2000#
14 YC-3-B 93 4 Lot 24699, 600#
14 YC-3-B 93 4 Lot _____, ____#

APR 14 1980 HP

Homog #4 - 1ST Pass
" #3 - 2ND "

Total Weight 3549# (Req. _____) Pumped V-262 Back To V-205

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® YELLOW - LIGHT Rehomogenize	USE LBS.	N CODE	ACCT. LBS.
		60" (990 G)			
203 & 205 1	1	Run ~~23" (360 G)~~ water into V-203 SET AGITATOR ON HIGH SPEED			
	2	Pour in	345	32-D	345
	3	Dump in Lot	52 x 50	YC-3-B	2600
		Record: Start 3:15 A.M. 24696			
		Fin 4:55 A.M. 24699			
		~~80" (1360 G)~~ 75" (1275 G)			
	4	Adj to ~~70" (1200 G)~~ 2400-2600			
	5	Pump V-203 thru Homog at ~~1800-2200~~ psi into V-~~205~~ 262			
	6	When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
To V-262	7	Record: V-~~205~~ Vol 67" & adj to 60" (2100 G)			
	8	Inspect Homog strainer & clean if necessary			
SV & 205 2	9	Run ~~10"~~ (514 G) into V-262 Install temp chart & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into SV 262			
		Record: Time Start 9:15A Total Min 165			
		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 3	12	While Homog, run 6" (248 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'~~ 1.065 ~~(9.0 ±0.2)~~ 1.063 - 1.066 g/mL			
SV V-262 H.T. 86° R.T. 88°	18	When S H Homog complete, adj SV to ~~47"~~ (2420 G) 24" V-262			
	19	Record: pH 9.7 & adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	40	7-D	20
		Siphon into SV & Record: pH 11.2			
	20	Heat to 190-194°F in 55-65 min & Record: HT 192 F & Rec 190			
		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 28, 9.18 #/Gal 19.6 Gal		27-D	180
	23	Stir 15 min or longer			
	24	Record: ~~°Be'~~ 1.016 ~~(2.4 ±0.1)~~ 1.014 - 1.016 g/mL			

<13829 REV.

N32256

V-202

EQUIPMENT		PAGE 2 CG 03 CODE KY-908-D (E) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT LBS.
SV	25	When S 20 heating complete Record: pH 9.9 (9.5-10.0)			
6	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 190-194°F during strike			
	29	Record: Start / Finish / Minutes V-343 2:05 PM / 5:15 PM / 190 V-349 2:05 PM / 4:10 PM / 150			

Record:	Time	V-343	V-349	SV pH	Normal pH
	2:05	33-in	14 in		
at 20 min	2:25	(28) 29+	(12)	9.5	9.3-10.0
40 min	2:45	(24) 26-	(10)	9.5	9.3-10.0
1 hr	3:05	(21) 21	(8)	9.5	9.3-10.0
2 hrs	4:05	(10) 10	(3)	9.5	9.3-10.0
Finish	5:05	(0) 0	(0) 0	7.9	7.5-8.5

		NOTE: (1) If pH not as specified notify supervisor & note in log (2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH	Assume 78%	27-D	
	30	Sift in	50	128-A	50
357	31	Run 29" (210 G) water into V-357 and heat to 135-140°F			
7	32	Dump in and stir to dissolve for S60	415	15-A	415
302	33	Add 24" (294 G) water to V-302			
8	34	Add and stir 2 min for S63	Assume 50% 100	7-D	50
PT	35	During strike pump into PT	312	169-A	312
9	36	Pump in	36	155-A	36
	37	Pump in	36	160-A	36
	38	Stir 10 min with lightning mixer for S42			
356	39	During Strike, run 14" (244 G) water into V-356			
10	40	Turn on steam			
	41	Adj to 26 3/8" (317 G) at ~~178-182°F~~ 81-82°C			
	42	Pump PT, mixture from S38 thru undersurface Distributor AFAP			
	43	Rinse PT with hot water from hot water mixer & pump in			
	44	Shutoff pump 81-82°C			
	45	Stir 30 min at ~~178-182°F~~ for S54			
	46	Do not shutoff agitator			
SV	47	When V-349 MTY, rinse in with minimum water then set pump to zero setting			
11	48	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	49	Heat to 198-200°F in 5-10 min			
	50	Close water line & Discharge valves at stearate pump			
	51	Open V-356 Discharge valves to stearate pump inlet			
	52	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer			
	53	While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & close valve to sewer			

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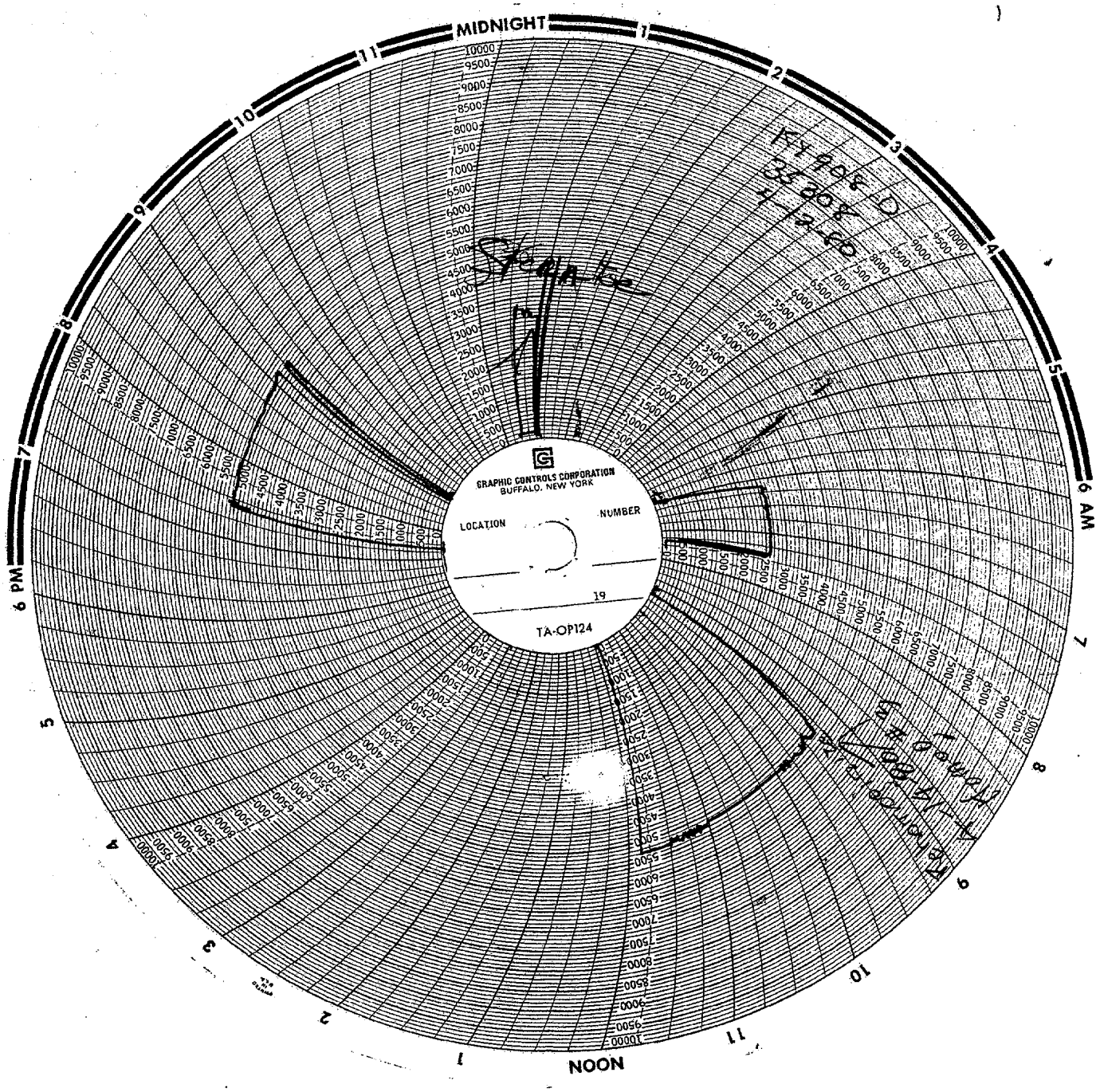
EQUIPMENT		PAGE 3 CG 03 CODE KY-908-D (E) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 11 con't	54	Immediately open stearate pump discharge valve,			
		turn on pump & homog V-356 to SV at 2800-3100 psi			
		maintain SV at 198-200°F			
	58	While Homog V-356 to SV, shut off water valve at			
		stearate pump ASAP			
	56	When homog complete, rinse in V-356 with hot water			
		from hot water mixer			
	57	When S56 complete, turn off Homog & stearate pump			
	58	Stir 5 min at 198-200°F			
	59	Shut off steam			
	60	Run in V-357 from S32 and stir 5 min			
	61	Record: pH 2.8 (3.3-3.7)			
	62	If necessary, adj pH to 3.3-3.7 (Downward only) and			
		Record: pH		15-A	
	63	Run in N-7-D from S34 in 4-6 min and stir 5 min			
	64	Record: pH 3.5 (4.2-4.4) and if necessary, adj to			
		pH 4.2-4.4 and Record: pH 4.2 Assume 78%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	105	7-D	52
		Siphon N-7-D into SV			
	65	Do not stop agitator			
		START FIN OPTR			
4/14-80		11:00 PM 7:00 AM 409-244			
		7:00 A 3:00 PM 335-54			
		3:01 P 9:00 P 23-383			



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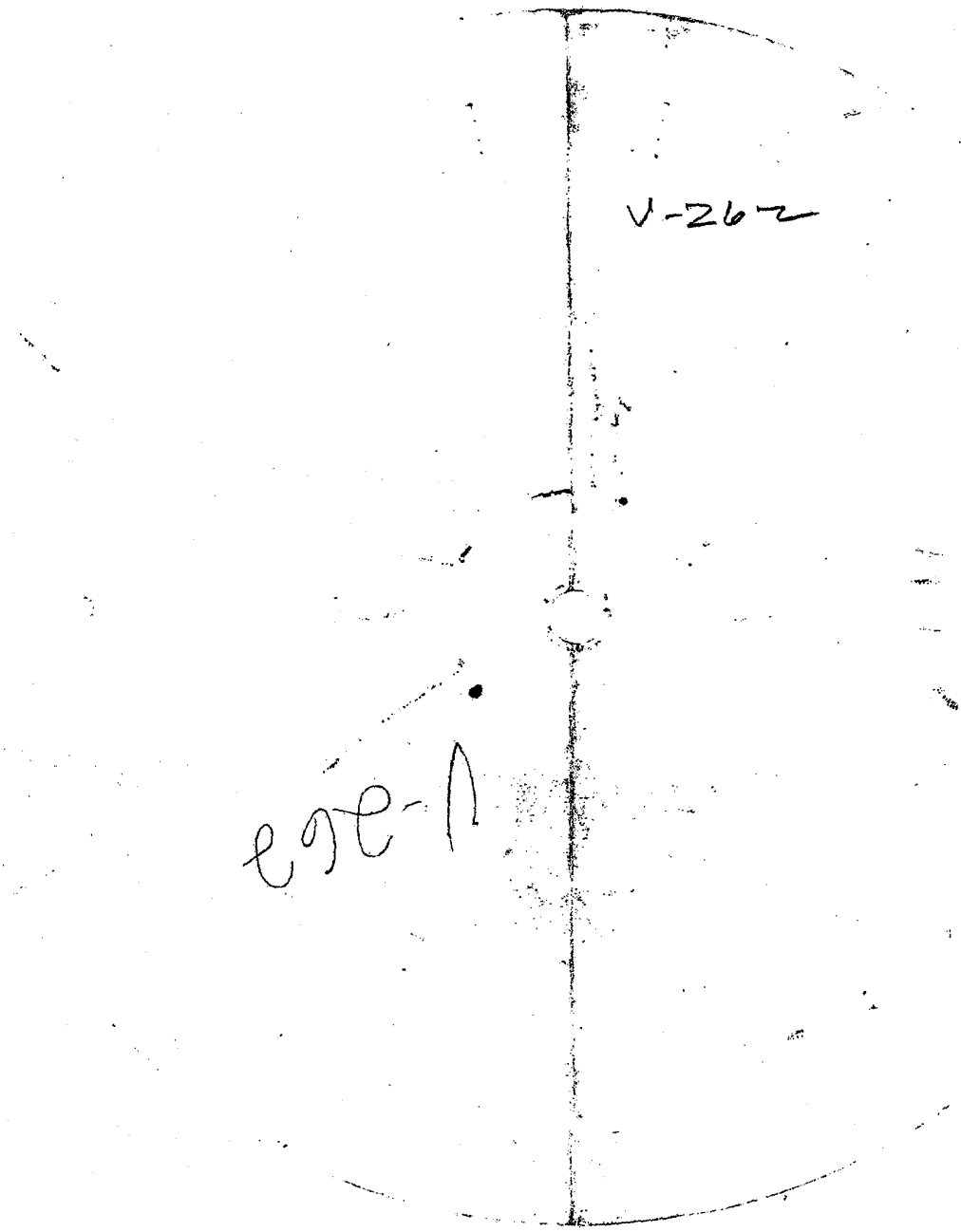
V-262
edge-1