

MAR 24 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 246 (247)

C.V.

D.V.

06 04 CODE KO-786-D PKG.

MAR 26 35075

PUNCHED & CHECKED

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

11P M APR 1 1980 FP

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 33488 200#
 01 YC-10-B 93 4 34404 1700#
 01 YC-10-B 93 4 34410 800#

01 YC-10-B 93 34411 1400#
 MAR 27 1980

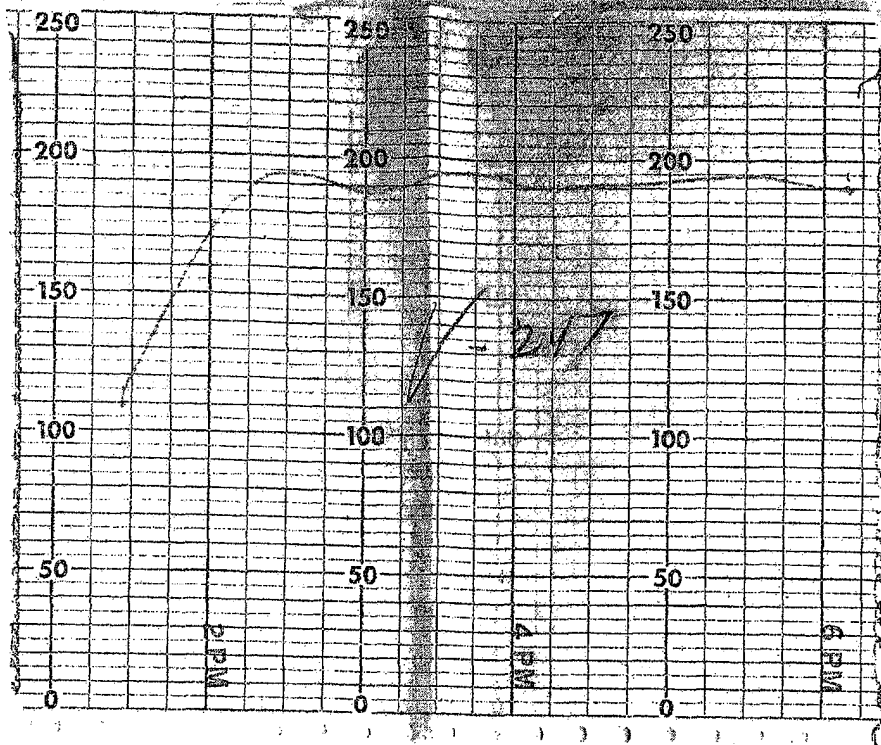
Total Weight 4962# (Req.)

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 60" (990 G) water in V-211 and add	Assume 50%	30	7-D 15
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 4:15	33488		
	Fin 5:15	34404		
	75" (1275 G)	34410		
	4 Adjust to 80" (1370 G)	34411		
	5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-208 Vol 48 " and adjust to 50" (1840 G)			
	8 Inspect homog strainer and clean if necessary			
	DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED			
208	9 Run 15" (771 G) water into V-247 and start agitator and install temperature chart			
8	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
SV	Record: Time Start 12:23 A Total Minutes 160			
2	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: 8.1 1.081 (10.9 ±0.2) - 1.078 - 1.081			
	8/1 ml			
SV	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	19 Record: pH 10.9 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 183°F and Rec 193°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 #/Gal 9.16 Gal 38.8		27-D	355
386	23 Stir 15 minutes or longer			
5	24 Record: 8.1 1.018 (2.8 ±0.1) 1.017 - 1.019			
	8/1 ml			

V-247

EQUIPMENT	PAGE	2	CG 04	CODE	K0-786-D (2)	EST. WGT.	4962	LBS.	USE	N	ACCT.
									LBS.	CODE	LBS.
SV	25	When S 20 heating complete, Record: pH 10.1 (9.6-10.2)									
6	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	5:30	9:30 P	240					
			V-349	P 8:40 P	190						
		Record:	Time	V-343	V-349	SV	Normal				
			5:30	5 3/4 Inches	Inches	pH	pH				
	at 20 min		5:50	(47) 49	(20)	9.8	9.3-10.0				
	40 min		6:10	(43) 45	(17) +	9.8	9.3-10.0				
	1 hr		6:30	(38) 41	(15)	9.8	9.3-10.0				
	2 hrs		7:30	(24) 26-	(7) +	9.8	9.3-10.0				
	3 hrs		8:30	(10) 12	(0) 1-	9.8	9.3-10.0				
	Finish		9:35	(0)		7.2	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 3.4 (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 4.0 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH 4.0 Assume 77%									
										27-D	
								(Dilute 10 parts water to 1 part N-7-D) Assume 50%	10	7-D	3
		Siphon N-7-D into SV									
	42	Stop agitator									
		START	FINISH		OPTR						
		3:00 P	10:00 P		235-259						



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