MAKING INSTRUCTIONS: BATCH UNIT

S.V. ~~245~~, 247 C.V. D.V.

CG 04 CODE KO-906-D PKG.

PUNCHED & CHECKED MAY 20 1980

EST. WGT. 1377 LBS.

STD. HRS. TIME 11A M

PROCESSES		APPROVED BY
( ) KO-906-D	(C)	EWK 1/24/78
( )	( )	DCG 1/26/78
( )	( )	MW 1/26/78
( )	( )	
TYPED BY		
rj 3/2/78		

01 YC-10-B	93	4	33359	1700 #
01 YC-10-B	93	4	35462	2000 #
01 YC-10-B	93	4		#

TOTAL WEIGHT 5077# (Req.)

Hom 700 #2 ? MAY 20 1980

NON-BLEEDING

EQUIPMENT		NAME: 60" (990 G) KROLOR® ORANGE R (RUN AGITATOR ON HIGH SPEED)	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run ~~31" (505 G)~~ water in V-211 and add Assume 50%	26	7-D	13
	2	Weigh in drum and pour in	245	32-D	245
	3	Dump in and stir 5 min Lot	74 x 50	YC-10-B	3700
		Record: Start 8:45 PM 33359	1700		
		Finish 10:15 PM 35462	2000		
		~~80" (1360 G)~~ 75" (1275 G)			
	4	Adjust to 64" (1082 G)			
	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 45 " & adjust to 45" (1662 G)			
	8	Inspect Homog strainer and clean if necessary			
		DURING HOMOG, RUN #2 V-211 AGITATOR ON LOW SPEED			
208 & SV 2	9	Run 15" (793 G) water into V-247 & start agitator			
	10	Pump V-208 thru Homog at 4800-5200 psi into SV			
	11	Record: Time Start 850 Total Min 150			
		Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	12	When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384 3	13	While Homog, run 5" (237 G) water into V-349			
	14	Run 1000#water into V-384 and heat to 110-120°F			
	15	Weigh into V-384 and pump to V-349	2165	32-D	2165
	16	Run 1000#water into V-384 and pump to V-349			
	17	Adjust V-349 to 20" (946 G) and stir 15 min or longer			
	18	Record: ~~°Be'~~ 1.079 (10.9 ± 0.2) (1.078-1.081) g/mL			
SV 4	19	When S12 Homog complete, adj to 59" (3033 G) in SV			
	20	Record: pH 10.5 & adj 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, stir 5 min & record: pH			
	21	Heat to 190-194°F in 55-65 min & Record: HT 186 , Rec 194 °F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	22	While heating SV, run 46" (1265 G) water into V-343			
	23	Meter in from V-386 M 34 .10 d 3 #/Gal 29.6 Gal		27-D	320
	24	Stir 15 min or longer			
	25	Record: ~~°Be'~~ 1.019 (2.9 ±0.1) (1.018-1.019) g/mL			
		Clean For 26 Press	1000	7-D	500

K 16829 REV.

N34583

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V-247

EQUIPMENT		PAGE 2 CG 04 CODE KO-906-D (C) EST. WGT. 5077 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	26	When S20 heating complete, Record: pH 9.9 (9.6-10.2)			
6	27	Set V-343 acid pump at 65 setting (±225 min)			
	28	Set V-349 Silicate pump at 57 setting (±180 min)			
	29	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	30	Record: Start / Finish / Minutes V-343 12:50 PM / 4:45 AM / 235 V-349 12 PM / 4:00 AM / 190			
		Record: Time / V-343 Inches / V-349 Inches / SV pH / Normal pH 12:50 / / / /
		at 20 min 1:10 / (43) / (18) / 9.7 / 9.3-10.0
		40 min 1:30 / (39) + / (16) / 9.7 / 9.3-10.0
		1 hr 1:50 / (35) 36 / (13) + / 9.7 / 9.3-10.0
		2 hrs 2:50 / (22) 24 / (7) 8 / 9.5 / 9.3-10.0
		3 hrs 3:50 / (10) 12 / (0) / 9.75 / 9.3-10.0
		Finish 4:45 / (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 to 7.5-8.5 and Record: pH			
	31	Sift in 1 bag Assume 78%	50	27-D 128-A	50
357	32	Run 19" (137 G) water into V-357 & heat to 135-140°F			
7	33	Pump in & stir to dissolve for S61	270	15-A	270
302	34	Run 24" (294 G) water into V-302			
8	35	Add & stir 2 min for S64 Assume 50%	136	7-D	68
PT	36	During strike pump into PT	464	169-A	464
9	37	Pump in	52	155-A	52
	38	Pump in	52	160-A	52
	39	Stir 10 min with lightning mixer for S43 15"			
356	40	During strike, run ~~22~~" (268 G) water into V-356			
10	41	Turn on steam			
	42	Adj to ~~30~~" (366 G) at ~~178-182~~°F 81-82°C			
	43	Pump PT, mixture from S39 thru undersurface Distributor AFAP			
	44	Rinse PT with hot water from hot water mixer & pump in			
	45	Shutoff pump 81-82°C			
	46	Stir 30 min at ~~178-182~~°F for S55			
	47	Do not shutoff agitator			
SV	48	When V-349 MTY, rinse in with minimum water then set pump to zero setting			
11	49	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	50	Heat to 198-200°F in 5-10 min			
	51	Close water line & discharge valves at stearate pump			
	52	Open V-356 Discharge valves to stearate pump inlet			
	53	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer			
	54	While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & close valve to sewer			
	55	Immediately open stearate pump Discharge valve, Turn on pump & Homog V 356 to SV at 2900-3100 psi Maintain SV at 198-200°F			
	56	While Homog V-356 to SV, shutoff water valve at Stearate pump ASAP			

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V-247

EQUIPMENT		PAGE 3 CG 04 CODE KO-906-D (C) EST. WGT. 5077 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 11 Con't	57	When Homog complete, rinse in V-356 with hot water			
		From hot water mixer			
	58	When S57 complete, turn off Homog & stearate pump			
	59	Stir 5 min at 198-200°F			
	60	Shut off steam			
	61	Run in V-357 from S33 and stir 5 min			
	62	Record: pH 3.25 (3.3-3.7)			
	63	If necessary, adj pH to 3.3-3.7 (Downward only) and			
		Record: pH		15-A	
	64	Run in N-7-D from S35 in 4-6 min and stir 5 min			
	65	Record: pH 3.8 (4.0-4.2) and if necessary, adj to			
		pH 4.0-4.2 and Record: pH 4.2 Assume 78%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	18	7 D	5
		Siphon N-7-D into SV			
	66	Do not stop agitator			

START	FIN	OPTR
11:00P	7:00AM	235-320
9:00P	11:00P	126-120
11:00P	6:10AM	235-237

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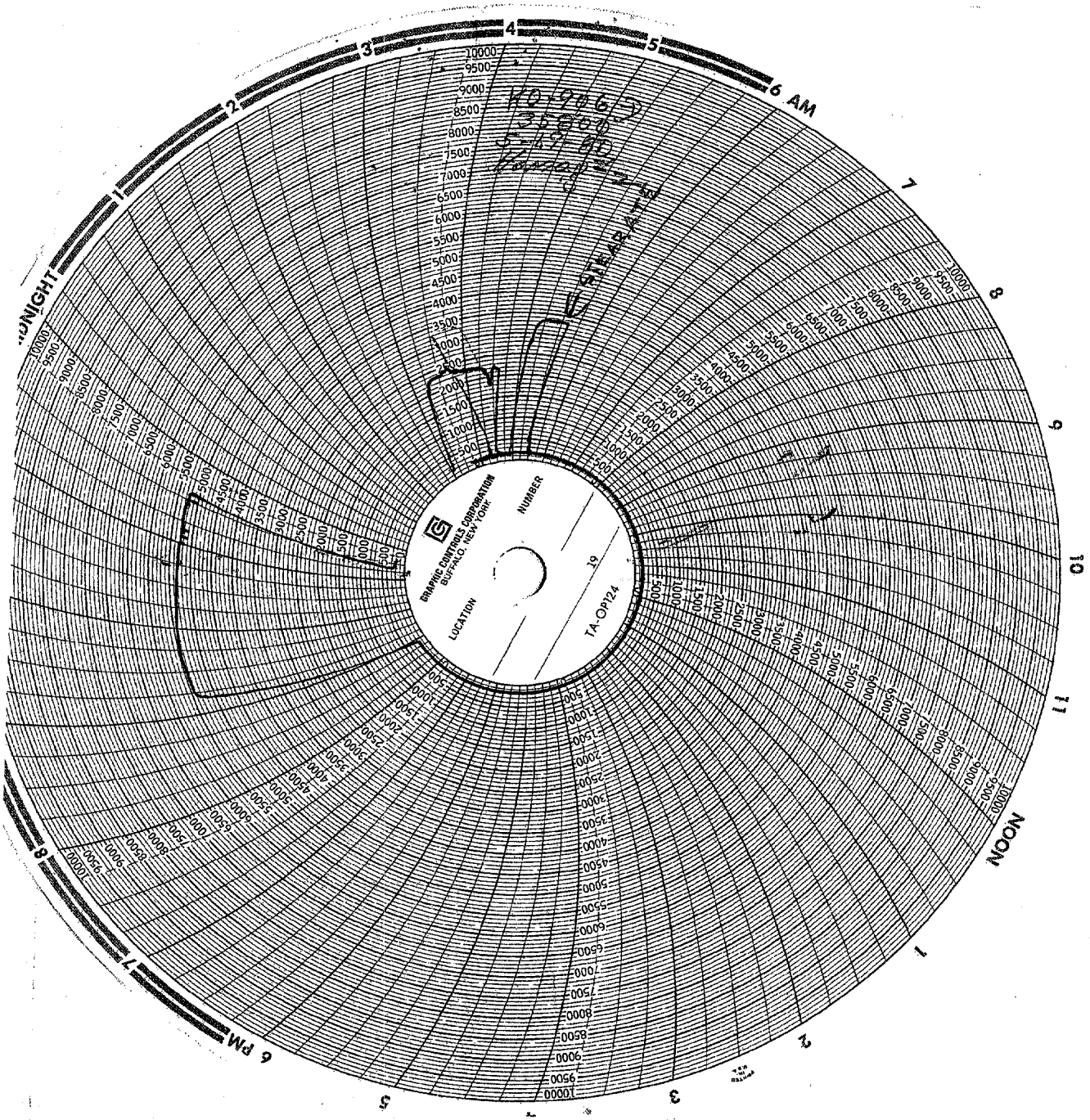

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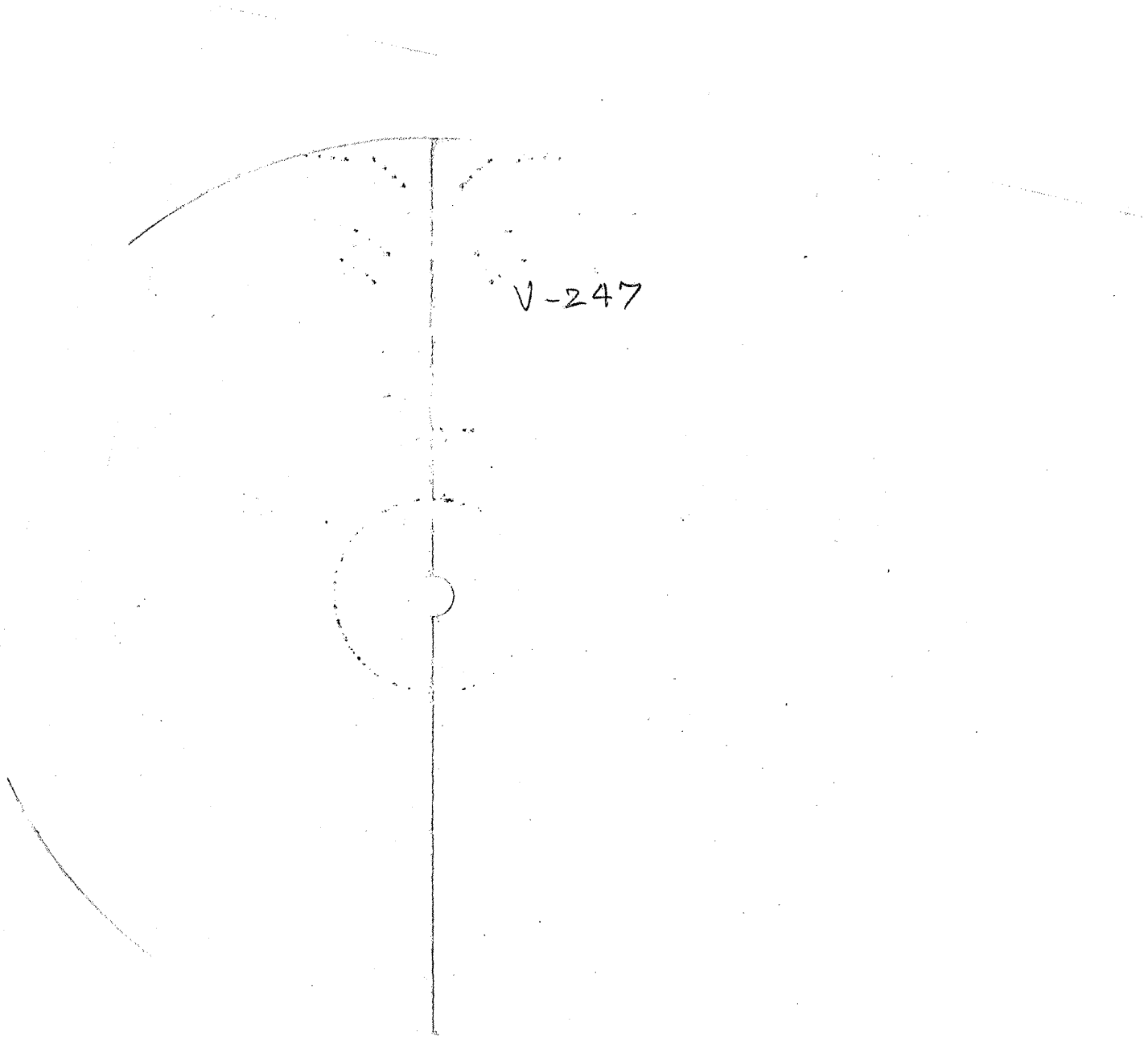
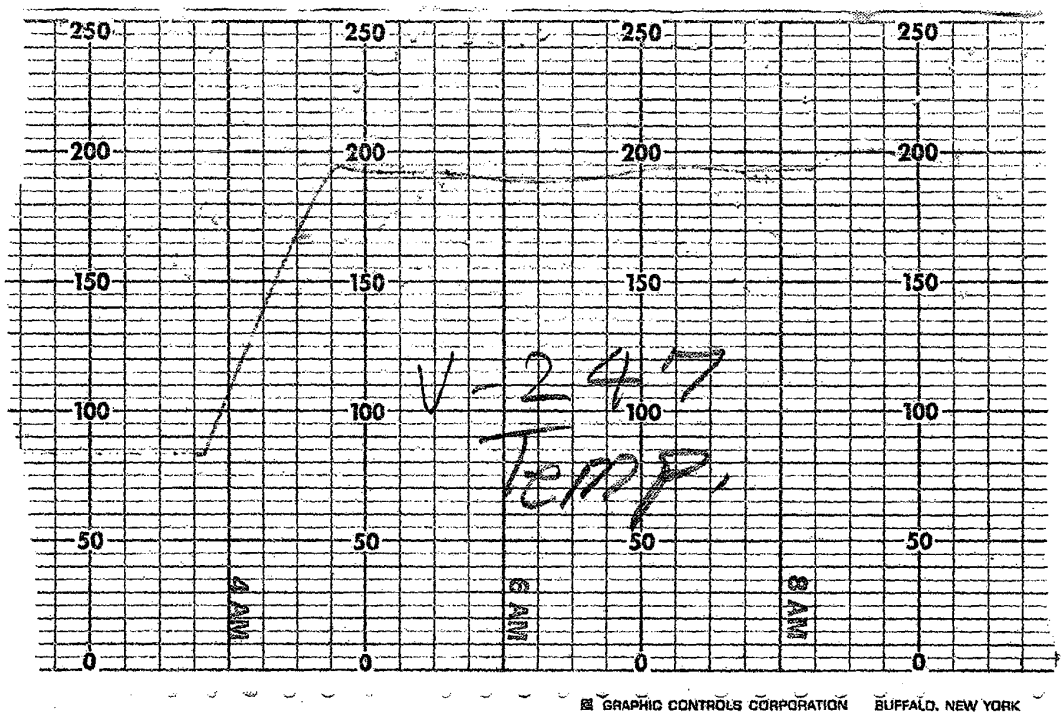

V-247



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

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