

MAKING INSTRUCTIONS BATCH UNIT

V. 246 *246* *OK*
 CC. DN. CODE KO-736-D PKG. *PUNC*
 EST. WGT 862 LBS. *APR 1968*
 STD. HR 10.5 TIME *11:15 AM*
 01 VC-10-B 93 4 *33485 500*
 01 VC-10-B 93 4 *34407 500*
 01 VC-10-B 93 4 *33485 930*

PROCESSES	APPROVED BY
KO-736-D	ENK 2-21-76
	DCG 2-21-76
	MTY 10-1-76
TYPED BY	
HC 11-16-76	

Total Weight 4962# (Req.)

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS	N CODE	ACT LBS
211	Run 60" (990 G) water in V-211 and add. Assume 50%	30	7-D	15
8	Weigh in drum and pour in V-211	278	10-B	270
208	Dump in and stir 5 minutes LOT	82 x 50	VC-10-B	4100
1	Record: Start <i>11:30</i> Fin <i>1:30</i> <i>75" (12756)</i> Adjust to 80" (1370-G)			
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	When V-211 MTY, wash color thru Homog at 1800-2200 psi using mild soap water			
	Record: V-208 Vol <i>11.1</i> and adjust to 50" (1800 G)			
	Inspect homog strainer and clean if necessary			
208	Run 15" (771 G) water into V-247 and start agitator and install temperature chart			
SV	Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start <i>7:30</i> Total Minutes <i>120</i> Note: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349	While Homog, run 6" (284 G) water into V-349			
8	Run 1000# water into V-384 and heat to 110-120°F			
384	Weigh into V-384 and pump to V-349	2400	32-D	2400
3	Run 1000# water into V-384 and pump to V-349			
	Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	Record: <i>Sp 1.031 (10.9 ± 0.2) (1.078-1.081)</i> <i>21 mL</i>			
SV	When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	Record: pH <i>10.9</i> 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			
	Heat to 190-194°F in 55-65 minutes & Record: HT <i>175</i> F and Rec <i>175</i> F			
	Note: Strike must be started immediately on completion of heating			
343	While heating SV, run 51" (1400 G) water into V-343			
8	Measure in from V-386 M <i>16</i> #/Gal <i>9307</i> Gal <i>35.1</i>		27-D	355
386	Stir 15 minutes or longer			
5	Record: <i>Sp 1.019 (2.8 ± 0.1) (1.017-1.019)</i> <i>21 mL</i>			

247

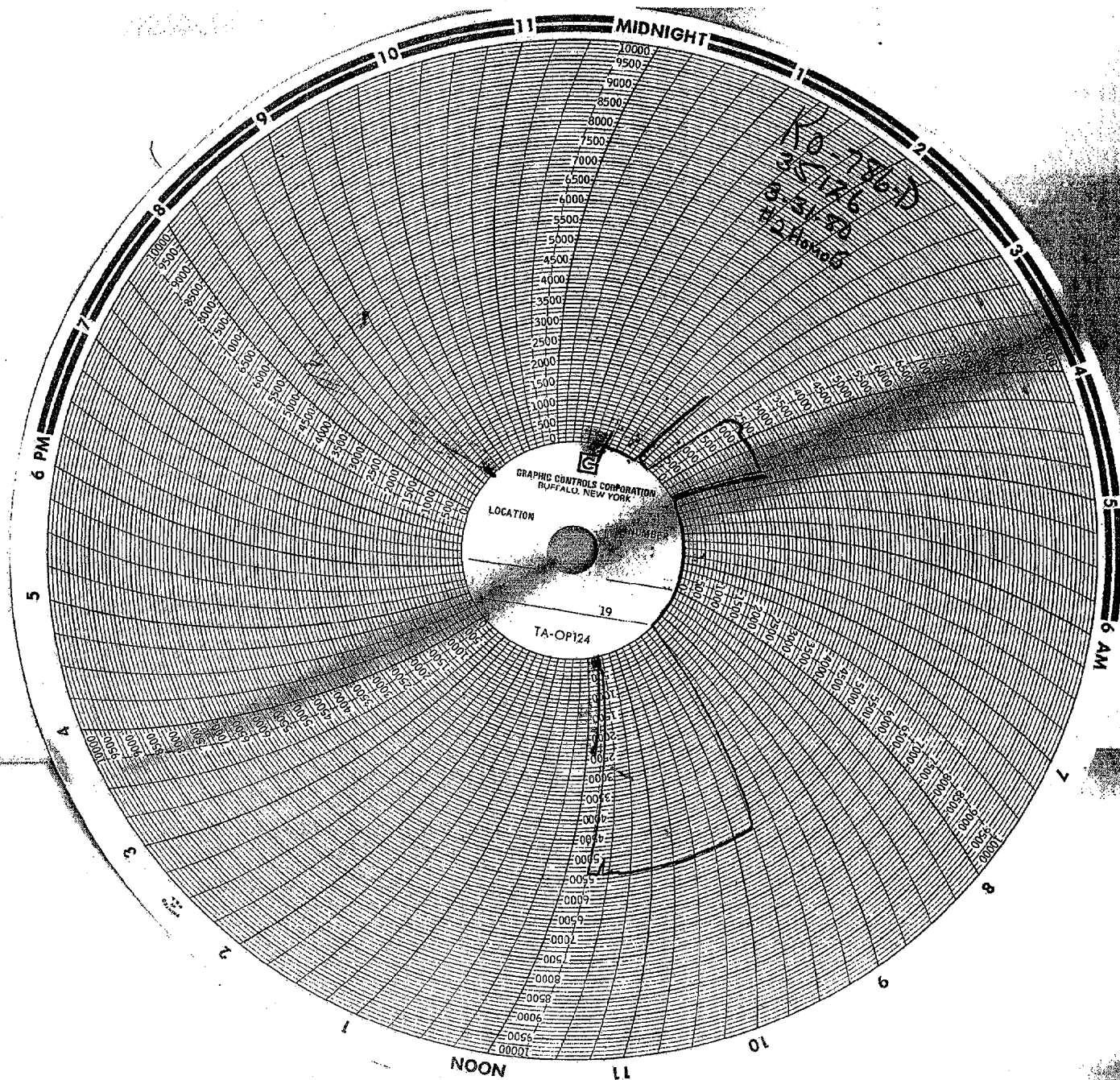
EQUIPMENT	PAGE	CG 04	CODE	K0-786-D (R)	EST. WGT	4962	LBS	USE LBS	N CODE	ACT LBS
SV	25	When S-20 heating complete, Record: pH	10.0	(9.6-10.2)						
6	26	Set V-343 acid pump at 72 setting (+225 minutes)								
	27	Set V-349 silicate pump at 66 setting (+180 minutes)								
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike								
	29	Record: Start Finish Minutes								
		V-343 2:10 P	5:55 PM							
		V-349 5:10 PM	5:10 PM							
		Record: Time V-343 V-349 SV Normal								
		at 20 min 2:30 P (47) 9.7 (20) 20 9.8 9.3-10.0								
		40 min 2:50 P (43) 9.3 (17) 16.7 9.8 9.3-10.0								
		1 hr 3:10 P (38) 3.9 (15) 15 9.8 9.3-10.0								
		2 hrs 4:10 P (24) 2.6 (7) 7 9.9 9.3-10.0								
		3 hrs 5:10 P (10) 1.2 (0) 1 7.9 9.3-10.0								
		Finish 6:55 P - (0)								
		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 7%							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 3.3 (3.3-3.7)								
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH							15-A	
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes								
	41	Record: pH 4.2 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH Assume 7%							27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%							7-D	
		Siphon N-7-D into SV								
	42	Stop agitator								
		START FINISH OPTR								
		7:11 7:30 PM 1:40-2:1								
		3:10 PM 7:30 PM 2:37-3:20								



U.S. DEPARTMENT OF COMMERCE, BUREAU OF ECONOMIC ANALYSIS, BUFFALO, NEW YORK

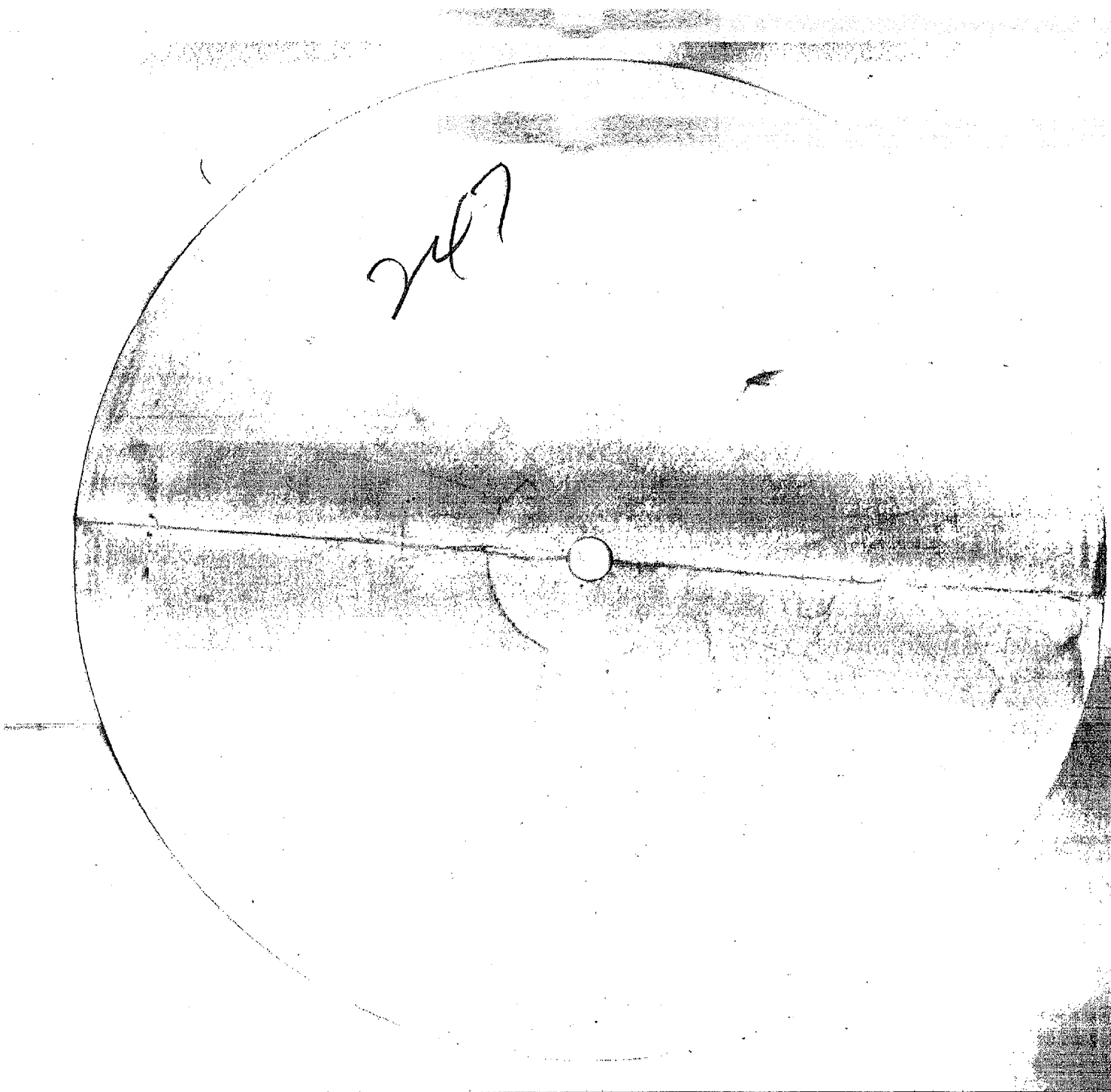
N32509.01

DUP050461539



N32509.02

DUP050461540



DUP050461541