

(262), 247

115R⁹⁹

4C-2

MAKING INSTRUCTIONS: BATCH UNIT

CG 03 CODE KY-907-D PKG.

EST. WGT. 2437 2737-LBS.

STD. HRS.

TIME

M

14 YC-2-B 93 4 Lot 23769, 2000#

14 YC-2-B 93 4 Lot 23964, 2000#

14 YC-2-B 93 4 Lot 23968, 1357#

2087 23484 300

Total Wgt 8387# (Req)

D.V.

PROCESSES

APPROVED BY

() KY-907-D (F) EWK 12-12-77

() Alternate () DCG 12-14-77

() () MTW 12-15-77

() () FWP 02-13-79

TYPED BY

emw021479

Homog² 3-2nd Pass

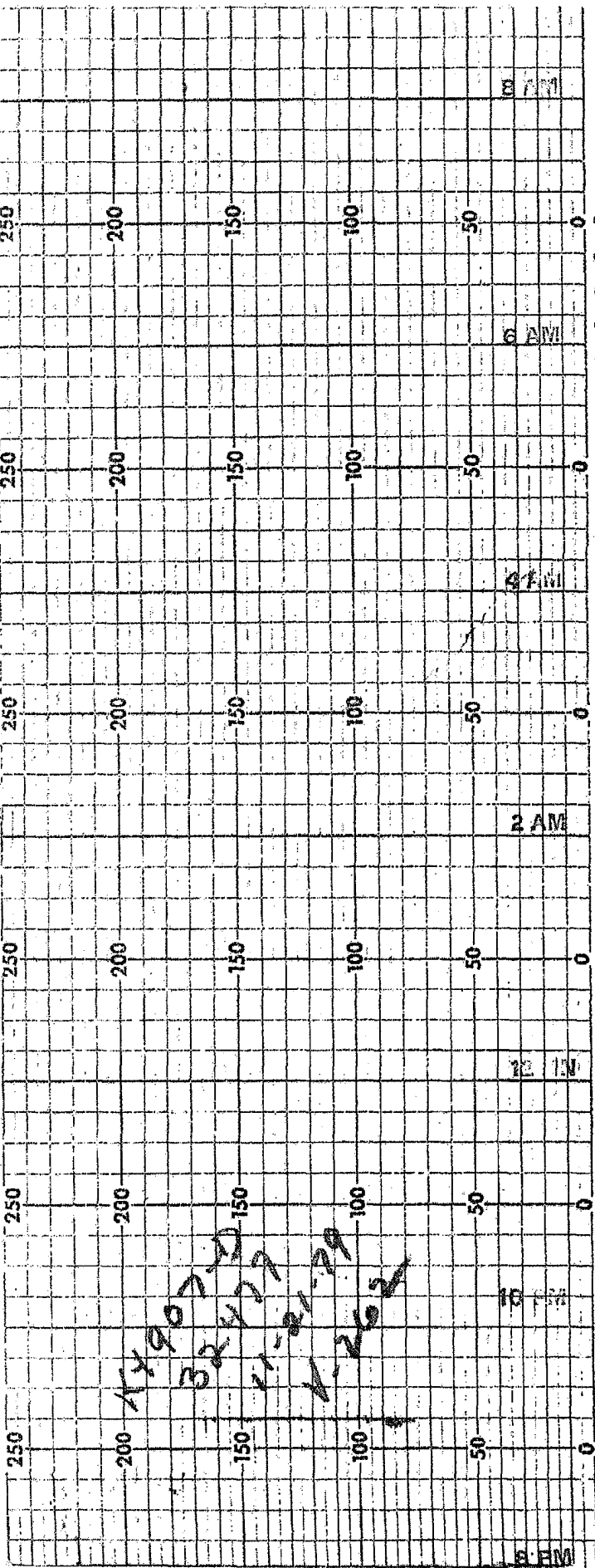
NON-BLEEDING

IPMENT	NAME:	KROLOR® YELLOW MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203	1	Run 50" (827 G) water into V-203			
&	2	Weigh in drum & pour in	790	32-D	790
205	3	Dump in & stir 5 min	113 x 50	YC-2-B	5650
1		Record: Start 12-20-PM. 23769			
		Fin 1:30 PM. 23764			
		23968			
		23484			
	4	Adj to 80" (1360 G)			
	5	Pump V-203 thru Homog at 2400-2600 psi into V-205			
	6	When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7	Record: V-205 Vol 43 " & adj to 54" (1900 G)			
	8	Inspect Homog strainer & clean if necessary			
SV	9	Run 7" (200 G) water into V-262 & install temp chart			
&		& start agitator			
205	10	Pump V-205 thru Homog at 4800-5200 psi into SV-262			
12		Record: Time Start 6:00 AM Total Min 115			
		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. Rinse in using Hot Water			
349	12	While Homog, run 6" (284 G) water into V-349			
&	13	Run ± 1000 # water into V-384 & heat to 110-120°F			
384	14	Weigh into V-384 & pump to V-349	✓ 2150	32-D	2150
3	15	Run ± 1000 # water into V-384 & heat to 110-120°F			
	16	Weigh into V-384 & pump to V-349	2150	32-D	2150
	17	Run ± 1000 # water into V-384 & pump to V-349			
	18	Adj V-349 to 25" (1163 G) & stir 15 min or longer			
	19	Record: 086'1.127 (46.7 ± 0.2) (1.126 - 1.130)			
SV	20	When S 11 Homog complete, adj SV to 21" (2100 G)			
4	21	Record: pH 10.4 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon into SV & Record: pH 11.2			
	22	Heat to 190-194°F in 35-45 min & Record: HT OF & Rec OF			
		NOTE: Strike must be started immediately on completion of heating			
343	23	While heating SV, run 56" (1520 G) water into V-343			
&	24	Meter in from V-386 M76, 9.58#/Gal 60.5 Gal		27-D	647
386	25	Stir 15 min or longer			
5	26	Record: 086'1.031 (4.6 ± 0.1) (1.030 - 1.032)			

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PMENT	PAGE 2	CG 03	CODE KY-907-D (F)	EST. WGT.	8387 LBS.	USE LBS.	N CODE	ACCT LBS.
SV 6	27	When S 22 heating complete, Record: pH <u>10.0</u> (9.6-10.2)						
	28	Set V-343 acid pump at 69 setting (± 255 min)						
	29	Set V-349 silicate pump at 60 setting (± 210 min)						
	30	Immediately meter in V-343 & 349, maintain SV at 190-194°F during strike						
	31	Record: Start Fin Min						
		V-343	1255	5:30 PM	275			
		V-349	1255	9:45 PM	230			
		Record:	Time	V-343 in	V-349 in	SV pH	Normal pH	
		at 20 min	1:10	(52)	(22)	9.9	9.3-10.0	
		40 min	1:35	(48)	(20)	9.9	9.3-10.0	
		1 hr	1:55	(43)	(18)	9.8	9.3-10.0	
		2 1/2 hrs	3:10	(27)	(7)	9.7	9.3-10.0	
		3 1/2 hrs	4:25	(10)	(0)	9.7	9.3-10.0	
		Finish	5:10	(0)	(3)	9.5	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%						
	32	Sift in					27-D 128-A	300
357 7	33	Run 29" (257 G) water into V-357 & heat to 135-140°F						
	34	Pump in & stir to dissolve for S 62				400	15-A	400
302 8	35	Add 24" (294 G) water to V-302						
	36	Add & stir 2 min for S 64				Assume 50%	140 7-D	70
PT 9	37	During strike pump into PT				760	169-A	760
	38	Pump in				84	155-A	84
	39	Pump in				84	160-A	84
	40	Stir 10 min with lightning mixer for S 44						
356 10	41	During strike, run 20" (350 G) water into V-356						
	42	Turn on steam						
	43	Add to 26" (447 G) at 82°C						
	44	Pump PI mixture from S 40 thru undersurface distributor A F A P						
	45	Rinse PT with hot water from hot water mixer & pump in						
	46	Shut off pump						
	47	Stir 30 min at 82°C for S 56						
	48	Do not shut off agitator						
SV 11	49	When V-349 MTY, rinse in with minimum water then set pump to zero setting						
	50	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	51	Heat to 198-200°F in 5-10 min						
	52	Close water line & discharge valves at stearate pump						
	53	Open V-356 discharge valves to stearate pump inlet						
	54	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer						
	55	While Homog water at 2900-3100 psi, open Homog discharge valve to SV & close valve to sewer						
	56	Immediately open searate pump discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 psi						
		Maintain SV at 198-200°F						
	57	While Homog V-356 to SV, shut off water valve at stearate pump A S A P						

JIPMENT	PAGE 3	CG 03 CODE KY-907-D (F) EST. WGT.	8387 LBS.	USE LBS.	N CODE	ACC LBS.
SV	59	When Homog complete, rinse in V-356 with hot water from hot				
11		water mixer				
cont't	59	When S 59 complete, turn off Homog & stearate pump				
	60	Stir 5 min at 198-200°F				
	61	Shut off steam				
	62	Run in V-357 from S 34 & stir 5 min				
		Record: pH <u>4.1</u> (3.3-3.7)				
	63	If necessary, adj pH to 3.3-3.7 (DOWNWARD ONLY) &				
		Record: pH <u>3.7</u>				
	64	Run in N-7-D from S 36 in 4-6 min & stir 5 min		70	15-A	70
	65	Record: pH <u>5.1</u> (4.2-4.4) & if necessary, adj to pH 4.2-4.4 &				
		Record: pH <u>4.2</u>				
		(Dilute 10 parts water to 1 part N-7-D)		15	27-D	35
		(Dilute 10 parts water to 1 part N-7-D)			7-D	
		Siphon N-7-D into SV				
	66	Do not stop agitator				
	Step	V-262 (20) RPM	V-243, 244, 246, 247			
	9	2"	4"			
	20	21"	42"			
	START	FINISH	OPTR			
	7:00P	11:00P	27-126			
	11:00P	7:00AM	28-5-54			
	7AM	3PM	28-2-201			
	3:00PM	9:30PM	409-223			

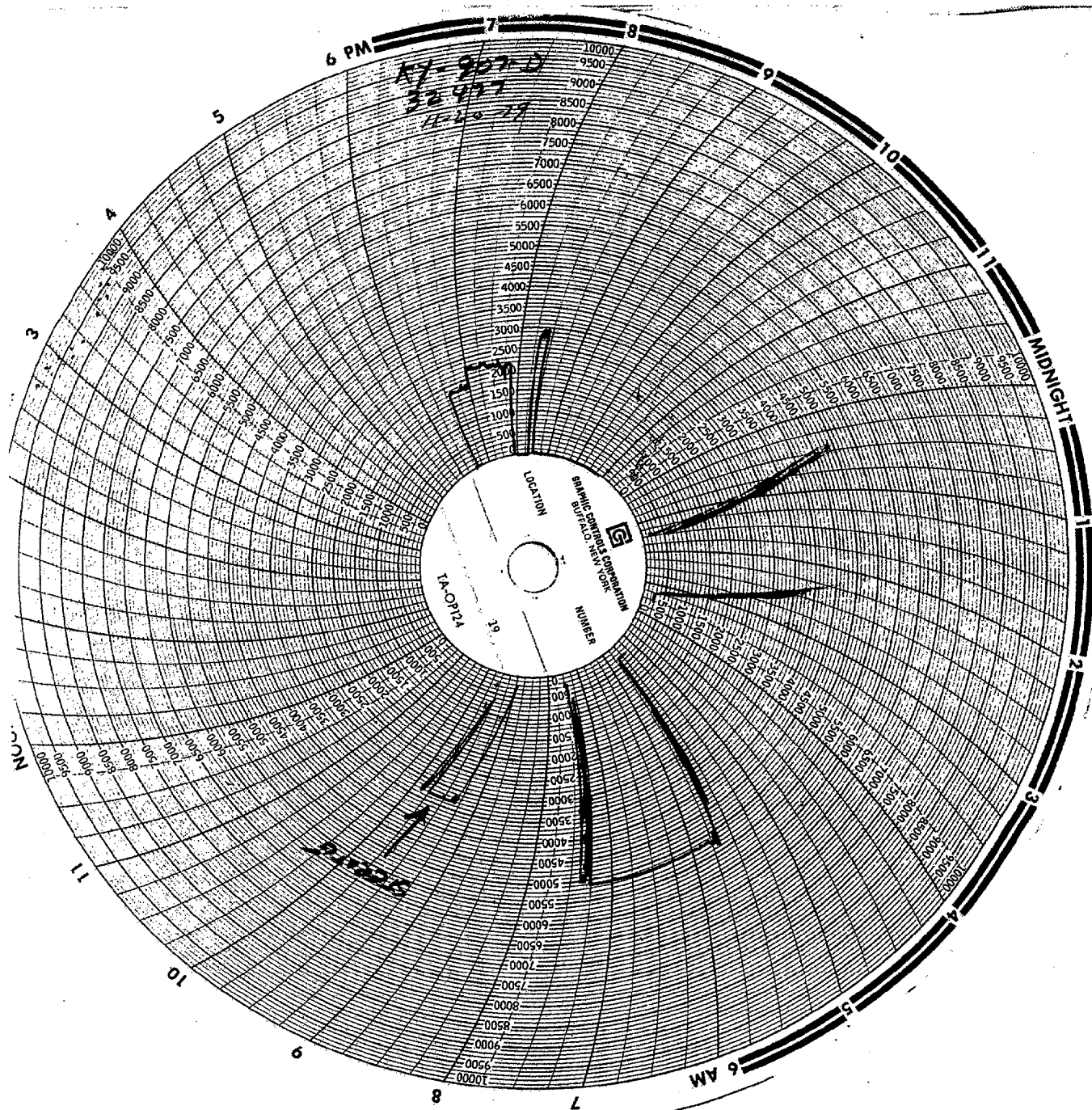


GRAPHIC CONTROLS CORPORATION

No. 215A350

DUP050456350

N32039.01



DUP050456351

N32039.02

AGG
100
100

N32039.03

DUP050456352