NOV - 5 1979

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244, 246, 247, (262) G.V. D.V.

PROCESSES		APPROVED BY
( ) KY-788-D	( )	EWK 10/19/77
( ) Alternate	( )	DCG 10/28/77
( )	( )	MTW 10/26/77
( )	( )	
TYPED BY		
jlc 11/2/77		

CG 03 CODE KY-788-D PKG.

→ NOV-8 32601

EST. WGT. 1648 LBS.

NOV 10 1979

STD. HRS. TIME 5:PM

14 YC-3-B 93 4 Lot 23872, 2000#
14 YC-3-B 93 4 Lot 23882, 2600#
14 YC-3-B 93 4 Lot ____, ____#

Homog #4 - 1ST Pass
#304 - 2ND Pass

Total Wgt. 6248# (REQ ____)

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® Yellow - Light	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1	Run 39" (645 G) water into V-203			
	2	Weigh in drum & pour in	610	32-D	610
	3	Dump in & stir 5 min LOT	92 x 50	YC-3-B	4600
		Record: Start 5:00 PM 23872	2000		
		Fin 7:45 PM 23882	2600		
	4	Adj to 75" (1275 G) 2400-2600			
	5	Pump V-203 thru Homog at 1800-2200 psi into V-205			
	6	When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
→	7	Record: V-205 Vol 41 " & adj to 60" (2100 G)			
	8	Inspect Homog strainer & clean if necessary			
SV & 205 2	9	Run 2 " (200 G) into V-262 install temp chart & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into SV 262			
CHANGED DUE TO HYDRO	11	Record: Time Start 2:30 PM Total Min 140			
		Note: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-205			
		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" (284 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	2150	32-D	2150
	15	Run ± 1000# water into V-384 & pump to V-349			
	16	Adj V-349 to (20") (946 G) & stir 15 min or longer			
	17	Record: Be' 10.8 (10.8 ± 0.2)			
SV 4	18	When S 11 Homog complete, adj SV to 24 " (2420 G)			
	19	Record: pH 12.10 & adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D Assume 50%	36	7-D	18
		Siphon into SV & Record: pH 11.1			
	20	Heat to 190-194°F in 35-45 min (V-262) or in 55-65 min (V-243, 244, 246, 247)			
		Record: HT ____°F & Rec ____°F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 45" (1237 G) water into V-343			
	22	Meter in from V-386 M 7/ , 7.42 #/Gal 33.8 Gal		27-D	318
	23	Stir 15 min or longer			
	24	Record: Be' 2.6 (2.5 ±0.1)			

K 13829 REV.

N32204

V-262

EQUIPMENT		PAGE 2 CG 20 CODE KY-788-D EST. WGT. 6248 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete, Record: pH 9.8 (9.5-10.1)			
	26	Set V-343 acid pump at 64 setting (± 225 min)			
	27	Set V-349 silicate pump at 57 setting (± 180 min)			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	29	Record: START FIN MIN			
		V-343 8:30A			
		V-349			

Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	8:50A	(42)	(18)	9.6	9.3-10.0
40 min	9:10A	(38)	(15)	9.6	9.3-10.0
1 hr	9:30A	(34)	(13)	9.6	9.3-10.0
2 hrs	10:30A	(22)	(6)	9.6	9.3-10.0
3 hrs	11:30A	(11)	(0)	9.6	9.3-10.0
Finish	12:15P	(0)	(0)	7.5	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% — 27-D

330 7	30	Run 20" (392 G) water into V-330 & heat to 160-170°F			
	31	Add in 12-13 min	600	530-A	600
	32	Stir 5 min & Record: pH 10.1 (9.5-10.5)			
	33	Stir 20 min or longer to dissolve for S 46			
357 8	34	Run 29" (210 G) water into V-357 & heat to 135-140°F			
	35	Dump in & stir to dissolve for S 42	415	15-A	415
302 9	36	Run 33" (403 G) water into V-302			
	37	Add & stir 2 min for S 44 Assume 50%	400	7-D	200
SV 10	38	When V-349 MTY, rinse in with minimum water then set pump at zero setting			
	39	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	40	Turn off steam			
	41	Sift in 4 bags	200	128-A	200
	42	Run in V-357 from S 35 & stir 5 min			
	43	Record: pH 3.3 (3.7-4.2)			
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min			
	45	Record: pH 9.35 (9.0-9.5) & if necessary, adj to pH 9.0-9.5 & Record: pH _____ Assume 78%		27-D	
		Dilute 10 parts water to 1 part N-7-D Assume 50%		7-D	
		Siphon N-7-D into SV			
	46	Run in V-330 thru 20 mesh screen & stir 20 min			
313 11	47	Run 15" (222 G) water into V-313 & dump in	230	20-A	230
	48	Stir 5 min to dissolve for S 49			
SV 12	49	Run V-313 into SV in 15-20 min			
	50	Stir 15 min			
	51	Record: pH 9.5 (9.0-10.0)			
	52	Stop agitator			

START	FIN	OPTR
7:45P	11:00P	235-301
11:00PM	7:00AM	438-405

Step 7:00A — V-262 (20 RPM) V-243, 244, 246, 247

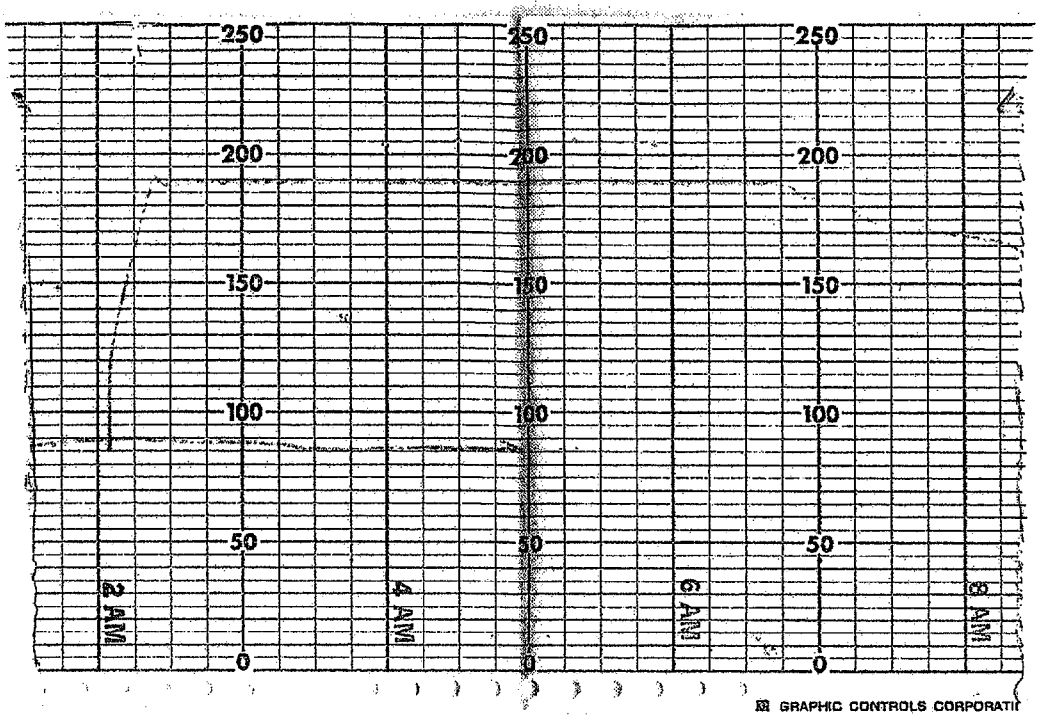
9	2"	2:40P	4"	120-27
18	24"		47"	

3/4 HR → DELAY CHANGED OVER TO #4 HOMO 2ND PASS

TIPE FROM VAT 205 TO PUMP SPRUNG A LEAK! = 3 KEEPS CUTTING OUT.

K 13830 REV.

DUP050457063



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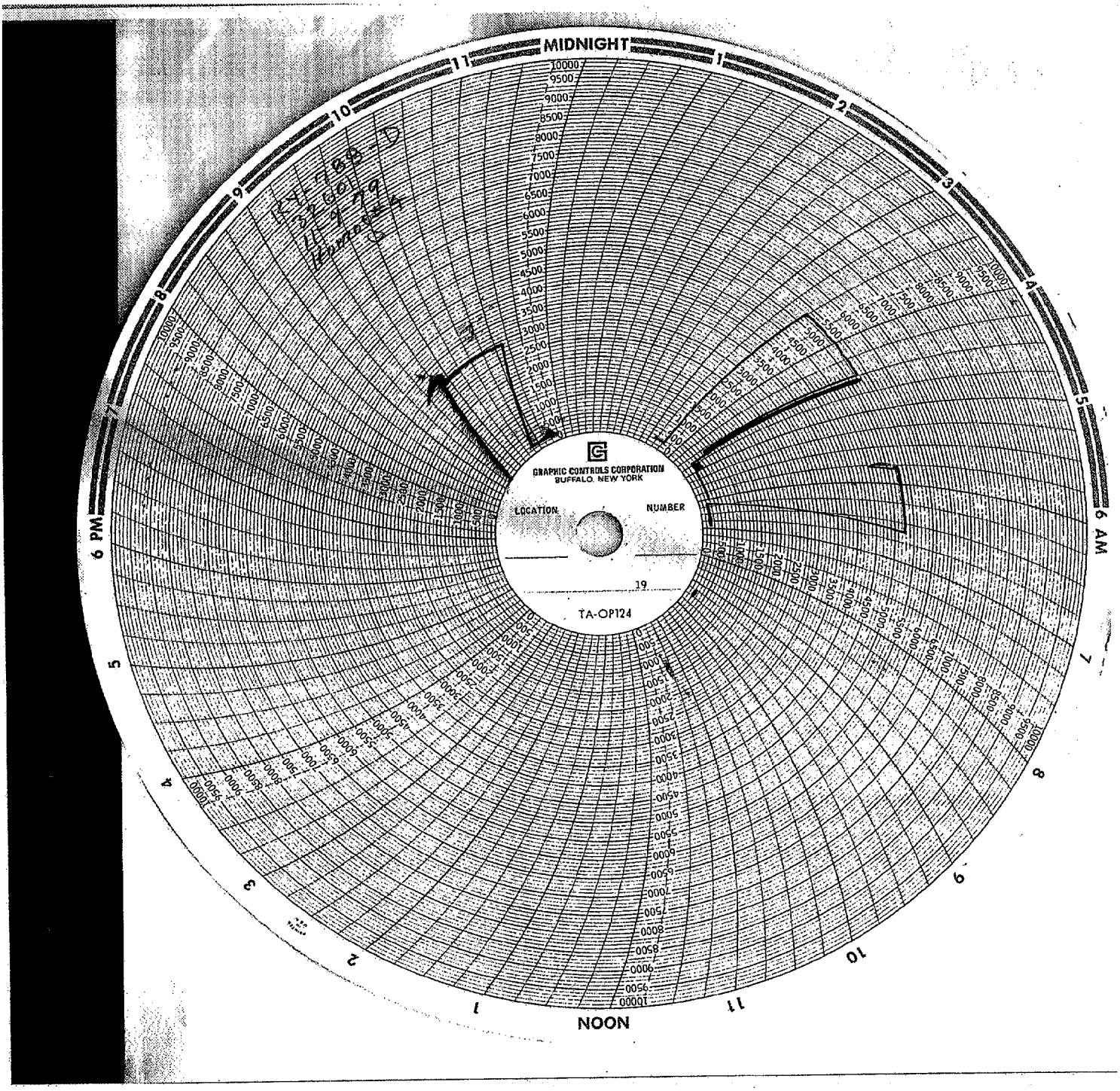

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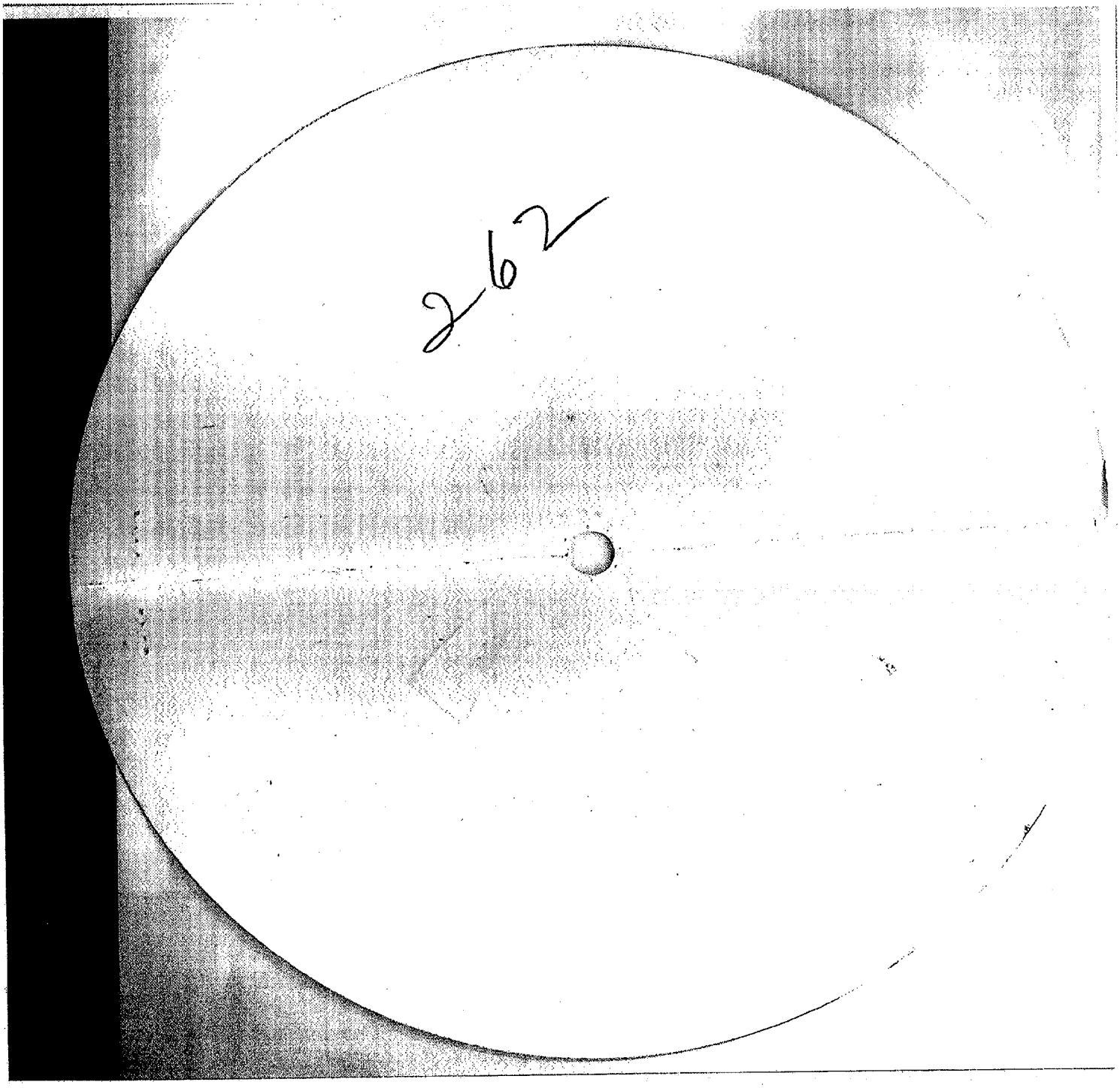
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