

EMENT	PAGE 2 CG 04 CODE KO-789-D (1) EST. WGT. 5199 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	25 When S 20 heating complete, Record: pH 10.2 (9.6-10.2)			
	26 Set V-343 acid pump at 76 setting (+225 minutes)			
	27 Set V-349 silicate pump at 60 setting (+180 minutes)			
	28 Immediately meter in V-343 and V-349. Maintain SV at 190-194°F during strike			
	29 Record: Start Finish Minutes			
	V-343 10:45 1:34 PM 2:35			
	V-349 1:11 PM 1:34 PM 1:87 1/2			
	Record: TIME V-343 V-349 SV NORMAL			
	INCHES INCHES pH pH			
	at 20 min 11:05 (50) 51 (19) + 10.0 9.3-10.0			
	40 min 11:50 (45) + (18) + 10.0 9.3-10.0			
	1 hr 12:40 (40) 41 (14) + 10.0 9.3-10.0			
	2 hrs 1:25 (26) 27 (7) + 9.9 9.3-10.0			
	3 hrs 2:10 (11) + (0) ± 1 9.8 9.3-10.0			
	Finish 2:30 PM (0) 7.8 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 33" (238 G) water into V-357 and heat to 135-140°F			
7	31 Dump in and stir to dissolve	530	15-A	530
102	32 Add 42" (514 G) water to V-302			
8	33 Add and stir 2 minutes	Assume 50% 330	7-D	165
SV	34 When V-349 MTY, rinse in with minimum water then set pump at zero setting			
2460 3460	35 When V-343 MTY, rinse in with minimum water then turn off pump motor			
	36 Stir 60 minutes at 190-194°F then turn off steam			
	Record: Start 2:40 PM			
	37 Run in V-357 from S 31 and stir 5 minutes			
	38 Record: pH 3.0 (3.4-3.8) and if necessary, adjust (down only) to 3.4-3.8 and Record: pH		15-A	
	Note: Dissolve extra N-15-A in water at 135-140°F in drum, use ±30 Gal water to 50# N-15-A. Stir SV 5 minutes after each addition			
	39 Run in N-7-D from S 33 in 10-12 minutes and stir 5 minutes			
	40 Record: pH 6.5 (6.2-6.4) and if necessary, adjust to pH 6.2-6.4 and Record: pH 6.3	Assume 77% 2	27-D	1
	(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
	Siphon N-7-D into SV			
	41 Pour in and stir 15 minutes	✓ 50	978-A	50
	42 Stop agitator			
	START FIN OPTR			
	3:00 P 11:00 P 2:35-1:40			
	1:10 PM 1:40 PM 2:35-4:10			
	7:10 AM 3:10 PM 5:47-1:20			
	3:00 P 4:50 PM 2:35-3:20			

~~PUNCHED & CHECKED~~

APR 25 1980

MAKING INSTRUCTIONS: BATCH UNIT

V. 246, 247 **245** C.V.

D.V.

G 04 CODE KO-789-D PKG.

PROCESSES APPROVED BY

EST. WGT. 1199 LBS.

STD. HRS. 10.8 TIME **7A** M

() KO-789-D (1) ENK 9-21-76
() () DCG 9-21-76
() () MTW 10-2-76
() ()

TYPED BY JLC 10-8-76

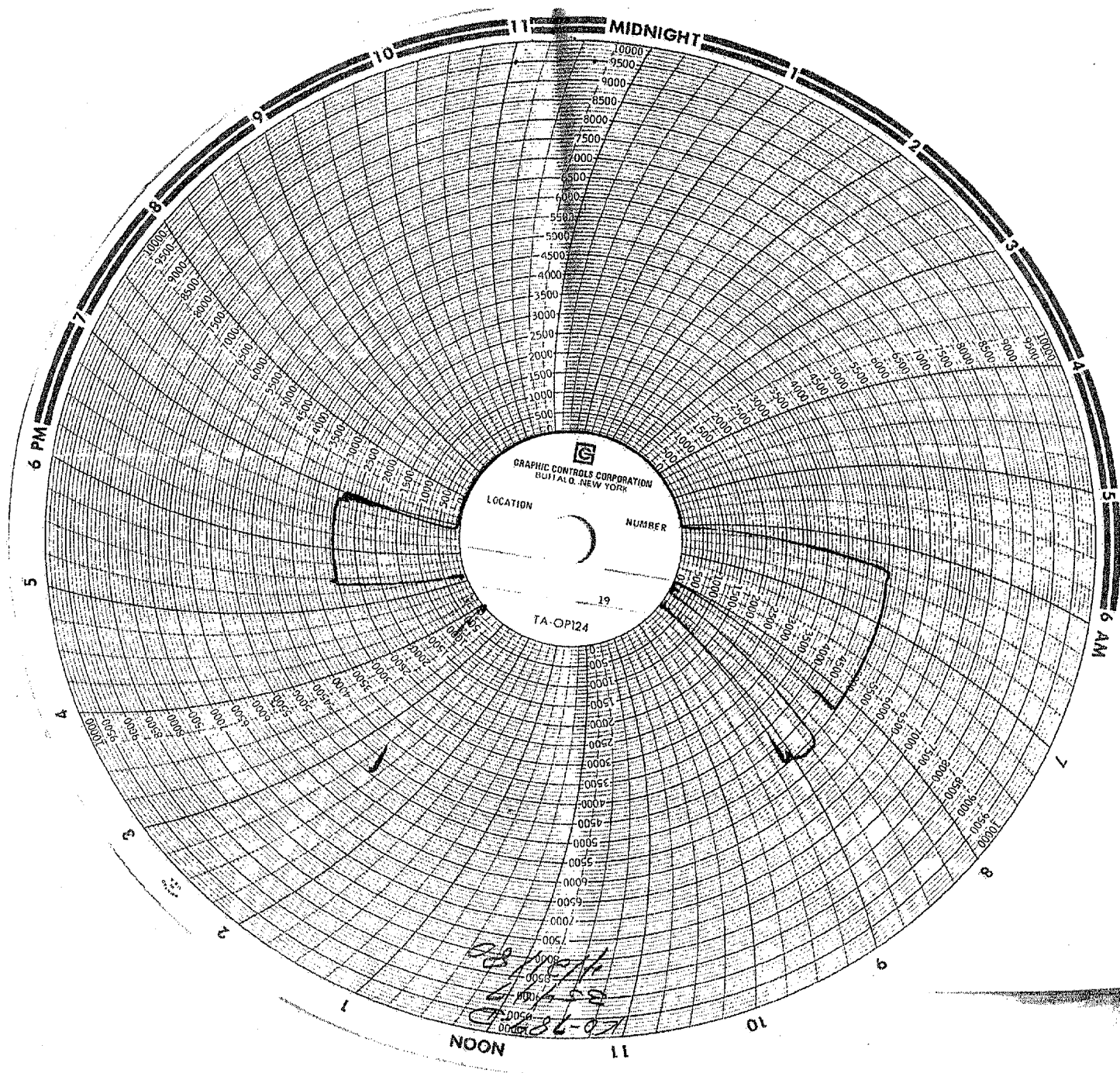
01 YC-16-B 93 4 33978 500#
01 YC-16-B 93 4 34184 400#
01 YC-16-B 93 4 34186 100#

OK
HP
01 YC16B 93 34653 3000#
7/11
11-22-1980

Total Weight 5199 # (Req. _____)

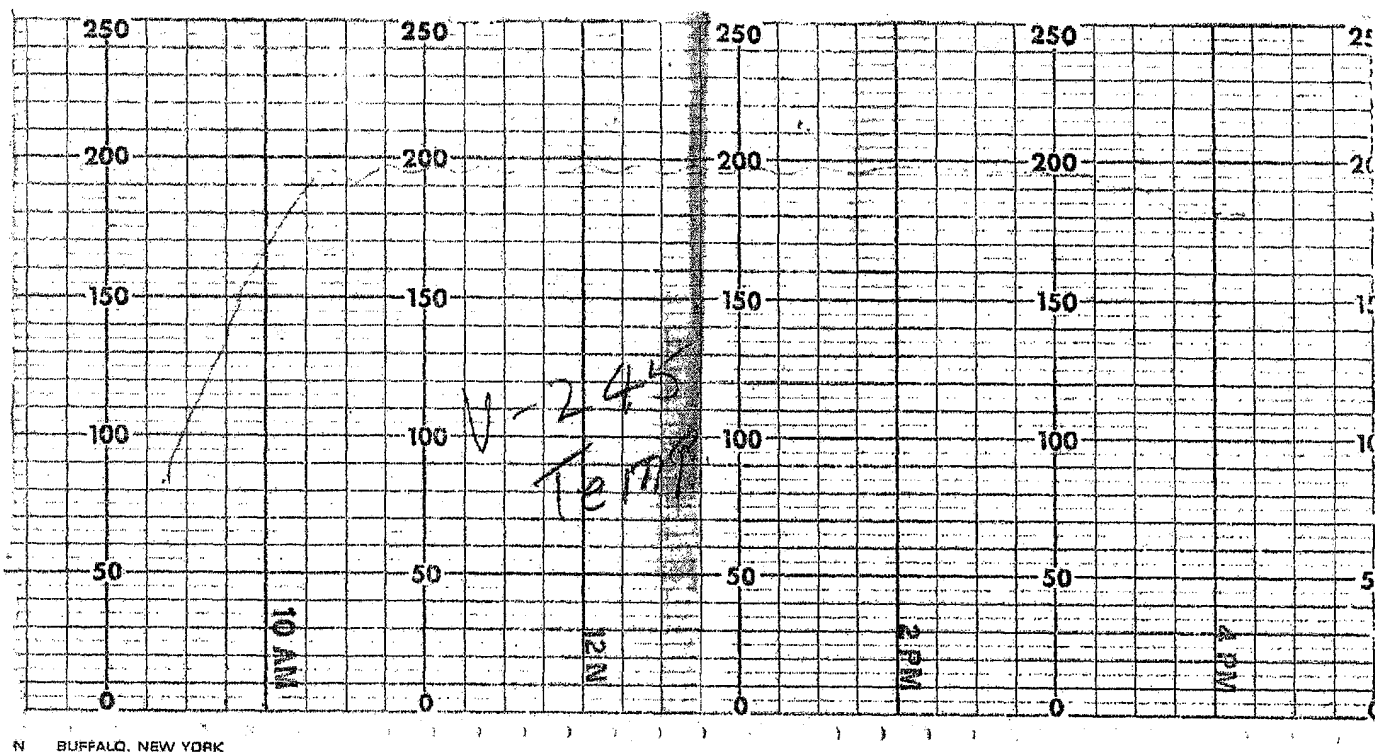
NON-BLEEDING

INSTRUMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
	"KROLOR" ORANGE Y			
211	Run 2" (560 G) water into V-211. RUN AGITATOR ON HIGH SPEED.			
&	Weigh in drum and pour in	530	32-D	530
208	Dump in and stir 5 minutes			
1	Record: Start 12:25. Fin 2:22. 75" (1256.)	39653 33978 34184	YC-16-B	4000
	Adj to 70" (1200 G) 2900-3200	34186		
	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 minimum water			
	Record: V-208 Vol 54" and adjust to 60" (2100 G)			
	Inspect homog strainer and clean if necessary			
	DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED			
208	Run 10" (514 G) water into V-245 and start agitator and			
&	Install temperature chart			
SV	Pump V-208 thru Homog at 4800-5200 psi into SV-245			
2	Record: Time Start 1:41 Total Minutes 150			
	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			
&	Run 1000# water into V-384 and heat to 110-120°F			
384	Weigh into V-384 and pump to V-349	3085	32-D	3085
3	Run 1000# water into V-384 and pump to V-349			
	Adj V-349 to 21" (1000 G) and stir 15 minutes or longer			
	Record: 986' 1108 (14.3 to 2) - (1106-1109)			
SV	When 5 10 Homog complete, adjust SV to 66" (3392 G)			
4	Record: pH 10.9 and adjust to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon N-7-D into SV and Record: pH 11.2	1.0	7-D	5
	Heat to 190-194°F in 55-65 minutes and Record: HT. F and Rec F			
	Note: Strike must be started immediately on completion of heating			
	While heating SV, run 54" (1485 G) water into V-343			
	Meter in from V-386 M 29.9124/Gal 150.4 Gal		27-D	460
	Stir 15 min or longer			
	Record: 1021 (2.4 to 0.1) (1021-1023)			



N32315.01

DUP050457541



N32315.02

DUP050457542