

DEC 28 1979

MAKING INSTRUCTIONS: BATCH UNIT

I.V. (246)

C.V.

D.V.

OG 04 CODE KO-786-D PKG.

JAN-2 33575

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 7 A M

01 YC-10-B 93 4 33362 1850 #
 01 YC-10-B 93 4 33351 1200 #
 01 YC-10-B 93 4 33355 1050 #

PROCESSES		APPROVED BY	
() KO-786-D	(P)	EWK 9-21-76	
()	()	DCG 9-21-76	
()	()	MTW 10-1-76	
()	()		
TYPED BY			
JIC 11-16-76			

Total Weight 4962# (Req. 2508)

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 60" (990 G) water in V-211 and add Assume 50%	30	7-D	15
&	2 Weigh in drum and pour in V-211	270	32-D	270
208	3 Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
1	Record: Start 8:15 A.M. 33362 1850			
	Fin 10:15 A.M. 33351 1200			
	75" (1275 G) 33355 1050			
	4 Adjust to 80" (1370 G) 4100			
	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 38 " and adjust to 50" (1840 G)			
	8 Inspect homog strainer and clean if necessary			
208	9 Run 15" (771 G) water into V-246 and start agitator and install temperature chart			
&	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
SV	Record: Time Start 9:10 AM Total Minutes 145			
2	Note: If homog pressure falls below 4800 psi, 3-Way Va will recirculate slurry to V-208			
	11 When V-208 MTY, run in 5" (240 G) water and pump thru Hc at 4800-5200 psi			
349	12 While Homog, run 6" (284 G) water into V-349			
&	13 Run ±1000# water into V-384 and heat to 110-120°F			
384	14 Weigh into V-384 and pump to V-349	2400	32-D	2400
3	15 Run ±1000# water into V-384 and pump to V-349			
	16 Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	17 Record: 9.1 mL 1.079 (10.9 ±0.2) 1.078 - 1.081			
SV	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	19 Record: pH 10.8 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			
	20 Heat to 190-194°F in 55-65 minutes & Record: HT 192°F and Rec 191°F			
	Note: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 51" (1400 G) water into V-343			
&	22 Meter in from V-386 M 1 #/Gal 9.70 Gal 36.6 71.41		27-D	355
386	23 Stir 15 minutes or longer			
5	24 Record: 9.1 mL 1.018 (2.8 ±0.1) 1.017 - 1.019			

OK
FP

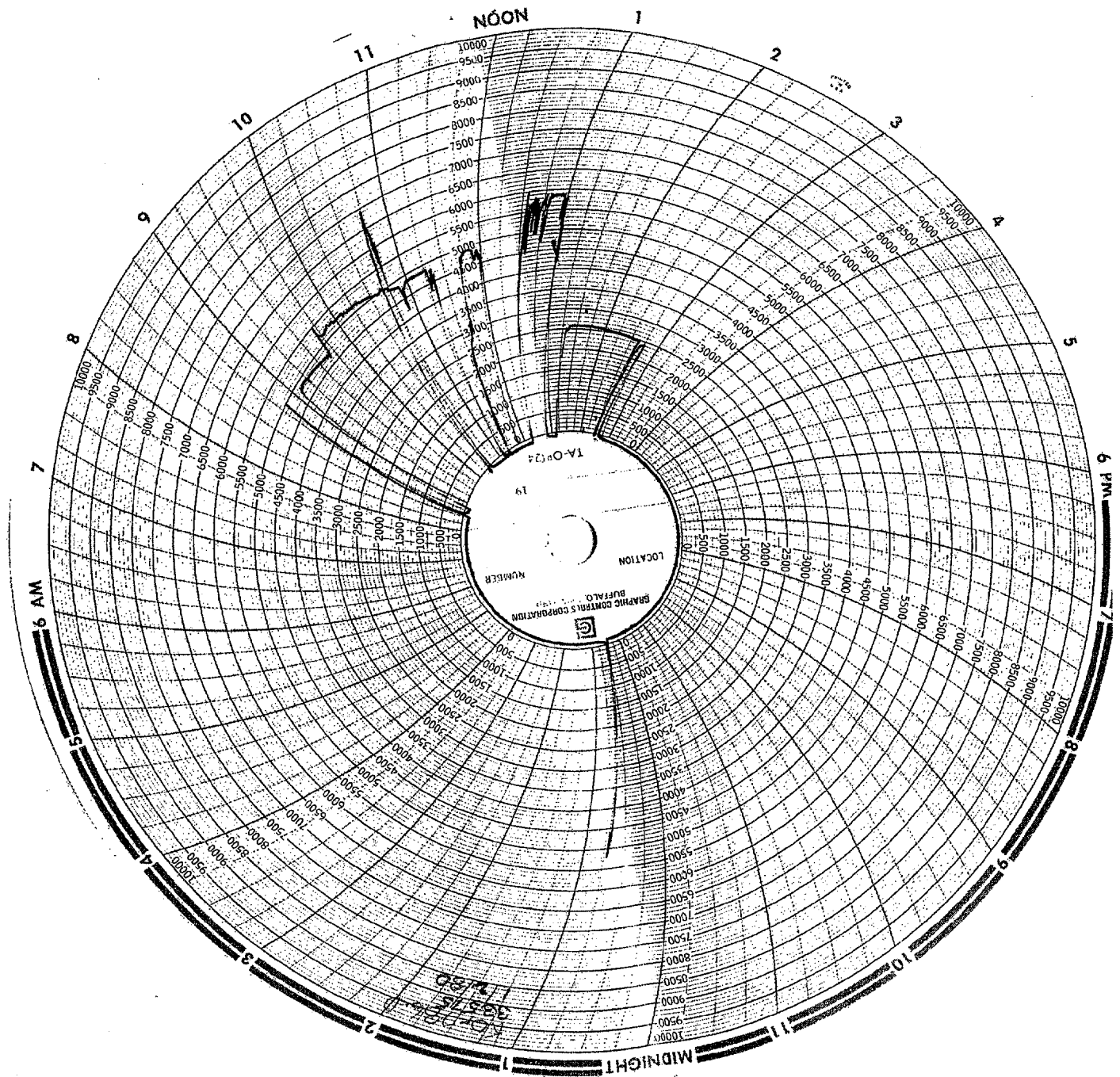
Homog #2

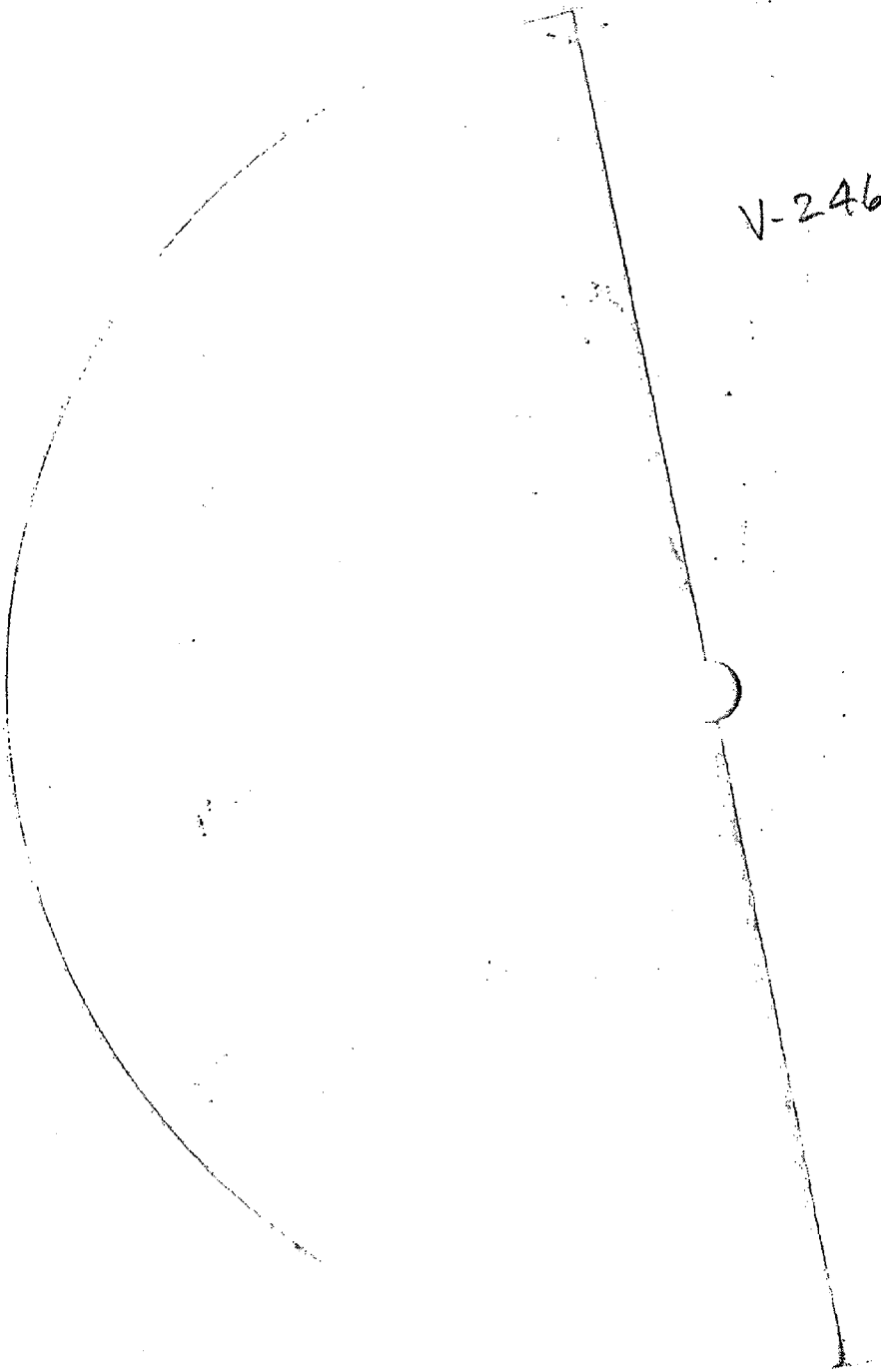
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V-246

EQUIPMENT	PAGE	CG	CODE	KO-786-D (M)	EST. WGT.	4962	LBS.	USE LBS.	N CODE	ACCY. LBS.
SV 6	25	When S 20 heating complete. Record: pH 9.6 (9.6-10.2)								
	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 1:35 PM 5:30 P 235								
		V-349 1:35 PM 4:40 P 185								
		Record: Time V-343 V-349 SV Normal								
		at 20 min 1:55 PM (47) 47 (20) 20 9.6 9.3-10.0								
		40 min 2:15 (43) 43 (17) 17 9.6 9.3-10.0								
		1 hr 2:35 (38) 39 (15) 15 9.6 9.3-10.0								
		2 hrs 3:15 (24) 26+ (7) 8 9.75 9.3-10.0								
		3 hrs 3:35 (10) 12 (0) 0 9.8 9.3-10.0								
		Finish 5:20 PM (0) 0 6.5 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	
302 8	30	Run 21" (150 G) water into V-357 and heat to 135-140°F								
	31	Dump in and stir to dissolve						300	15-A	300
	32	Add 42" (514 G) water to V-302								
	33	Add and stir 2 minutes Assume 50%						150	7-D	75
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump to zero setting								
	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 3.2 (3.3-3.7)								
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH 4.2							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 77%							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								
		3:00 P 11:00 P 235-301								
		1:00 PM 3:00 PM 320-704								
		3:00 P 6:15 PM 235-259								





V-246

