

V. 228 247

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

OG 04 CODE KO-786-D PKG.

DEC 20 33428

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 7 A.M.

01 YC-10-B 93 4 33059 700 # Bay 3 5BAGS
 01 YC-10-B 93 4 33057 400 # Bay 2 6BAGS
 01 YC-10-B 93 4 32895 3000 # Bay 2

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

32829
32991

Total Weight 4962# (Req. 0489)

NON-BLEEDING

SHIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 60" (990 G) water in V-211 and add Assume 50%	20 30	7-D	15/0
&	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 11:00 PM 32829 60 3,000			
	Fin 11:15 PM 33059 5 250			
	75" (12756) 32897 6 300			
	4 Adjust to 80" (1370 G) 32829 2 100			
	5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208 32901-9 450			
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-208 Vol 44" and adjust to 50" (1840 G)			
	8 Inspect homog strainer and clean if necessary			
208	9 Run 15" (771 G) water into V-247 and start agitator and install temperature chart			
&	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
SV	Record: Time Start 11:55 AM Total Minutes 100			
2	Note: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	11 When V-208 MTY, run in 5" (240 G) water and pump thru Homog 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: 1.080 (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 10.2 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 187 and Rec 197 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 8.2 #/Gal 1.81/Gal			
386	23 Stir 15 minutes or longer			
5	24 Record: 1.019 (2.8 ±0.1) 1.017-1.019			

8/100L

EQUIPMENT	PAGE	CG	CODE	KO-786-D (A)	EST. WGT.	4962	LBS.	USE LBS.	N CODE	A LBS.
SV	25			When S 20 heating complete. Record: pH	9.8	(9.6-10.2)				
6	26			Set V-343 acid pump at 72 setting (± 25 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	10:10	2:10 P	240			
				V-349	10:10	1:25 P	195			
				Record:	Time	V-343	V-349	SV	Normal	
					10:10	54 inches	22 inches	pH	pH	
				at 20 min	10:30	(47) 49	(20) -	9.6	9.3-10.0	
				40 min	10:50	(43) 44+	(17) +	9.6	9.3-10.0	
				1 hr	11:10	(38) 40	(15) =	9.6	9.3-10.0	
				2 hrs	12:10	(24) 26	(7) 8	9.6	9.3-10.0	
				3 hrs	1:10	(10) 12+	(0) 1+	9.6	9.3-10.0	
				Finish	2:10	(0)		3.2	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 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 2.7 (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 4.4 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH 4.2 Assume 77% (Dilute 10 parts water to 1 part N-7-D) Assume 50%				6	27-D	5
				Siphon N-7-D into SV					7-D	
	42			Stop agitator						
				START	FINISH	OPTR				
				7:00 AM	11:00 PM	407				
				11:00 PM	11:00 AM	145-144				
				7:00 A	2:50 PM	235-242				

V-247

