

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

C.V.

D.V.

CG 03 CODE KY-787-D

PKG. PUNCHED & CHECKED

PROCESSES

APPROVED BY

MAR-1 34841

EST. WGT. 1090 990 LBS.

MAR - 3 1980

OK

STD. HRS. 10.6 TIME

14 YC-2-B 93 4 Lot 2400, 2400#

14 YC-2-B 93 4 Lot #

14 YC-2-B 93 4 Lot #

() KY-787-D (R)

() Alternate ()

() ()

() ()

TYPED BY

NE 2/12/77

FWK 9/22/76

DCG 9/22/76

MTW 9/30/76

3390

Delay Rec VAT 262 AT 125 AM

Total Wgt. 3490# Req(

NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
60	(9906) "KROLOR" YELLOW-MEDIUM			
203	Run 33" (560-G) water into V-203. SET AGITATOR ON HIGH SPEED			
&	12 Weigh in drum & pour in	320	32-D	320
205	13 Dump in & stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start 12:30 PM Lot 24480	2400		
	Fin 1:30 PM			
	75" (12756)			
	4 Adj to 70" (1200 G) 2400-2600			
	5 Pump V-203 thru Homog # 3 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 " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if Necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
SV	9 Run 2" (514 G) water into V-262 Install temp chart & start agitator			
&	10 Pump V-205 thru Homog at 4800-5200 psi into SV-262			
205	Record: Time Start 1:30 AM Total Min			
2	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			
349	12 While Homog, run 6" (284 G) water into V-349			
&	13 Run ± 1000# water into V-384 & heat to 110-120F			
384	14 Weigh into V-384 & Pump to V-349	1840	32-D	1840
3	15 Run ± 1000# water into V-384 & pump to V-349			
	16 Adj V-349 to 7" (805 G) & stir 15 min or longer			
	17 Record: Be 1080 (10.95 ± 0.2) (1.079 - 1.082)			
	9/ml			
SV	18 When S 1V Homog complete, Adj SV to 2.4" (2470 G)			
4	19 Record: pH 10.8 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 Parts water to 1 part N-7-D) Assume 50%	30	7-D	15
	Siphon into SV & Record: pH 11.2			
	20 Heat to 190-194 F in 55-65 min & Record: HT F & Rec F			
	Note: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 39" (1070 G) water into V-343			
&	22 Meter in from V-386 M 19, 919 #/Gal 299 Gal		27-D	275
386	22 Stir 15 min or longer			
5	23 Record: Be 1017 (2.8 ± 0.1) (1.017 - 1.018)			
	3/ml			
	N-7 for 22 press	1000	2-D	500

V-262

EQUIPMENT	PAGE 2	CG03	CODE KY-787-D (R)	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete Record: pH <u>10.1</u> (9.5-10.0)						
	26	Set V-343 acid pump at 82 setting (± 150 min)						
	27	Set V-349 silicate pump at 72 setting (± 120 min)						
	28	Immediately meter in V-343 & 349, maintain SV at 190-193F during strike						
	29	Record: Start Finish Minutes						
		V-343	<u>5:40 AM</u>			<u>170</u>		
		V-349	<u>5:40 AM</u>			<u>130</u>		
		Record:	Time	V-343	V-349	SV	Normal	
				in	in	pH	pH	
		at 20 min	<u>6:4 AM</u>	(35)	(14)	<u>10.0</u>	9.3-10.0	
		40 min	<u>6:20 AM</u>	(30)	(11)	<u>10.0</u>	9.3-10.0	
		1 hr	<u>6:40 AM</u>	(24)	(9)	<u>10.0</u>	9.3-10.0	
		2 hrs	<u>7:40 AM</u>	(8)	(0)	<u>10.0</u>	9.3-10.0	
		Finish	<u>8:10 AM</u>	0		<u>7.5</u>	7.5-8.5	
		Note: If pH drops below 9.0 in 1st hr, stop pumps & see Supv.						
		If final pH is above 8.5 adj to 7.5-8.5 & Record: pH						
		Assume 77 %						
		27-D						
330 7	30	Run 20" (392 G) water into V-330 & heat to 80-100 °F						
	31	Add in 7-8 min						
	32	Stir 5 min & Record: pH <u>10.3</u> (9.5-10.5)						
	33	Stir 20 min or longer to dissolve for S 46						
357 8	34	Run 11" (80 G) water into V-357 & heat to 135-140 °F						
	35	Dump in & stir to dissolve for S-42						
		160 15-A 160						
302 9	36	Run 30" (360 G) water into V-302						
	37	Add & stir 2 min for S44						
		Assume 50%						
		180 7-D 90						
SV 10	38	When V-349 MTY, Rinse in with minimum water then set pump to zero setting						
	39	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	40	Turn off steam						
	41	Stir in 2 bags						
	42	Run in V-357 from S 35 & stir 5 min						
	43	Record: pH <u>3.3</u> (3.7-4.2)						
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
	45	Record: pH <u>8.0</u> (9.0-9.5) & if necessary adj to pH 9.0-9.5						
		& Record: pH <u>9.0</u>						
		Assume 77%						
		(Dilute 10 parts water to 1 part N-7-D)						
		Assume 50%						
		Siphon N-7 into SV						
	46	Run in V-330 thru 20 mesh screen & stir 20 min						
313 11	47	Run 10" (128 G) water into V-313 & dump in						
	48	Stir 5 min to dissolve for S 49						
		135 20-A 135						
SV 12	49	Run V-313 into SV in 15-20 min						
	50	Stir 15 min						
	51	Record: pH <u>9.5</u> (9.0-10.0)						
	52	Stop agitator						
		Do Not START						
		FINISH						
		OPTR						
		<u>3:00 PM</u>						
		<u>11:00 PM</u>						
		<u>2:35-2:59</u>						
		<u>7:40 AM</u>						
		<u>10:15 AM</u>						
		<u>120-101</u>						
		Step	V-262 (20 RPM) V-243, 244, 246, 247					
		9	5"					
		18	25"					
			10"					
			48"					



