

V. 243 244 246 247 262

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 03 CODE KY-795-D PKG.

PUNCHED & CHECKED

EST. WGT. 1170 938 LBS.

MAY - 8 1980

STD. HRS. 11.1

TIME

7P M

14 YC-2-B 93 4 Lot 24775.2000
 14 YC-2-B 93 4 Lot 24845.1700
 14 YC-2-B 93 4 Lot

PROCESSES		APPROVED BY	
() KY-795-D	(I)	EWK	10/5/76
() ALTERNATE	()	DCG	10/7/76
()	()	MTW	10/11/76
()	()		
TYPED BY			
NE 3/3/77			

Total Wgt. 4638

NON-BLEEDING

UPLMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	"KROLOR" YELLOW - MEDIUM			
203	11 Run 26" (416 G) water in V-203. RUN AGITATOR ON HIGH SPEED.			
205	12 Weigh in drum & pour in	500	32-D	500
1	13 Dump in & stir 5 min	Lot 74x50	YC-2-B	3700
263	Record: Start	24775		
	Fin 9.20	24845		
	75" (275 G)			
	4 Adj to 70" (1928 G) 2400-2600	37		
	5 Pump V-203 thru Homog # 3 at 1800-2200 psi into V-205 263			
	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-205 263 " & adj to 51" (1874 G)			
	8 Inspect homog, strainer & clean if necessary			
SV	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
	9 Run 5" (514 G) water into V-262. install temp charts & start agitator			
263	10 Pump V-203 thru Homog at 4800-5200 psi into SV			
	Record: Time Start 11:35 Total Min 1.56			
	Note: If Homog pressure falls below 4800 psi 3-way valve 263 will recirculate slurry to V-205 263			
	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			
384	13 Run 1000# water into V-384 & heat to 110-120°F			
3	14 Weigh into V-384 & pump to V-349	2030	32-D	2030
	15 Run 1000# water into V-384 & pump to V-349	2000		2000
	16 Adj V-349 to 29" (1372 G) & stir 15 min or longer			
	17 Record: Bk 1.05 (9.85 ± 0.2) (1.044-1.051)			
SV	18 When S-19 Homog complete, adj. to 2.5" (9495 G) (2496 G)			
4	19 Record: pH 10.6 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	32	1-D	16
	Siphon into SV & Record: pH 11.3			
	20 Heat to 190-194°F in 55-65 min & Record: HT 190°F & Rec 190°F			
	Note: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 69" (1898 G) water into V-343			
386	22 Meter in from V-386 M.32: 11.06 #/Gal Gal 28.2		27-D	446
5	23 Stir 15 min or longer			312
	24 Record: Bk 1.010 (2.3 ± 0.1) (1.010-1.012)			
SV	25 When S-20 heating complete Record: pH 10.1 (9.5-10.0)			
6	26 Set V-343 acid pump at 96 setting (±25 min)			
	27 Set V-349 Silicate pump at 82 setting (± 180 min)			
	28 Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			

Homog #3 - 1st Pass
 " 3 - 2nd "

MAY 1 1980

V-262

EQUIPMENT

PAGE 2 CG 03 CODE KY-795-D(I) ALT EST. WGT. 4878 LBS. USE LBS. N CODE AC LBS.

Record:	Start	Finish	Minutes		
V-343	11:20 P.M.	11:45	25		
V-349	1:20 P.M.	1:45	25		
Record:	Time	V-343	V-349	SV	Normal
		in 70	in 29	pH	pH
at 20 min	7:40 P.M.	(64) 63	(26) 26	100	9.0-10.0
40 min	8:00 P.M.	(58) 59	(23) 24	100	9.0-10.0
1 hr.	8:20 P.M.	(51) 53	(19) 20	100	9.0-10.0
2 hrs	9:20 P.M.	(33) 38	(10) 13	97	9.0-10.0
3 hrs	10:20 P.M.	(14) 22	(0) 4	97	9.0-10.0
Finish	11:05 P.M.	(0) 8		85	7.5-8.5

Note: If pH drops below 9.0 in 1st. hr. stop pumps & see Subv.

If pH. above 8.5 at final adj to 7.5-8.5

Record: pH Assume 77%

27-D

350 Run 15" (108 G) water into V-343 & heat to 135-140°F

Dump in & stir to dissolve for S 38

220

15-A

220

Drum 32 Weigh into 55 Gal Drum

Assume 50%

60

7-D

30

32 Fill with water & stir 2 min for S 40

SV 34 When V-349 MTY, rinse in with minimum water then set pump to zero setting

34 When V-343 MTY, rinse in with minimum water then turn off pump motor

9 36 Turn off steam

37 Sift in 3 bags

150

65
15-A

150

38 Run in V-357 from S 31 & stir 5 min

39 Record: pH 3.6 (3.3-3.7) & if necessary adj (down only) to 3.3-3.7 & Record: pH

15-A

Note: Dissolve extra N-15-A in water at 135-140°F in drum.

Use ± 40 Gal water to 50# N-15-A. Stir SV 5 min after each addition.

40 Siphon in N-7-D from S 33 in 4-6 min & stir 5 min

41 Record: pH 4.1 (4.0-4.2) & if necessary adj to pH 4.0-4.2

& Record: pH Assume 77%

27-D

(Dilute 10 parts water to 1 part N-7-D) Assume 50%

7-D

42 Siphon N-7-D into SV

42 Pour in & Stir 15 min

45

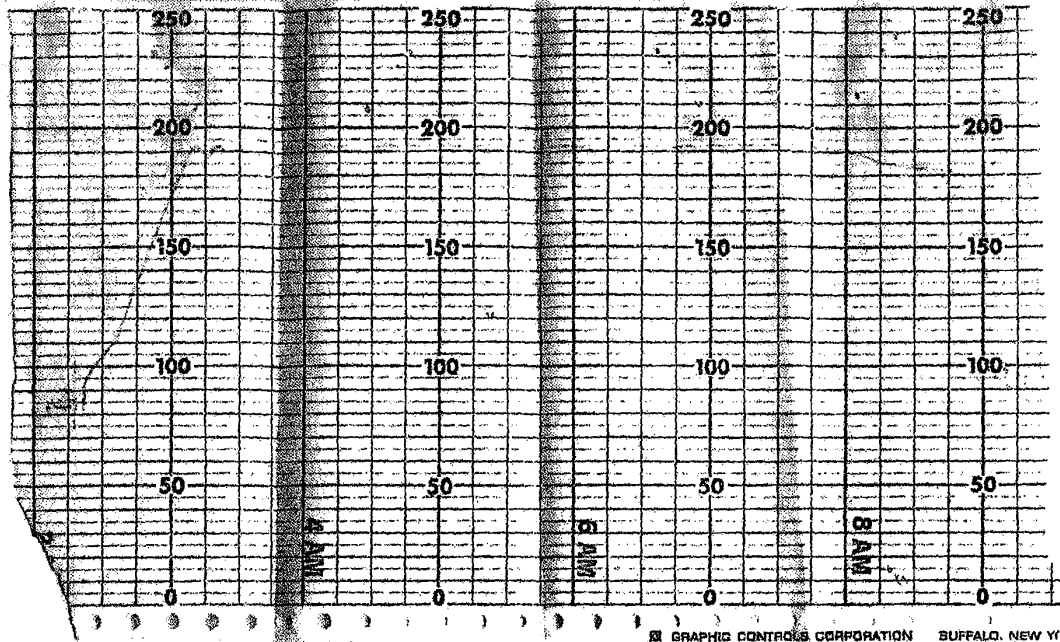
978-A

45

43 Stop agitator

Start	Fin	Optr
11:00 P	1:00 A	2:59
2:00 A	3:00 P.M.	2:35
3:00 P.M.	11:00 P.M.	3:51
11:00 P	1:00 A	1:26
Step	V-262 (20 RPM)	V-243, 244, 247
9	5"	10"
18	35" 25	60" 50

DUP050456682



DUP050456683
N32113.01