

S.V. 205C 247

C.V.

D.V.

CG 04 CODE K0-786-D PKG

PUNCHED & CHECKED

EST. WGT. 862 LBS.

APR 10 1980

STD. HRS. 10.5 TIME

01 YC-10-B 93 4 35479 450#
 01 YC-10-B 93 4 35479 450#
 01 YC-10-B 93 4 35479 450#

APR 8 1980

TYPED BY
JLC 11-16-76

PROCESSES		APPROVED BY	
() K0-786-D	(P)	ENK 9-21-76	
()	()	DCG 9-21-76	
()	()	MTW 10-1-76	
()	()		
TYPED BY			
JLC 11-16-76			

Total Weight 49624 (Req.)

MILL LOOK YELLOW

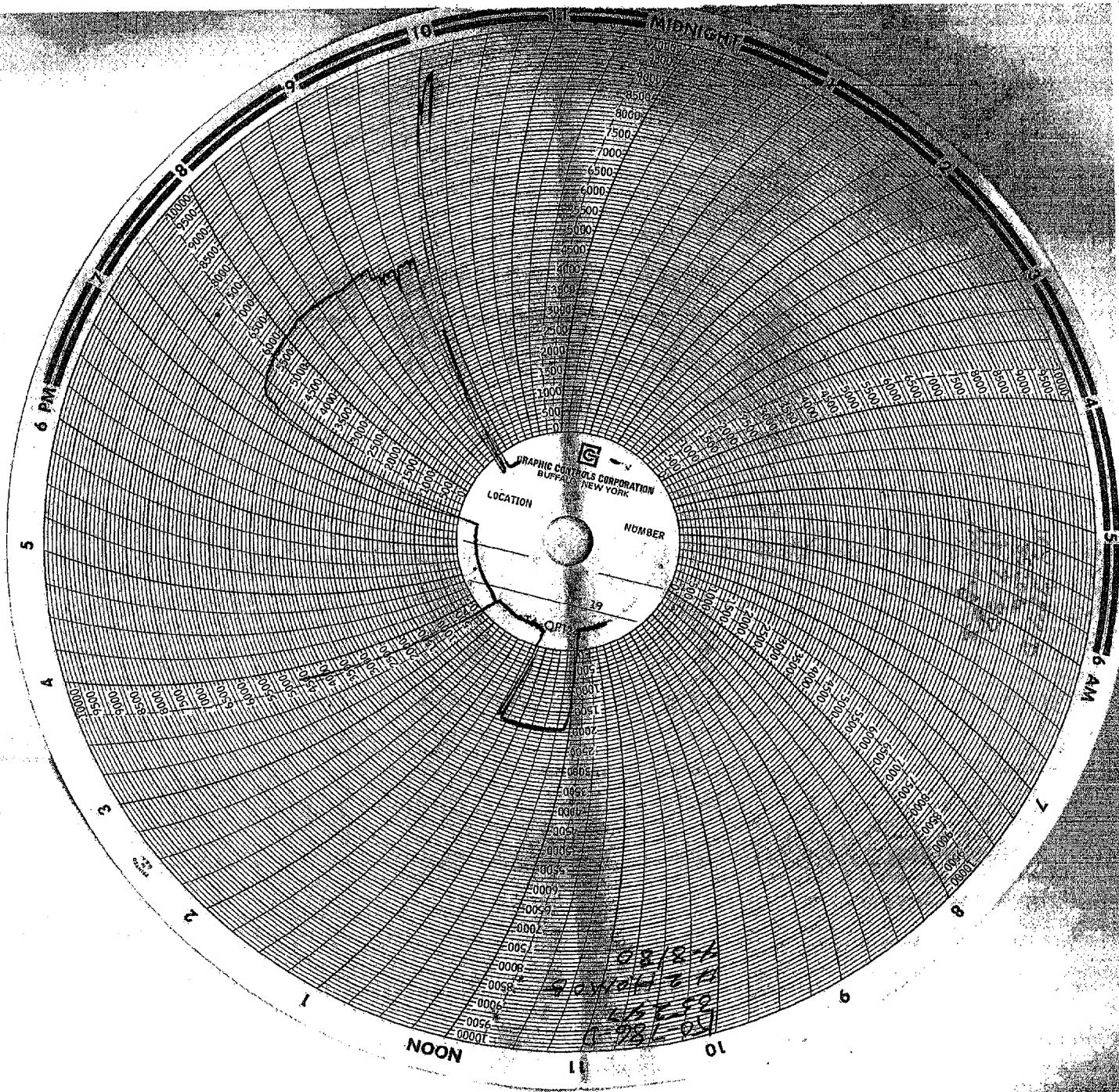
NON-BLEEDING

EQUIPMENT	NAME	SET AGITATOR ON HIGH SPEED	USE LBS.	N CODE	ACCT. LBS.
211 & 208	Run 60" (990 G) water in V-211 and add.	Assume 50%	30	7-D	15
1	Weigh in drum and pour in V-211		270	32-D	270
	Dump in and stir 5 minutes	LOT	84	82 x 50 YC-10-B	4100
	Record: Start 8:30 AM	33488	450		4500
	Fin 10:00 AM	34489	1100		
	75" (1275 G)	33479	850		
	Adjust to 80" (1370 G)	35019	1750		
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208	73241	100		
	When V-211 MTY. wash color thru Homog at 1800-2200 psi using minimum water				
	Record: V-208 Vol 46" and adjust to 50" (1840 G)				
	Inspect homog strainer and clean if necessary				
208 & SV	Run 15" (771 G) water into V-208 and start agitator and install temperature chart				
2	Pump V-208 thru Homog at 4800-5200 psi into SV				
	Record: Time Start 7:55 PM Total Minutes 165				
	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 & 384	While Homog. run 6" (284 G) water into V-349				
3	Run 1000# water into V-384 and heat to 110-120°F		2400	32-D	2400
	Weigh into V-384 and pump to V-349				
	Run 1000# water into V-384 and pump to V-349				
	Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer				
	Record: Spc 1081 (10.9-10.2) (1.078-1.081)				
SV	When S-11 Homog complete, adjust to 66" (3400 G) in SV				
4	Record: pH 10.9 and adjust to 10.4-10.8 using N-7-D diluted to 3% (10 parts water to 1 part N-7-D) Assume 50%			7-D	
	Siphon N-7-D into SV and Record: pH				
	Heat to 190-194°F in 55-65 minutes & Record: HT 184°F and Rec 192°F				
	Note: Strike must be started immediately on completion of heating				
343 & 386	While heating SV, run 51" (1400 G) water into V-343			27-D	355
5	Meter in from V-386 M 28 #/Gal 9.18 Gal 38.7				
	Stir 15 minutes or longer				
	Record: Spc 1019 (2.8-3.1) (1.017-1.019)				

2ime

V-247

EQUIPMENT	PAGE	2	CG 04	CODE	KO-786-D (K)	EST. WGT.	4962	LBS.	USE LBS.	N CODE	ACCT LBS.
SV 6	25	When S-20 heating complete, Record: pH 10.0 (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 190-199°F during strike									
	29	Record: Start Finish Minutes									
		V-343		12:20		4:45 AM		240			
		V-349		12:20		3:50 AM		185			
		Records	Time	V-343	V-349	SV	Normal				
			12:20	Inches	Inches	pH	pH				
Best at 1:05 AM		at 20 min.	12:40	(47) +	(20) -	9.8	9.3-10.0	STOP METERING			
		40 min.	1:25	(43) +	(17) +	9.8	9.3-10.0				
		1 hr.	1:45	(38) 37+	(15) 16-	9.75	9.3-10.0				
		2 hrs.	2:45	(24) 26	(7) 8	9.75	9.3-10.0				
		3 hrs.	3:45	(10) 12+	(0) +	9.7	9.3-10.0				
		Finish	4:45	(0) -		7.4	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%									
357 7	30	Run 21" (190 G) water into V-357 and heat to 135-140°F									
	31	Dump in and stir to dissolve									
								300	15-A	300	
302 8	22	Add 42" (514 G) water to V-302									
	23	Add and stir 2 minutes									
								150	7-D	75	
SV 9	24	When V-349 MTY, rinse in with minimum water then set pump to zero setting									
	25	When V-343 MTY, rinse in with minimum water, then turn off pump motor									
	26	TURN OFF STEAM									
	27	Run in V-357 from S-31 and stir 5 minutes									
	28	Record: pH 2.1 (3.3-3.7)									
	29	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH									
	30	Run in N-7-D from S-33 in 4-6 minutes and stir 5 minutes									
	31	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						
		11:00 P.	5:40 AM		235-342						
Note	STEP 29 - STEAM PRESSURE DOWN IN POWER HOUSE										
	4:15 12:30 AM. TEMP PROPPING SHUT METERING										
	DOWN 12:40 AM - RESTARTED 1:05 AM - DOWN 25 MIN										

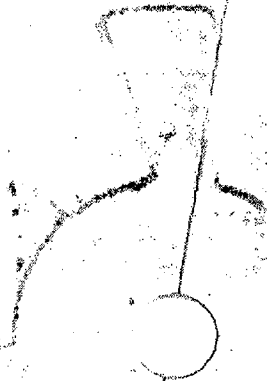


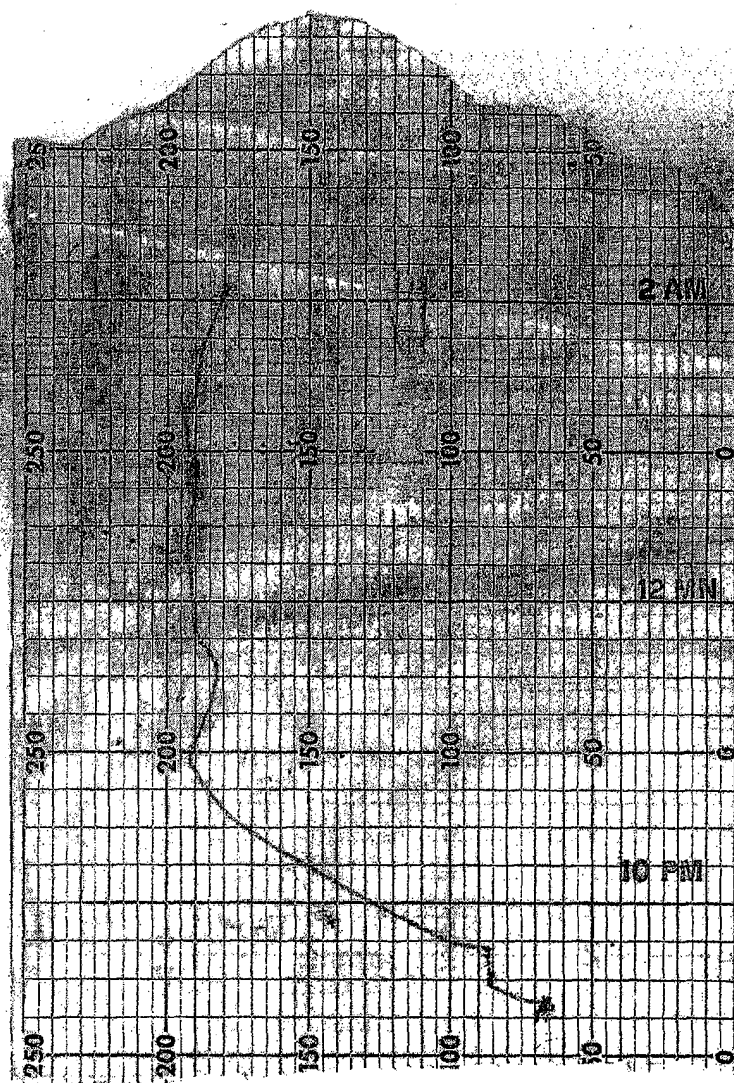
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N32425.01

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N32425.02