

APR 1 1976

MAKING INSTRUCTIONS BATCH UNIT

S.V. 246

C.V.

D.V.

CG. 04 6005 KO-786-D PKG.

EST. WGT. 862 LBS. 35105

STD. HRS. 10.5 TIME

01 YC-10-B 93 4 33485 500 #

01 YC-10-B 93 4 34412 1000 #

01 YC-10-B 93 4 34408 1550 #

Total Weight 4962# (Req. _____)

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	

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
	Pump in and stir 5 minutes		84	82 x 50 YC-10-B	4100
	Record: Start 10:45 Am	34485	500		4200
	Fin 1:10 pm	34412	1000		
	75" (1275 G)	34408	1550		
	Adjust to 80" (1370 G)	34714	1050		
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208	34412	100		
	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water				
	Record: V-208 Vol 43 " and adjust to 50" (1840 G)				
	Inspect homog strainer and clean if necessary				
208 & SV 2	Run 15" (771 G) water into V-246 and start agitator and install temperature chart				
	Pump V-208 thru Homog at 4800-5200 psi into SV				
	Record: Time Start 10:20 PM Total Minutes 115				
	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				
	Weigh into V-384 and pump to V-349		2400	32-D	2400
	Run ±1000# water into V-384 and pump to V-349				
	Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer				
	Record: 85 (10.9-10.2) (1.078-1.081)				
SV 4	When S-11 Homog complete, adjust to 66" (3400 G) in SV				
	Record: pH 10.9 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				
	Heat to 190-194°F in 55-65 minutes & Record: HT F and Rec F				
	Note: Strike must be started immediately on completion of heating				
343 & 386	While heating SV, run 51" (1400 G) water into V-343				
5	Meter in from V-386 M 25 #/Gal 9.16 Gal 38.8			27-D	355
	Stir 15 minutes or longer				
	Record: 85 (10.18 (2.8-0.1) 1.017-1.019				

NON-BLEEDING

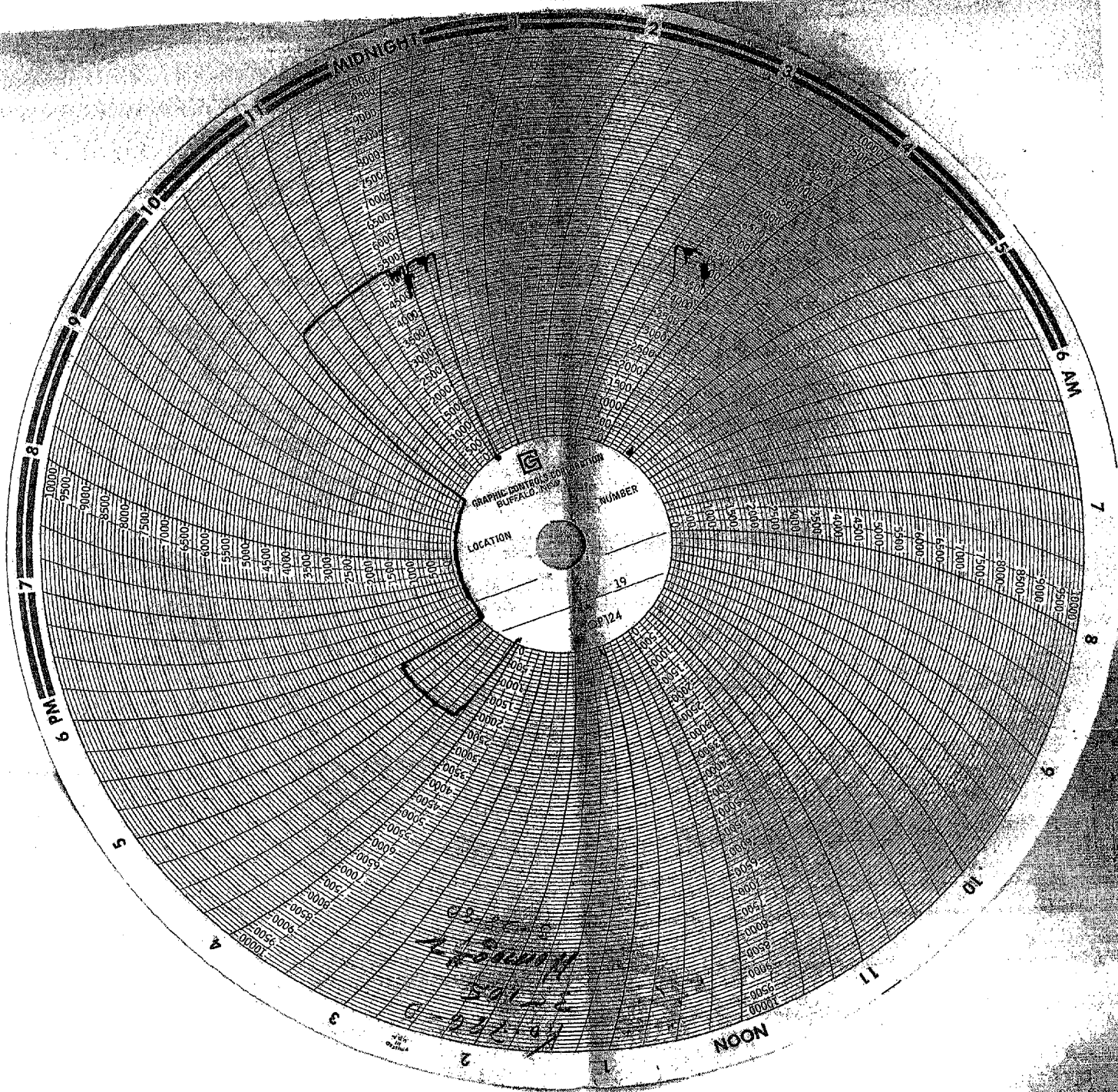
Not Initial

MAY LOOK YELLOW

7/11

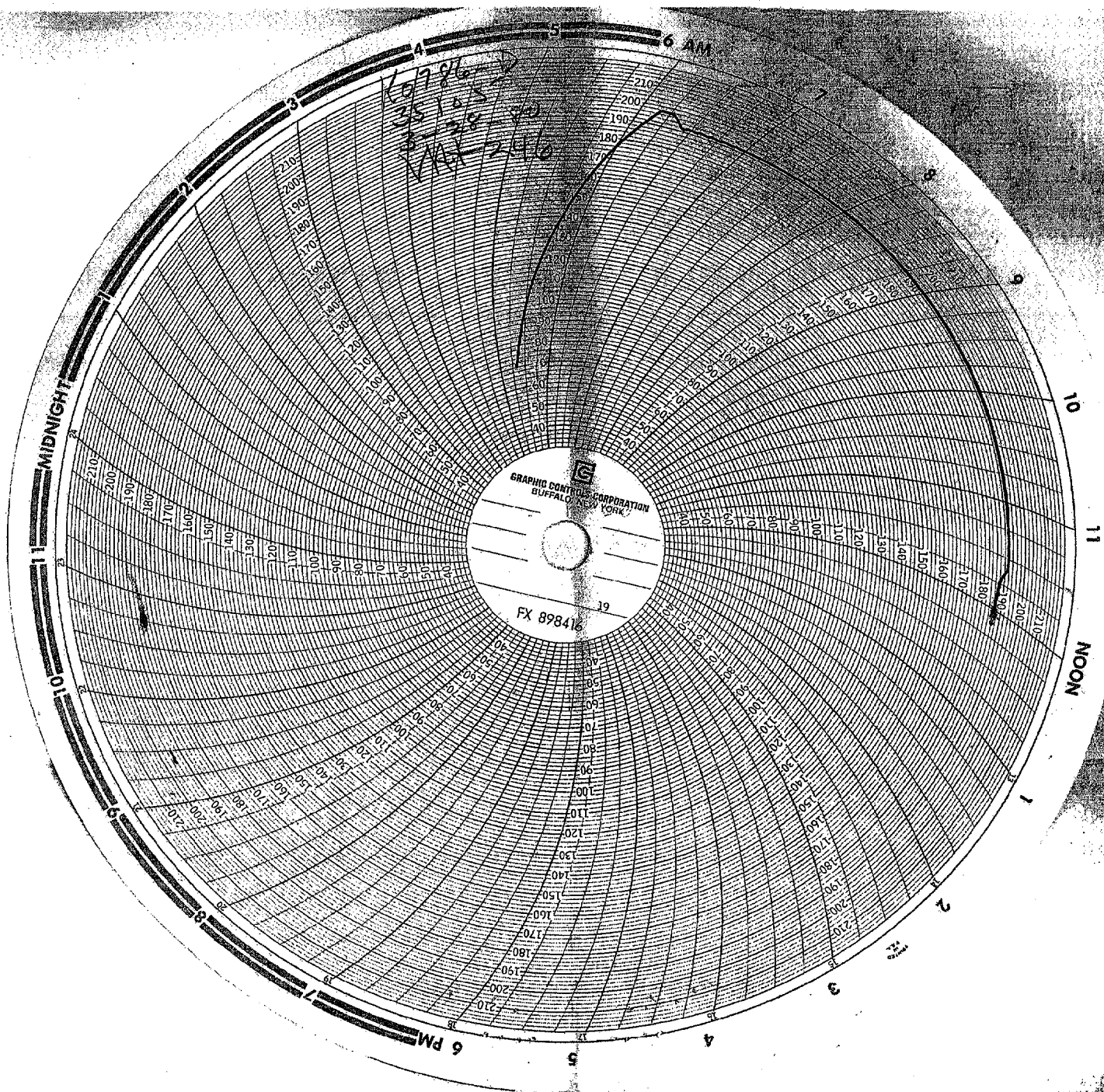
V-246

EQUIPMENT	PAGE	CG	04	CODE	K0-786-D (2)	EST. WGT.	4962	LBS.	USE	N	ACT.
									LBS.	CODE	Lbs.
SV 6	25	When S 20 heating complete, Record: pH <u>10.0</u> (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	<u>5:45</u>	<u>9:40 AM</u>	<u>235</u>						
		V-349	<u>5:45</u>	<u>9:40 AM</u>	<u>195</u>						
		Record:	Time	V-343	V-349	SV	Normal				
				Inches	Inches	pH	pH				
		at 20 min	<u>6:10</u>	(47)	(20)	<u>9.8</u>	<u>9.3-10.0</u>				
		40 min	<u>6:25</u>	(43)	(17)	<u>9.8</u>	<u>9.3-10.0</u>				
		1 hr	<u>6:45</u>	(38)	(15)	<u>9.8</u>	<u>9.3-10.0</u>				
		2 hrs	<u>7:45</u>	(24)	(7)	<u>9.8</u>	<u>9.3-10.0</u>				
		3 hrs	<u>8:45</u>	(10)	(0)	<u>9.8</u>	<u>9.3-10.0</u>				
		Finish	<u>9:30</u>	(0)	(0)	<u>6.7</u>	<u>7.5-8.5</u>				
		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 7	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	
302 8	32	Add 42" (514 G) water to V-302									
	33	Add and stir 2 minutes									
							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 <u>3.1</u> (3.3-3.7)									
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH <u>3.1</u>									
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes									
	41	Record: pH <u>4.0</u> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH Assume 77%									
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%									
		Siphon N-7-D into SV									
	42	Stop agitator									
		START	FINISH		OPTR						
		<u>3:00 P</u>	<u>11:00 PM</u>		<u>235</u>						
		<u>11 PM</u>	<u>7 AM</u>		<u>282</u>						
		<u>7 A.M.</u>	<u>11:30 A.M.</u>		<u>201</u>						



DUP050457950

N32422.01



DUP050457951

N32422.02