

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

C.V.

5/8/80 GW

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 03 CODE KY-795-D PKG.

35663

EST. WGT. 1178-938 LBS.

PUNCHED & CHECKED

STD. HRS. 11.1 TIME

MAY 12 1980

14 YC-2-B 93 4 Lot

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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			

Homog # 3 - 1st Pass

Total Wgt. 4878# 4638

NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	60" (2106) "KROLOR" YELLOW - MEDIUM			
203	1 Run 26" (419 G) water in V-203. RUN AGITATOR ON HIGH SPEED			
203	2 Weigh in drum & pour in	500	32-D	500
203	3 Dump in & stir 5 min			
203	Record: Start 8:30 AM Lot 24775 2000			
203	Fin 9:45 PM 24790 300			
203	25" (275 G) 24720 1200			
203	4 Adj to 28" (1328 G) 2400-2600			
203	5 Pump V-203 thru Homog # 3 at 1800-2200 psi into V-205 - 263			
203	6 When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water 263			
203	7 Record: V-205 Vol " & adj to 51" (1874 G)			
203	8 Inspect homog, strainer & clean if necessary			
SV	9 Run " (514 G) water into V- 262, install temp charts & start agitator			
SV	10 Pump V-205 thru Homog at 4800-5200 psi into SV			
SV	Record: Time Start 4:30 PM Total Min 150			
SV	Note: If Homog pressure falls below 4800 psi 3-way valve will recirculate slurry to V-205			
SV	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			
349	13 Run ± 1000# water into V-384 & heat to 110-120°F	2000		2000
384	14 Weigh into V-384 & pump to V-349	2836	32-D	2836
384	15 Run ± 1000# water into V-384 & pump to V-349			
384	16 Adj V-349 to 29" (1372 G) & stir 15 min or longer			
384	17 Record: Bt 1.049 (9.85 ± 0.2) (1.049-1.051)			
SV	18 When S 18 Homog complete, adj. to 26" (3486 G) (24966)			
SV	19 Record: pH 10.7 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	18	1-D	9
SV	Siphon into SV & Record: pH 11.3			
SV	20 Heat to 190-194°F in 55-65 min & Record: HT 192°F & Ref V OF			
SV	Note: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 69" (1898 G) water into V-343			212
343	22 Meter in from V-386 M 33, 10.50 #/Gal 32.7 Gal		-27-D	416
386	23 Stir 15 min or longer			
386	24 Record: Bt 1.011 (2.5 ± 0.1) (1.010-1.012)			
SV	25 When S 25 heating complete, adj. to 26" (3486 G) (24966)			
SV	26 Set V-343 cold pump at 500 settings (250 min)			
SV	27 Set V-343 cold pump at 500 settings (250 min)			
SV	28 Immediately meter in V-343 & V-349. Maintain SV at			

21 WHILE HEATING SV, RUN 69" (1898 G) WATER INTO
 343 V-343
 & 22 METER IN FROM V-386 M, GAL, GAL 27-D
 386 23 STIR 15 MIN OR LONGER
 5 24 RECORD: DENSITY G/ML (1.010-1.012)

25 WHEN S 20 HEATING COMPLETE, RECORD: PH 10.0
 26 SET V-343 ACID PUMP AT 8.2 SETTING (265 MIN)
 27 SET V-349 SILICATE PUMP AT 7.0 SETTING (210 MIN)
 28 IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV
 SV AT 190-194°F DURING STRIKE.

6 29 RECORD: START FINISH MINUTES
 V-343 11:15 11:35 370
 V-349 11:15 11:35 235
 TIME V-343 V-349 SV NORMAL
 PH PH
 AT 20 MIN 11:35 INCHES INCHES PH PH
 40 MIN 11:55 (65) 60+ (26) 25 10 (9.0-10.0)
 1 HR 12:15 (59) 61 (23) 24 10 (9.0-10.0)
 2 HRS 12:15 (54) 56 (21) 22 10 (9.0-10.0)
 3 HRS 12:15 (38) 44 (12) 14 10 (9.0-10.0)
 3 1/2 HRS 12:15 (22) 31 (4) 5 10 (9.0-10.0)
 FINISH 12:40 (0) 8.5 (7.5-8.5)

NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP
 PUMPS & SEE SUPV. IF FINAL PH IS ABOVE
 8.5, ADJ TO 7.5-8.5 & RECORD: PH
 ASSUME 77% 27-D

30 RUN 15" (108 G) WATER INTO V-356 & HEAT TO
 135-140°F
 31 DUMP IN & STIR TO DISSOLVE FOR S-38 220 15-A 220

32 WEIGH INTO 55 GAL DRUM 60 7-D 30
 33 FILL WITH WATER & STIR 2 MIN FOR S-40

SV 34 WHEN V-349 MT, RINSE IN WITH MINIMUM WATER &
 SET PUMP TO ZERO SETTING
 35 WHEN V-343 MT, RINSE IN WITH MINIMUM WATER &
 TURN OFF PUMP MOTOR
 36 TURN OFF STEAM
 37 SIFT IN 150 N-65-A 150
 38 RUN IN V-356 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
 NOTE: DISSOLVE EXTRA N-15-A IN WATER AT 135-140
 °F IN DRUM, USE 30 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 4.2 (4.0-4.2) & IF NECESSARY ADJ TO
 PH 4.0-4.2 & RECORD: PH ASSUME 77% 27-D
 DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50% 7-D
 42 SIPHON N-7-D INTO SV 45 978-A 45
 43 POUR IN STIR 15 MIN
 STOP AGITATOR

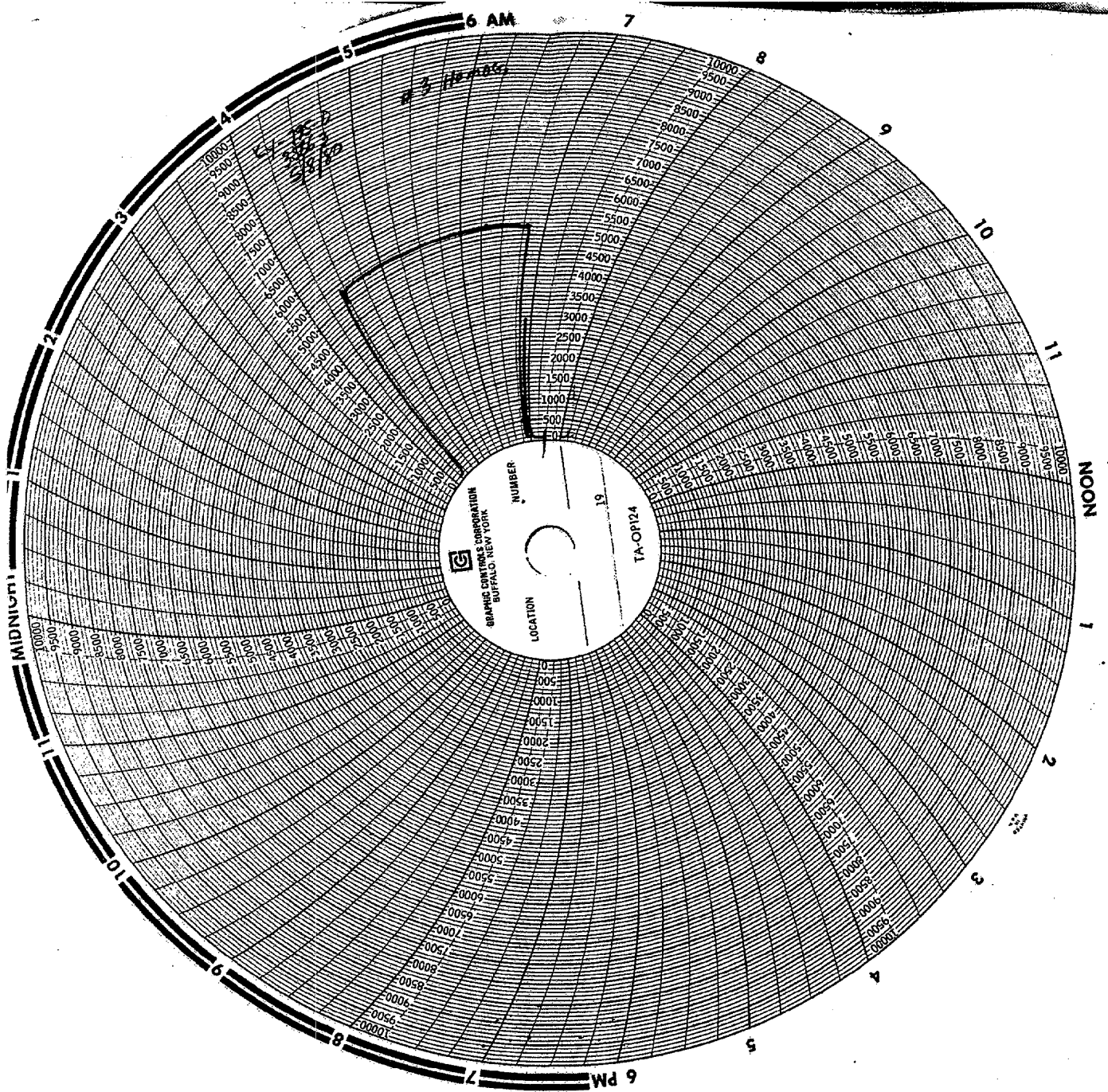
START FINISH OPERATOR
 11:00 545A 120
 STEP V-262 (20 RPM) V-243, 244
 9 5 10
 18 25 50

262

16

DUP050456310

N32031.02



DUP050456311

N32031.03