

MAKING INSTRUCTIONS: BATCH UNIT.

246 (247) 247
 06 04 CODE KO-786-D PKG. _____
 DEC 27 33531
 EST. WGT. 862 LBS.
 STD. HRS. 10.5 TIME 11:00 PM
 01 YC-10-B 93 4 33358 4100 #
 01 YC-10-B 93 4 _____ #
 01 YC-10-B 93 4 _____ #

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

Total Weight 4962# (Req. _____)

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	11 Run 60" (990 G) water in V-211 and add Assume 50%	30	7-D	15
218	12 Weigh in drum and pour in V-211	270	32-D	270
1	13 Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
	Record: Start 12:20 PM			
	Fin 11:30 AM 33358	4100		
	15" (1275 G)			
	14 Adjust to 30" (1370 G)			
	15 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	16 When V-211 MTY wash color thru Homog at 1800-2200 psi using minimum water			
	17 Record: V-208 Vol 42" and adjust to 50" (1840 G)			
	18 Inspect homog strainer and clean if necessary			
208	9 Run 15" (771 G) water into V-247 and start agitator and install temperature chart			
SV	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start 5:05 AM Total Minutes 150			
	Note: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	11 When V-208 MTY, run in 5" (240 G) water and 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 and heat to 110-120°F			
3	14 Weigh into V-384 and pump to V-349	2400	32-D	2400
	15 Run 1000# water into V-384 and pump to V-349			
	16 Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	17 Record: 1.081 (10.9 ± 0.2) 1.078 - 1.081			
SV	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	19 Record: pH 10.7 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 10.7 F and			
	20 Heat to 190-194°F in 55-65 minutes & Record: HT 192 F and Rec 192 F			
	Note: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 51" (1400 G) water into V-343			
386	22 Meter in from V-386 M 8.3 #/Gal 7.88 Gal 35.9		27-D	355
5	23 Stir 15 minutes or longer			
	24 Record: 1.019 (2.8 ± 0.1) 1.017 - 1.019			
	9/LM			

U-247

150
45

JIPMENT	PAGE	2	CG 04	CODE	K0-786-D (H)	EST. WGT.	4962	LBS.	USE	N	ACTY.
									LBS.	CODE	LBS.
SV 6	25	When S 20 heating complete, Record: pH <u>9.7</u> (9.6-10.2)									
	26	Set V-343 acid pump at 72 setting (± 25 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	11:45 AM	3:30	225					
			V-349	2:35	1:90						
		Record:	Time	V-343	V-349	SV	Normal				
				Inches	Inches	pH	pH				
		at 20 min	12:05 PM	(47) 48	(20) 20	9.5	9.3-10.0				
		40 min	12:25 PM	(43) 44	(17) 17	9.5	9.3-10.0				
		1 hr	12:45 PM	(38) 40	(15) 15	9.5	9.3-10.0				
		2 hrs	1:45 PM	(24) 26	(7) 7	9.6	9.3-10.0				
		3 hrs	2:45 PM	(10) 11	(0) 1	9.6	9.3-10.0				
		Finish	3:30 PM	(0)	(0)	6.0	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%									
										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
		Assume 50%									
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>3.3</u> (3.3-3.7)									
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH <u>4.0</u>								15-A	
	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%								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							
		1:30 AM	2:00 AM	201.322							
		7:00 AM	3:00 PM	381							
		9:00 PM	4:35 PM	409							

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M.

LOT 3353

Production Co

Production Control

[illegible]

PICK UP AND RETURN TO STORAGE THE FOLLOWING:

*Each Supervisor must explain weight differences on reverse side.

[illegible]

PRODUCTION CONTROL COPY	-- WHITE
OPERATING FILE COPY	-- YELLOW
WAREHOUSE FILE COPY	-- GREEN
RAW MATERIAL FILE COPY	-- BLUE
PRODUCTION CONTROL FILE COPY	-- PINK

PLACED IN LOCATION BY: OPER. #

DATE:

SUPVR.



