

MAR 27 1980

PUNCHED &amp; CHECKED

APR 1 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 246, 247

C.V.

D.V.

26 04 CODE K0-786-D PKG.

EST. WGT.

LBS.

STD. HRS.

10.5

TIME

34 M

01 YC-10-B

93

4

34407

500#

01 YC-10-B

93

4

33485

500#

01 YC-10-B

93

4

34714

150#

01 YC-10-B 93 34407

1100#

01 YC-10-B 93 34485

1850#

01 YC-10-B 93 34714

1850#

Total Weight 4962# (Req. 3327)

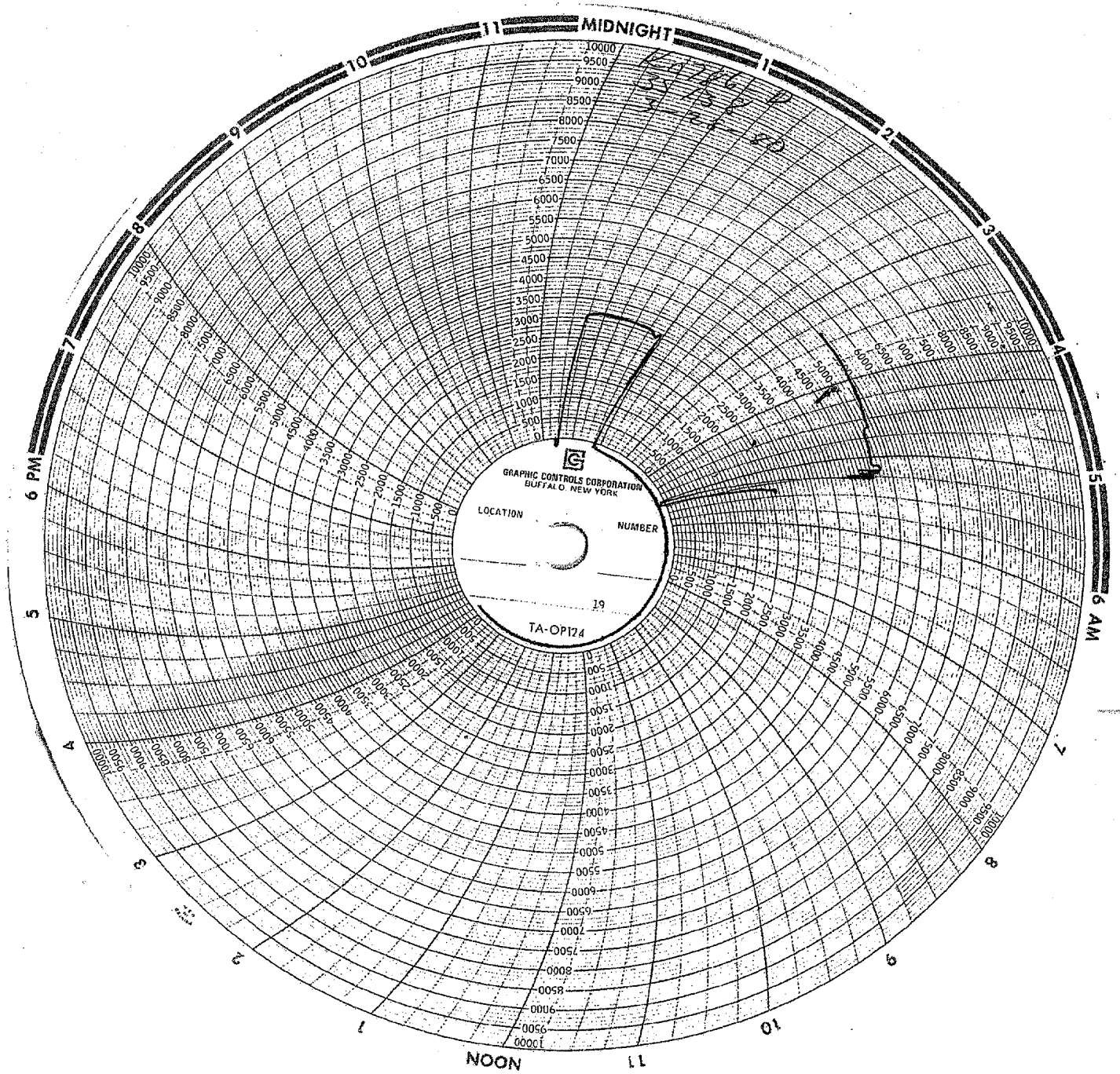
MAR 31 1980

NON-BLEEDING

| EQUIPMENT | NAME: "KROLOR" ORANGE R                                                                                          | SET AGITATOR ON HIGH SPEED | USE LBS. | N CODE  | ACCT. LBS. |
|-----------|------------------------------------------------------------------------------------------------------------------|----------------------------|----------|---------|------------|
| 211       | 1 Run 8" (990 G) water in V-211 and add                                                                          | Assume 50%                 | 20       | 7-D     | 15         |
| 8         | 2 Weigh in drum and pour in V-211                                                                                |                            | 270      | 32-D    | 270        |
| 208       | 3 Dump in and stir 5 minutes                                                                                     | LOT                        | 82 X 50  | YC-10-B | 4100       |
| 1         | Record: Start 8:30 P/M                                                                                           | 34407                      | 500      |         |            |
|           | Fin 10:20 P/M                                                                                                    | 33485                      | 500      |         |            |
|           | 75" (225 G)                                                                                                      | 34714                      | 150      |         |            |
|           | 4 Adjust to 80" (2370 G)                                                                                         | 34407                      | 1100     |         |            |
|           | 5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208                                                           | 34407                      | 1850     |         |            |
|           | 6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water                                     |                            |          |         |            |
|           | 7 Record: V-208 Vol. 54" and adjust to 50" (1840 G)                                                              |                            |          |         |            |
|           | 8 Inspect homog strainer and clean if necessary                                                                  |                            |          |         |            |
|           | DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED.                                                                   |                            |          |         |            |
| 208       | 9 Run 15" (771 G) water into V-247 and start agitator and                                                        |                            |          |         |            |
| 8         | install temperature chart                                                                                        |                            |          |         |            |
| SV        | 10 Pump V-208 thru Homog at 4800-5200 psi into SV                                                                |                            |          |         |            |
| 2         | Record: Time Start 3:30 P/M Total Minutes 120                                                                    |                            |          |         |            |
|           | 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                                                                  |                            |          |         |            |
| 8         | 13 Run ±1000# water into V-384 and heat to 110-120°F                                                             |                            |          |         |            |
| 384       | 14 Weigh into V-384 and pump to V-349                                                                            |                            | 2400     | 32-D    | 2400       |
| 3         | 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: 1.08 (1.078-1.081)                                                                                    |                            |          |         |            |
|           | 3/ml                                                                                                             |                            |          |         |            |
| SV        | 18 When S-11 Homog complete, adjust to 66" (3400 G) in SV                                                        |                            |          |         |            |
| 4         | 19 Record: pH 10.4 and adjust to 10.4-10.8 using N-7-D diluted to 6% (10 parts water to 1 part N-7-D) Assume 50% |                            |          | 7-D     |            |
|           | Siphon N-7-D into SV and Record: pH                                                                              |                            |          |         |            |
|           | 20 Heat to 190-194°F in 55-65 minutes & Record: HT 192°F and Rec F                                               |                            |          |         |            |
|           | Note: Strike must be started immediately on completion of heating                                                |                            |          |         |            |
| 343       | 21 While heating SV, run 51" (1400 G) water into V-343                                                           |                            |          |         |            |
| 8         | 22 Meter in from V-386 M 7.3 Gal 32.2                                                                            |                            |          | 27-D    | 355        |
| 386       | 23 Stir 15 minutes or longer                                                                                     |                            |          |         |            |
| 5         | 24 Record: 1.018 (1.017-1.019)                                                                                   |                            |          |         |            |
|           | 8/ml                                                                                                             |                            |          |         |            |

V-247

| EQUIPMENT | PAGE 2 CG 04 CODE K0-786-D (B) EST. WGT. 4962 LBS.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | USE LBS. | N. CODE | ACCT. LBS. |
|-----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------|---------|------------|
| SV 6      | <p>25 When S 20 heating complete, Record: pH <u>10.2</u> (9.6-10.2)</p> <p>26 Set V-343 acid pump at 72 setting (<math>\pm 25</math> minutes)</p> <p>27 Set V-349 silicate pump at 66 setting (<math>\pm 180</math> minutes)</p> <p>28 Immediately meter in V-343 &amp; V-349. Maintain SV at 190-193°F during strike</p> <p>29 Record: Start Finish Minutes</p> <p>V-343 <u>7:40</u> <u>11:25 PM</u> <u>225</u></p> <p>V-349 <u>7:40</u> <u>10:50 PM</u> <u>190</u></p> <p>Record: Time V-343 V-349 SV Normal</p> <p>Inches Inches pH pH</p> <p>at 20 min <u>8:25 PM</u> (47) <u>4.6</u> (20) <u>2.0</u> <u>10.0</u> <u>9.3-10.0</u></p> <p>40 min <u>8:25 PM</u> (43) <u>4.4</u> (17) <u>1.7</u> <u>10.0</u> <u>9.3-10.0</u></p> <p>1 hr <u>8:40 PM</u> (38) <u>3.8</u> (15) <u>1.5</u> <u>10.0</u> <u>9.3-10.0</u></p> <p>2 hrs <u>9:10 PM</u> (24) <u>2.4</u> (7) <u>0.7</u> <u>10.0</u> <u>9.3-10.0</u></p> <p>3 hrs <u>10:40 PM</u> (10) <u>1.0</u> (0) <u>0</u> <u>9.9</u> <u>9.3-10.0</u></p> <p>Finish <u>11:15 PM</u> (0) <u>0</u> <u>8.2</u> <u>7.5-8.5</u></p> <p>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%</p> |          |         |            |
| 357 7     | <p>30 Run 21" (150 G) water into V-357 and heat to 135-140°F</p> <p>31 Dump in and stir to dissolve</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 300      | 15-A    | 300        |
| 302 8     | <p>32 Add 42" (514 G) water to V-302</p> <p>33 Add and stir 2 minutes Assume 50%</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 150      | 7-D     | 75         |
| SV 9      | <p>34 When V-349 MTY, rinse in with minimum water then set pump to zero setting</p> <p>35 When V-343 MTY, rinse in with minimum water, then turn off pump motor</p> <p>36 TURN OFF STEAM</p> <p>37 Run in V-357 from S 31 and stir 5 minutes</p> <p>38 Record: pH <u>3.9</u> (3.3-3.7)</p> <p>39 If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH <u>6.0</u></p> <p>40 Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes</p> <p>41 Record: pH <u>4.2</u> (4.0-4.2) &amp; if necessary, adjust to pH 4.0-4.2 and Record: pH Assume 77%</p> <p>(Dilute 10 parts water to 1 part N-7-D) Assume 50%</p> <p>Siphon N-7-D into SV</p> <p>42 Stop agitator</p> <p>START FINISH OPTR</p> <p><u>11 PM</u> <u>11:00 PM</u> <u>282</u></p> <p><u>11:00 PM</u> <u>11:00 PM</u> <u>237</u></p> <p><u>11:00 PM</u> <u>12:30 AM</u> <u>381-438</u></p>                                                                                                                                                                                                                                                                                                                                                                       |          | 15-A    | 60         |
|           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |          | 27-D    |            |
|           |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   |          | 7-D     |            |



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