

J. 243, 244, 246, 247, 262

C.V.

D.V.

CG 03 CODE KY-787-D PKG.

→ Dec 29 33549
EST. WGT. 2230 LBS.

STD. HRS.

TIME

5P

M

14 YC-2-B 93 4 Lot 24071, 4000 #
14 YC-2-B 93 4 Lot 24072, 500 #
14 YC-2-B 93 4 Lot 24074, 500 #

Total Wgt 7230# (REQ)

PROCESSES		APPROVED BY	
() KY-787-D	(S)	EWK 10-19-77	
() Alternate	()	DCG 10-25-77	
()	()	MTW 10-26-77	
()	()	FWP 02-01-79	
TYPED BY			
emw020179			

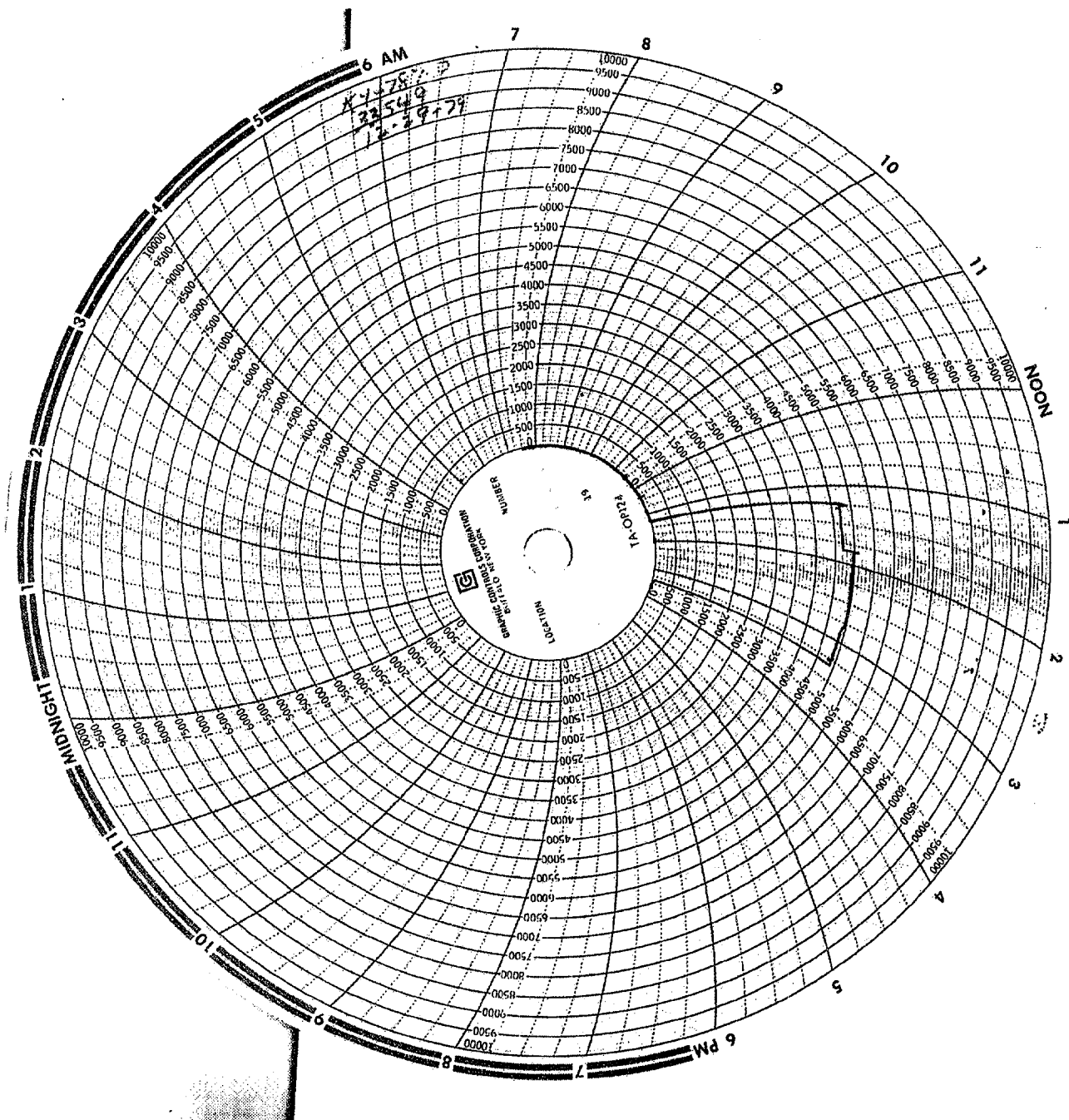
NON-BLEEDING

SHIPMENT	NAME	USE LBS.	N CODE	ACCT LBS.
203 & 205	KROLO® YELLOW MEDIUM			
1	4 Run 50" (827 G) water into V-203 AND ADD	90	7-B	75
	5 Weigh in drum & pour in	670	32-D	670
	6 Dump in & stir 5 min	100 x 50	YC-2-B	5000
	Record: Start 6:30 AM	Lot 24071		4000
	Fin 3:30 AM	24072		500
	75" (1275 G)	24074		500
	4 Adj to 80" (1360 G)			
	5 Pump V-203 thru Homog at 2400-2600 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7 Record: V-205 Vol 41" & adj to 54" (1900 G)			
	8 Inspect Homog strainer & clean if necessary			
SV & 205	9 Run 2" (200 G) water into V-262 & install temp chart & start agitator			
2	10 Pump V-205 thru Homog at 4800-5200 psi into SV-262			
	Record: Time Start 9:30, Total Min 1.35			
	NOTE: If Homog pressure falls below 4800 psi 3-way valve will recirculate slurry to V-205			
	11 When V-205 MTY, run in 5" (240 G) water & pump thru Homog at 4800-5200 psi. Rinse in using Hdt Water			
349 & 384	12 While Homog, run 6" (284 G) water into V-349			
3	13 Run ± 1000 # water into V-384 & heat to 110-120°F			
	14 Weigh into V-384 & pump to V-349	3830	32-D	3830
	15 Run ± 1000 # water into V-384 & pump to V-349			
	16 Adj V-349 to 28" (1163 G) & stir 15 min or longer			
	Record: 1119 (15.2 ± 0.2) (1.113 - 1.117)			
SV & 4	18 When S 11 Homog complete, adj SV to " (2100 G)			
	19 Record: pH 10.5 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	42	7-D	21
	Siphon into SV & Record: pH 11.2			
	20 Heat to 190-194°F in 35-45 min (V-262) or in 55-65 min (V-243, 244, 246, 247) &			
	Record: HT 190°F & Rec 192°F			
	NOTE: Strike must be started immediately on completion of heating			
343 & 386	21 While heating SV, run 56" (1520 G) water into V-343			
	22 Meter in from V-386 M 83.988 #/Gal 58.0 Gal		27-D	573
	23 Stir 15 min or longer			
5	24 Record: 1.0274 (1.027 - 1.028)			
	25 When S 20 Heating complete, Record: pH 9.9 (9.6-10.2)			
	26 Set V-343 acid pump at 52 setting (± 345 min)			
	27 Set V-349 dilute pump at 42 setting (± 300 min)			

N 2622

EQUIPMENT		PAGE 2 CG 03 CODE KY-787-D (S) EST. WGT. 7230 LBS.	USE LBS.	N CODE	AC L
SV 6	25	When S 20 heating complete, Record: pH (9.6-10.2)			
	26	Set V-343 agitator pump at 69 setting (± 255 min)			
	27	Set V-349 siphonate pump at 60 setting (± 210 min)			
	28	Immediately meter in V-343 & 349, maintain SV at 190-194°F during strike			
	29	Record: Start Fin Min			
		V-343			
		V-349			
		Record: Time V-343 V-349 SV Normal			
			in in pH pH		
		at 20 min (52) (22)			9.3-10.0
		40 min (48) (20)			9.3-10.0
		1 hr (43) (18)			9.3-10.0
		2 1/2 hrs (27) (7)			9.3-10.0
		3 1/2 hrs (10) (0)			9.3-10.0
		Finish (0)			7.5-8.5
		NOTE: (1) If pH not as specified, notify Supervisor & note in log			
		(2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH Assume 78%		27-D	
330 7	30	Run 22" (431 G) water into V-330 & heat to 160-170°F			
	31	Add in 12-13 min	700	530-A	700
	32	Stir 5 min & Record: pH (9.5-10.5)			
	33	Stir 20 min or longer to dissolve for S 46			
357 8	34	Run 29" (210 G) water into V-357 & heat to 135-140°F			
	35	Dump in & stir to dissolve for S 42	350	15-A	350
302 9	36	Run 36" (440 G) water into V-302			
	37	Add & stir 2 min for S 44 Assume 50%	380	7-D	190
SV 10	38	When V-349 MTY, rinse in with minimum water then set pump to zero setting			
	39	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	40	Turn off steam			
	41	Sift in	250	128-A	250
	42	Run in V-357 from S 35 & stir 5 min			
	43	Record: pH (3.7-4.2)			
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min			
	45	Record: pH (9.0-9.5) & if necessary, adj to pH 9.0-9.5 & Record: pH Assume 78%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV			
313 11	46	Run in V-330 thru 20 mesh screen & stir 20 min			
	47	Run 15" (222 G) water into V-313 & dump in	270	20-A	270
	48	Stir 5 min to dissolve for S 49			
SV 12	49	Run V-313 into SV in 15-20 min			
	50	Stir 15 min			
	51	Record: pH (9.0-10.0)			
	52	Stop agitator			
		Step V-262 (20 RPM) V-243, 244, 246, 247			
		9 2" 4"			
		18 26" 50"			
		START FIN OPTR			

UIPMENT	PAGE 2 CG 03 CODE KY-787-D (S) EST. WGT.	7230 LBS.	USE LBS.	N CODE	AC
SV	28 Immediately meter in V-343 + 349, maintain SV at 190-194°F during strike				
6	29 Record: Start Fin Min				
	V-343	2:00 AM	8:30 AM	390	
	V-349	2:00 AM	7:30 AM	330	
	Record:	Time	V-343	V-349	SV
			in	in	Normal
					pH pH
	at 20 min	2:20	(55) 55	(23) 23	9.9 9.3-10.0
	40 min	2:40	(51) 51+	(21) 21	9.8 9.3-10.0
	1 hr	3:00	(48) 48	(20) 20	9.8 9.3-10.0
	2 hrs	4:00	(38) 38+	(15) 15	9.8 9.3-10.0
	3 hrs	5:00	(28) 28+	(10) 10	9.8 9.3-10.0
	4 hrs	6:00	(18) 18+	(5) 5	9.9 9.3-10.0
	5 hrs	7:00	(8) 12	(0) 35	9.7 9.3-10.0
	Finish	7:45	(0)		7.7 7.5-8.5
	NOTE: (1) If pH not as specified, notify Supervisor & note in log				
	(2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH Assume 78%				
330	30 Run 22" (431 G) water into V-330 & heat to 160-170°F				
7	31 Add in 12-13 min			700	530-A 700
	32 Stir 5 min & Record: pH 10.0 (9.5-10.5)				
	33 Stir 20 min or longer to dissolve for S 46				
357	34 Run 29" (210 G) water into V-357 & heat to 135-140°F				
8	35 Dump in & stir to dissolve for S 42			350	15-A 350
302	36 Run 36" (440 G) water into V-302				
9	37 Add & stir 2 min for S 44			Assume 50%	380 7-D 190
SV	38 When V-349 MTY, rinse in with minimum water then set pump to zero setting				
10	39 When V-343 MTY, rinse in with minimum water then turn off pump motor				
	40 Turn off steam				
	41 Siphon in			250	128-A 250
	42 Run in V-357 from S 35 & stir 5 min				
	43 Record: pH 3.5 (3.7-4.2)				
	44 Run in N-7-D from S 37 in 10-12 min & stir 5 min				
	45 Record: pH 9.5 (9.0-9.5) & if necessary, adj to pH 9.0-9.5 & Record: pH Assume 78%				27-D
	(Dilute 10 parts water to 1 part N-7-D)			Assume 50%	7-D
	Siphon N-7-D into SV				
	46 Run in V-330 thru 20 mesh screen & stir 20 min				
313	47 Run 15" (222 G) water into V-313 & dump in			270	20-A 270
11	48 Stir 5 min to dissolve for S 49				
SV	49 Run V-313 into SV in 15-20 min				
12	50 Stir 15 min				
	51 Record: pH 9.6 (9.0-10.0)				
	52 Stop agitator Do not stop V-262				
	Step V-262 (20 RPM)			V-243, 244, 246, 247	
	9 2"			4"	
	18 28" 21"			50" 42"	
	START			OPTR	
	8:30 AM			12:00	
	11:00 AM			4:38:38	



V-262