

JUN 2 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244, 245, 247

C.V.

D.V.

CG 03 CODE KY-907-D PKG.

36005

EST. WGT. 1080 LBS.

STD. HRS. TIME 3P M

14 YC-2-B 93 4 Lot 24166, 2300 #
 14 YC-2-B 93 4 Lot 24422, 100 #
 14 YC-2-B 93 4 Lot _____, _____ #

PUNCHED & CHECKED

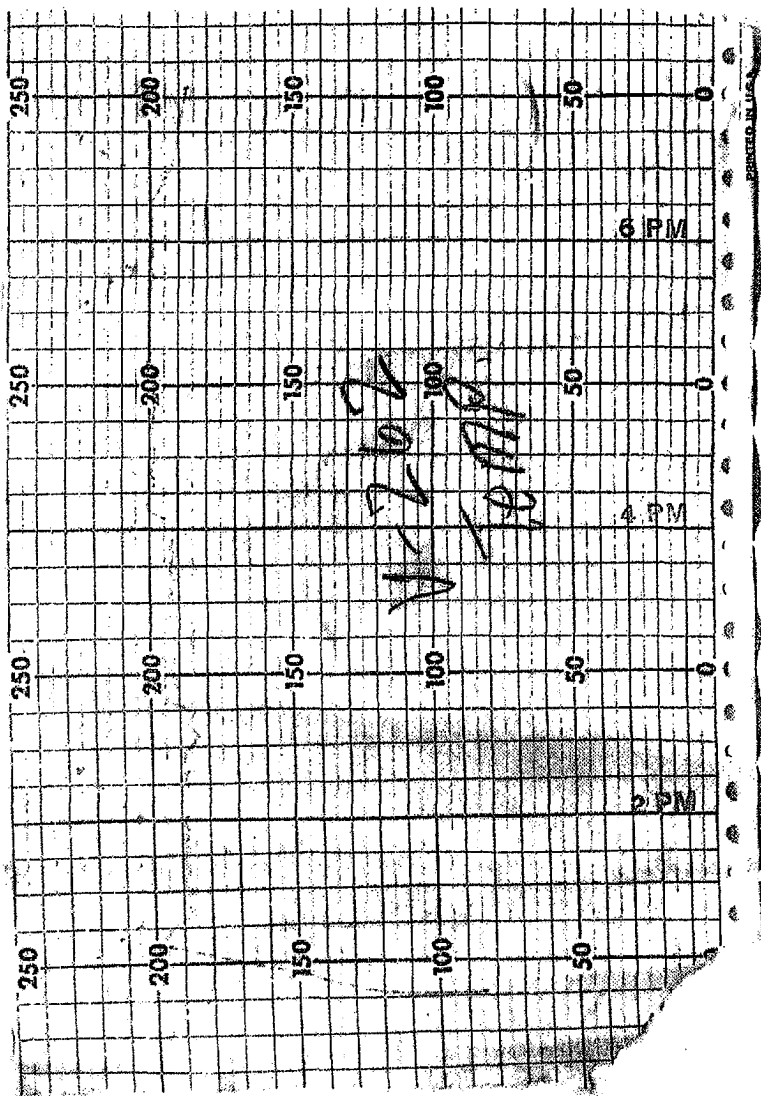
JUN 1 1980

Total Wgt. 3480# (Req.)

NON-BLEEDING

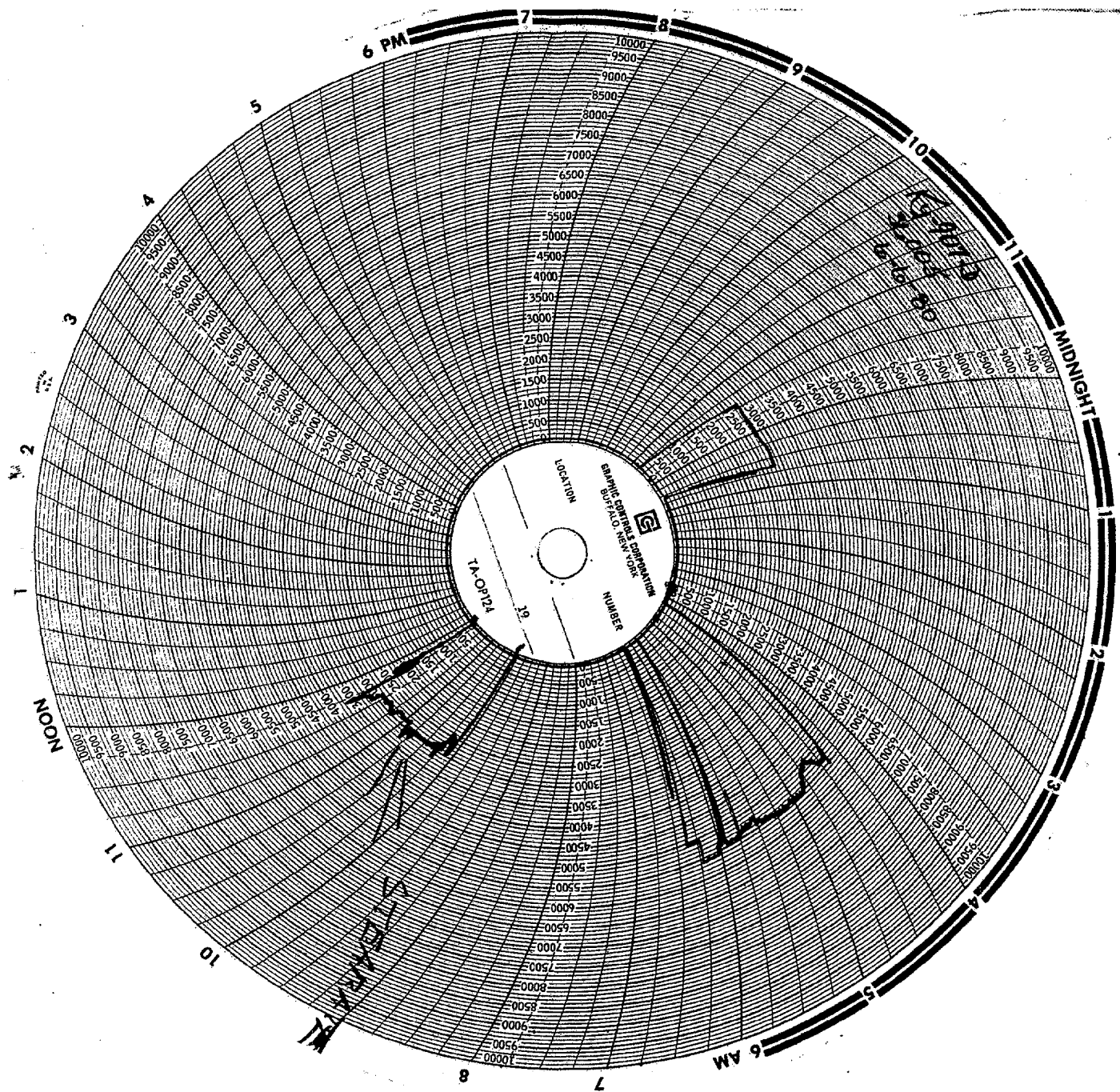
EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
	KROLOR ⁰ YELLOW - MEDIUM			
203 & 205	1 Run 33" (560 G) water into V-203 <i>Set agitator at high speed</i>			
	2 Pour in	320	32-D	320
	3 Dump in	48 x 50	YC-2-B	2400
1	Record: Start 1:15 PM	Lot 24166		
	Fin 2:30 PM	24422		
U-243	4 Adj to 70" (1200 G) 240-2600			
Set agitator	5 Pump V-203 thru Homog #3 at 1800-2200 psi into V-205 - 263			
flow speed	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water 263			
	7 Record: V-205 Vol _____ " & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
SV & 205	9 Run 10" (514 G) water into V-205 Install Temp chart & start agitator			
U-243	10 Pump V-205 thru Homog at 4800-5200 psi into SV			
	Record: Time Start 2:52 PM Total Min 80			
	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			
349 & 384	12 While Homog, run 6" (284 G) water into V-349			
	13 Run +1000# water into V-384 & heat to 110-120°F			
	14 Weigh into V-384 & pump to V-349	1840	32-D	1840
3	15 Run +1000# water into V-384 & pump to V-349			
	16 Adj V-349 to 17" (805 G) & stir 15 min or longer			
	17 Record: °Be' 1.080 (11.0±0.2)			
SV	18 When S 11 Homog complete, adj SV to 48" (2470 G)			
4	19 Record: pH 9.2 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	15
	Siphon into SV & Record: pH 11.2			
	20 Heat to 190-194°F in 55-65 min & Record: HT _____ °F & Rec. °F			
	Note: Strike must be started immediately on completion of heating			
343 & 386	21 While heating SV, run 39" (1070 G) water into V-343			
	22 Water in from V-386 M 27.1 P. 5.4 / Gal 23.5 Gal		27-D	275
5	23 Stir 15 min or longer			
	24 Record: °Be' 1.017 (2.8±0.1)			

EQUIPMENT	PAGE 2 CG 03 CODE ky-907-D (E) EST. WGT. 3480 LBS.	USE LBS.	N CODE	ACCT. LBS.																																				
SV 6	When S 20 heating complete Record: pH 10.0 (9.5-10.0) 26 Set V-343 acid pump at 82 setting (±150min) 27 Set V-349 silicate pump at 72 setting (±120min) 28 Immediately meter in V-343 & 349. Maintain SV at 190-194°F during strike 29 Record: Start Finish Minutes <table><tr><td>V-343</td><td>10:15</td><td>15:15</td></tr><tr><td>V-349</td><td>9:00</td><td>1:30</td></tr></table> Record: Time V-343 V-349 SV Normal <table><tr><td></td><td>Inches</td><td>Inches</td><td>pH</td><td>pH</td></tr><tr><td>at 20 min</td><td>(35)</td><td>(14)</td><td>10.0</td><td>9.3-10.0</td></tr><tr><td>40 min</td><td>(30)</td><td>(11)</td><td>10.0</td><td>9.3-10.0</td></tr><tr><td>1 hrs</td><td>(24)</td><td>(9)</td><td>10.0</td><td>9.3-10.0</td></tr><tr><td>2 hrs</td><td>(8)</td><td>(0)</td><td>9.9</td><td>9.3-10.0</td></tr><tr><td>Finish</td><td>(0)</td><td>(0)</td><td>8.5</td><td>7.5-8.5</td></tr></table> Note: (1) If pH Not as specified notify Supervisor & Note in log (2) If final pH is above 8.5 adj to 7.5-8.5 & Record: pH = 8.7 Assume 78%	V-343	10:15	15:15	V-349	9:00	1:30		Inches	Inches	pH	pH	at 20 min	(35)	(14)	10.0	9.3-10.0	40 min	(30)	(11)	10.0	9.3-10.0	1 hrs	(24)	(9)	10.0	9.3-10.0	2 hrs	(8)	(0)	9.9	9.3-10.0	Finish	(0)	(0)	8.5	7.5-8.5	50	27-D 128-A	50
V-343	10:15	15:15																																						
V-349	9:00	1:30																																						
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2 hrs	(8)	(0)	9.9	9.3-10.0																																				
Finish	(0)	(0)	8.5	7.5-8.5																																				
356 357 385 7	31 Run 11" (80 G) water into V-357 & heat to 135-140°F 32 Pump in & stir to dissolve for S 60	160	15-A	160																																				
302 302 8	33 Run 17" (208 G) water into V-302 34 Add & stir 2 min for S 62 Assume 50%	100	7-D	50																																				
PT 9	35 During strike pump into PT 36 Pump in 37 Pump in 38 Stir 10 min with lightning mixer for S 42	318 36 36	169-A 155-A 160-A	318 36 36																																				
356 385 10	39 During Strike, Run 20" (244G) water into V-356 40 Turn on steam 41 Adj to 26" (317G) at 178-182°F 42 Pump PT mixture from S38 thru undersurface Distributor AFAP 43 Rinse PT with hot water from hot water mixer & pump in 44 Shut off pump 45 Stir 30 min at 178-182°F for S 54 46 Do not shut off agitator																																							
SV 11	47 When V-349 MTY, rinse in with minimum water then set pump to zero setting 48 When V-343 MTY, rinse in with minimum water then turn off pump motor 49 Heat to 198-200°F in 5-10 min 50 Close water line & discharge valves at stearate pump 51 Open V-356 discharge valves to stearate pump inlet 52 Open water valve at stearate pump & run water thru Homog at 2900-3100 PSI to sewer 53 While Homog water at 2900-3100 PSI, open Homog discharge valve to SV & close valve to sewer 54 Immediately open stearate pump discharge valve turn on pump & Homog V-356 to SV at 2800-3100 PSI Maintain SV at 198-200°F 55 While Homog V-356 to SV, shut off water valve at stearate pump ASAP																																							



DUP050456512

N32080.01



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