

DEC 17 1979

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 04 CODE K0-786-D

PKS

DEC 19 33402

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

01 YC-10-B 93 4 32901 4000 # Bag 2
 01 YC-10-B 93 4 33051 100 # Bag
 01 YC-10-B 93 4

Total Weight 4962# (Req.)

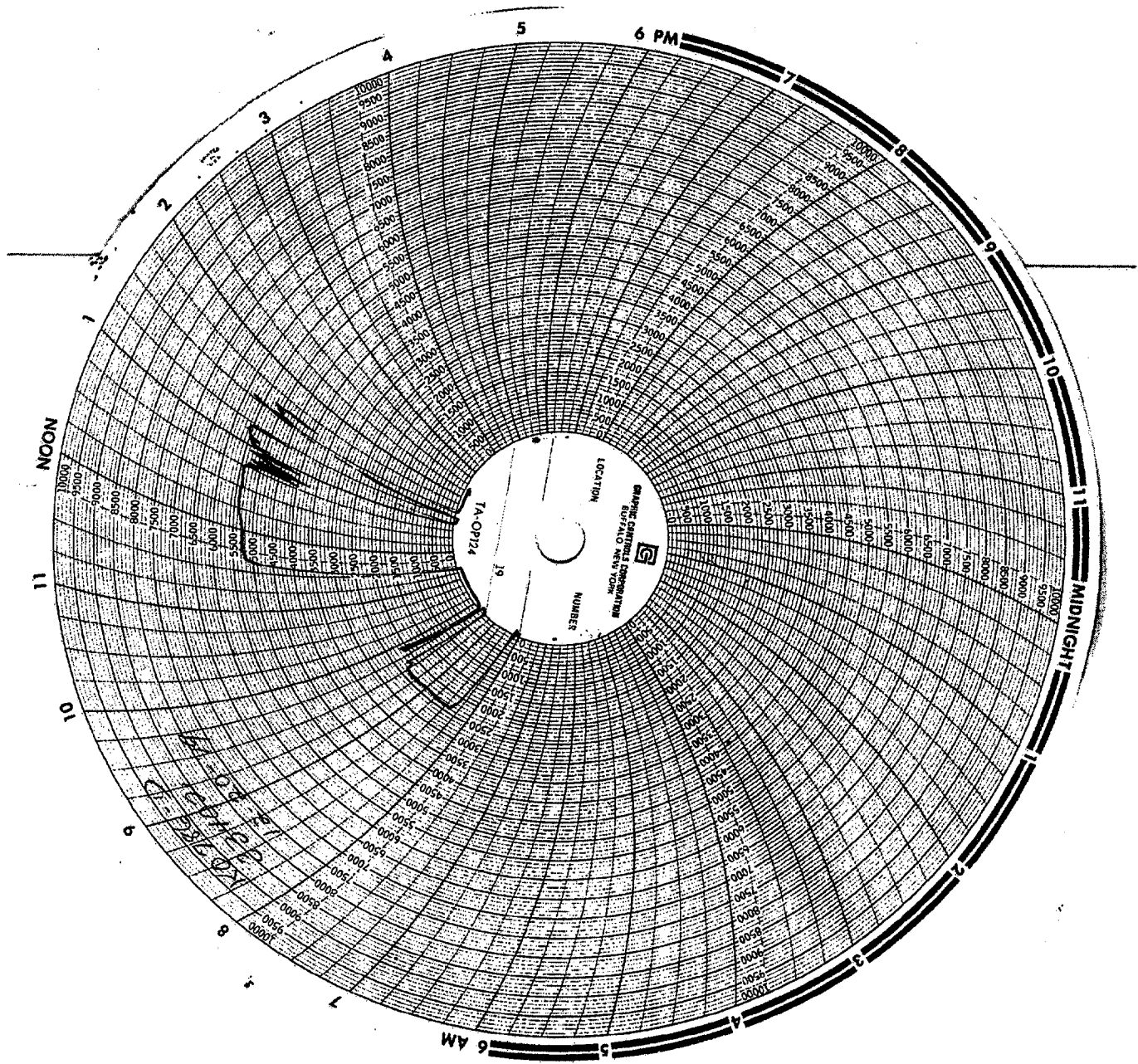
PROCESSES		APPROVED BY	
() K0-786-D	(P)	ENK 9-21-76	
()	()	DCG 9-21-76	
()	()	MTW 10-1-76	
TYPED BY			
JIC 11-16-76			

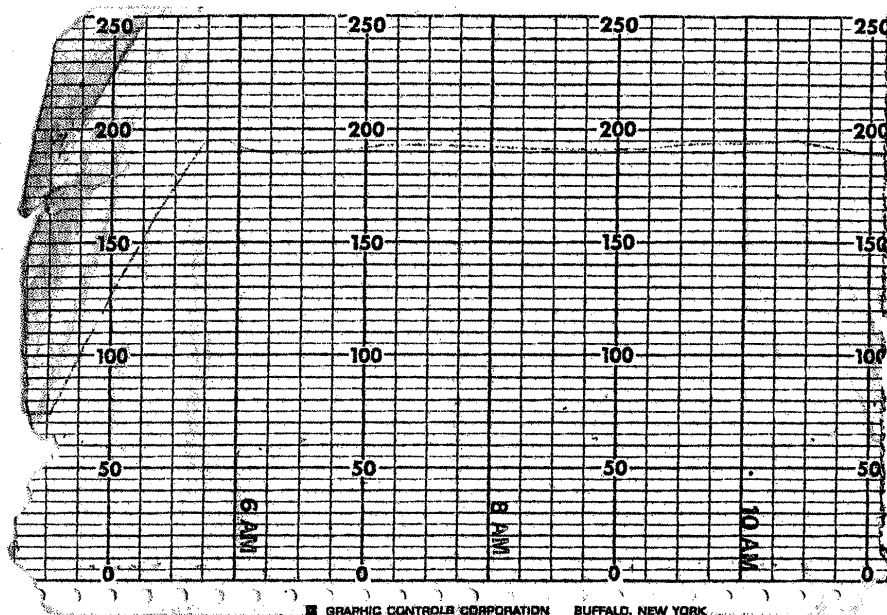
NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1 Run 60" (990 G) water in V-211 and add Assume 50% 2 Weigh in drum and pour in V-211 3 Dump in and stir 5 minutes LOT Record: Start 7:30 PM 32901 Fin 7:31 PM 33051 5" (1278 G) 4 Adjust to 80" (1370 G) 5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208 6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water 7 Record: V-208 Vol 42" and adjust to 50" (1840 G) 8 Inspect homog strainer and clean if necessary	30 270 82 x 50 4000 100	7-D 32-D YC-10-B	15 270 4100
208 & SV 2	9 Run 15" (771 G) water into V-247 and start agitator and install temperature chart 10 Pump V-208 thru Homog at 4800-5200 psi into SV Record: Time Start 11:20 A 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 & 384 3	12 While Homog, run 6" (284 G) water into V-349 13 Run ±1000# water into V-384 and heat to 110-120°F 14 Weigh into V-384 and pump to V-349 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: 8.2 g/ml (10.0 ± 0.2) (1.0178 - 1.0191)	2400	32-D	2400
SV 4	18 When S Homog complete, adjust to 66" (3400 G) in SV 19 Record: pH 11.0 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% Siphon N-7-D into SV and Record: pH 20 Heat to 190-194°F in 55-65 minutes & Record: HT F and Rec F Note: Strike must be started immediately on completion of heating		7-D	
349 & 386 5	21 While heating SV, run 5" (1400 G) water into V-343 22 Meter in from V-386 M 82 #/Gal 9.81 Gal 36.2 23 Stir 15 minutes or longer 24 Record: 8.2 g/ml (2.8 ± 0.1) (1.017 - 1.019)		27-D	355

V-247

EQUIPMENT	PAGE	CG	CODE	KO-786-D (R)	EST. WGT.	4962	LBS.	USE	N	ACT.
								LBS.	CODE	LBS.
SV	20			When S 20 heating complete. Record: pH <u>10.1</u> (9.6-10.2)						
6	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 <u>7:15 P.</u> <u>8:15 P.</u> <u>2.0</u>						
				V-349 <u>7:15 P.</u> <u>8:15 P.</u> <u>1.8</u>						
				Record: Time V-343 V-349 SV Normal						
				Inches Inches pH pH						
				at 20 min <u>7:15 P.</u> (47) <u>7.7</u> (20) <u>2.0</u> <u>9.8</u> 9.3-10.0						
				40 min <u>7:55 P.</u> (43) <u>7.3</u> (17) <u>1.7</u> <u>9.8</u> 9.3-10.0						
				1 hr <u>8:15 P.</u> (38) <u>3.8</u> (15) <u>1.5</u> <u>9.8</u> 9.3-10.0						
				2 hrs <u>8:15 P.</u> (24) <u>2.4</u> (7) <u>1</u> <u>9.8</u> 9.3-10.0						
				3 hrs <u>7:15 P.</u> (10) <u>10+</u> (0) <u>1</u> <u>9.8</u> 9.3-10.0						
				Finish <u>8:10 P.</u> (0) <u>8.0</u> 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	30			Run 21" (150 G) water into V-357 and heat to 135-140°F						
7	31			Dump in and stir to dissolve				300	15-A	300
302	32			Add 42" (514 G) water to V-302						
8	33			Add and stir 2 minutes Assume 50%				150	7-D	75
SV	34			When V-349 MTY. rinse in with minimum water then set pump to zero setting						
9	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>3.1</u> (3.3-3.7)						
	39			If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH					15-A	
	40			Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes						
	41			Record: pH <u>4.2</u> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH <u>4.1</u> 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						
				<u>11:00 P.</u> <u>7:00 A.</u> <u>235-301</u>						
				<u>7:00 A.M.</u> <u>3:00 P.M.</u> <u>409</u>						
				<u>3:15 P.</u> <u>9:40 P.M.</u> <u>201-27</u>						





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