MAKING INSTRUCTIONS: BATCH UNIT

246, 247 (245) C.V. D.V.

04 CODE KO-789-D PKG.

JAN 23 33931

WT 762 ~~1132~~ LBS.

PROCESSES		APPROVED BY
( ) KO-789-D	(I)	EWK 09-21-76
( )	( )	DCG 09-21-76
( )	( )	MTW 10-02-76
( )	( )	FWP 02-05-79
TYPED BY emw020579		

OK / KP

10.8 TIME 7 AM

01 YC-16-B 93 4 Lot 30094, 50#

01 YC-16-B 93 4 Lot 33655, 1050#

01 YC-16-B 93 4 Lot 32521, 1150#

01 YC-16-B 93 33478 850#

Total Weight ~~5332#~~ 3862 (Req _____)

NON-BLEEDING

		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run 60" (990 G) water into V-211			390
	2	Weigh in drum & pour in	390 ~~530~~	32-D	~~530~~
	3	Dump in & stir 5 min Lot 62	~~24~~ x 50	YC-16-B	~~4200~~ 3100
		Record: Start 12:15 PM 30094	1		
		Fin 2:00 33655	21		
		32521	23		
	4	Adj to 70" 1200 G) 2800-3200 33478	17		
	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. Use Hot Water	62		
	7	Record: V-208 Vol 41 " & adj to 54" (1890 G)			
	8	Inspect Homog strainer & clean if necessary			
208 & SV 2	9	Run 10" (514 G) water into V-245 & start agitator & install temperature chart			
	10	Pump V-208 thru Homog at 4800-5200 psi into SV-245			
		Record: Time Start 12:30 PM Total Min 135			
		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 & pump thru Homog at 4800-5200 psi. Rinse in using Hot Water			
349 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ± 1000# water into V-384 & heat to 110-120°F	1880		1880
	14	Weigh into V-384 & pump to V-349	~~2930~~	32-D	~~2930~~
	15	Run ± 1000# water into V-384 & pump to V-349			
	16	Adj V-349 to ~~30" (1400 G)~~ & stir 15 min or longer 22" (1040 G)			
	17	Record: °Be 1.06 g/mL ~~(10.0 ± 0.2)~~ (1.061 - 1.064)			
SV 4	18	When S 10 Homog complete, adj SV to 45" (2300 G)			
	19	Record: pH 10.4 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	10	7-D	10
		Siphon N-7-D into SV & Record: pH 11.2			
	20	Heat to 190-194°F in 55-65 min & Recrod: HT ____ °F & Rec ____ °F			
		NOTE: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run ~~70" (1920 G)~~ 52" (1430 G) water into V-343			
	22	Meter in from V-386 M 10, 9.502#/Gal 30.5 Gal		27-D	~~440~~ 290
	23	Stir 15 min or longer			
	24	Record: °Be 1.015 g/mL ~~(2.5 ± 0.1)~~ (1.013 - 1.015)			

V-Z 45

PAGE 2 CG 04 CODE KO-789-D (I) EST. WGT. 5332 LBS.

PMENT			USE LBS.	N CODE	ACCT LBS.
SV 6	25	When S 20 heating complete, Record: pH 9.9 (9.6-10.2)			
	26	Set V-343 acid pump at ~~26~~ setting (± 255 minutes) 65			
	27	Set V-349 silicate pump at ~~22~~ setting (± 210 minutes) 54			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start Fin Min V-343 4:30 PM 9:15 AM V-349 6:25 AM 215			

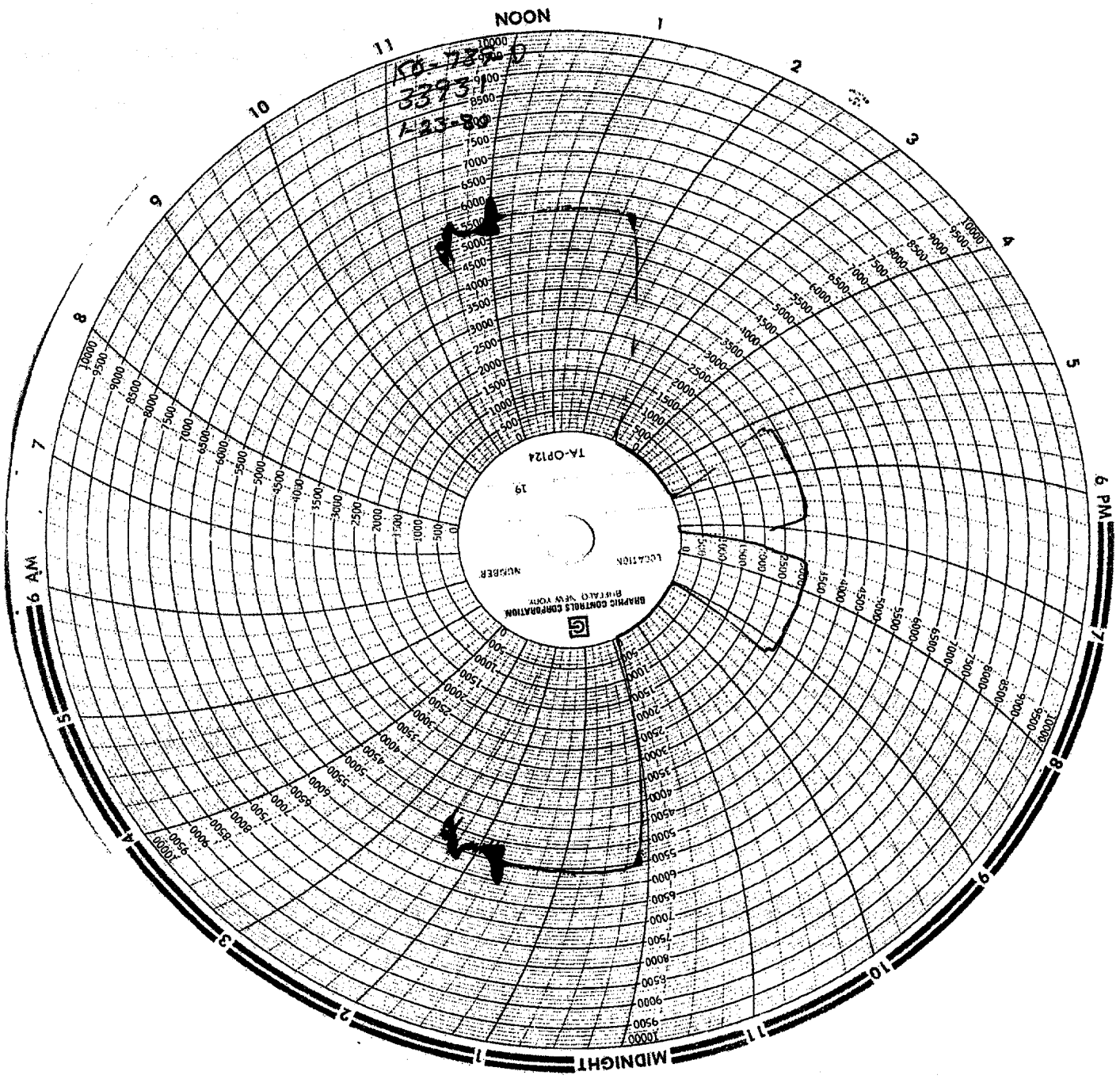
Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	5:10 A	(~~26~~) 49	(~~27~~) 30	9.7	9.3-10.0
40 min	5:30 A	(~~60~~) 45	(~~24~~) 18	9.7	9.3-10.0
1 hr	5:50 A	(~~55~~) 41	(~~21~~) 16	9.7	9.3-10.0
2½ hrs	7:05 A	(~~34~~) 25	(~~14~~) 2 +	9.6	9.3-10.0
3½ hrs	9:30 A	(~~13~~) 9	0 +	9.55	9.3-10.0
Finish	9:15 A	0		6.95	7.5- 8.5

NOTE: If pH drops below 9.3 in 1st hr, stop pumps & see Supervisor. If final pH is above 8.5, adj to 7.5-8.5 & Record: pH

			Assume 77%	27-D	
357 7	30	Run 33" (238 G) water into V-357 & heat to 135-140°F			~~390~~
	31	Dump in & stir to dissolve	~~530~~	15-A	~~530~~
302 8	32	~~Add~~ 42" (514 G) water to V-302			
	33	Add & stir 2 min	Assume 50% ~~330~~	7-D	~~165~~ 190
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump at zero setting			
	35	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	36	Stir 30 min at 190-194°F then turn off steam Record: Start 9:20 AM			
	37	Run in V-357 from S 31 & stir 5 min			
	38	Record: pH 3.4 (3.4-3.8) & if necessary, adj (DOWN ONLY) to 3.4-3.8 & Record: pH NOTE: Dissolve extra N-15-A in water at 135-140°F in drum, use ±30 G water to 50# N-15-A. Stir SV 5 min after each addition		15-A	
	39	Run in N-7-D from S 33 in 10-12 min & stir 5 min			
	40	Record: pH 4.6 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.4	Assume 77% 28	27-D	14
		(Dilute 10 parts water to 1 part N-7-D)	Assume 50%	7-D	
		Siphon N-7-D into SV			37
	41	Pour in & stir 15 min	~~25~~	978-A	~~25~~
	42	Stop agitator			

START	FIN	OPTR
3:00 PM	11:00 PM	438-409
11:00 PM	7:00 AM	244-3-7
7:00 A	11:00 AM	235

DUP050095100



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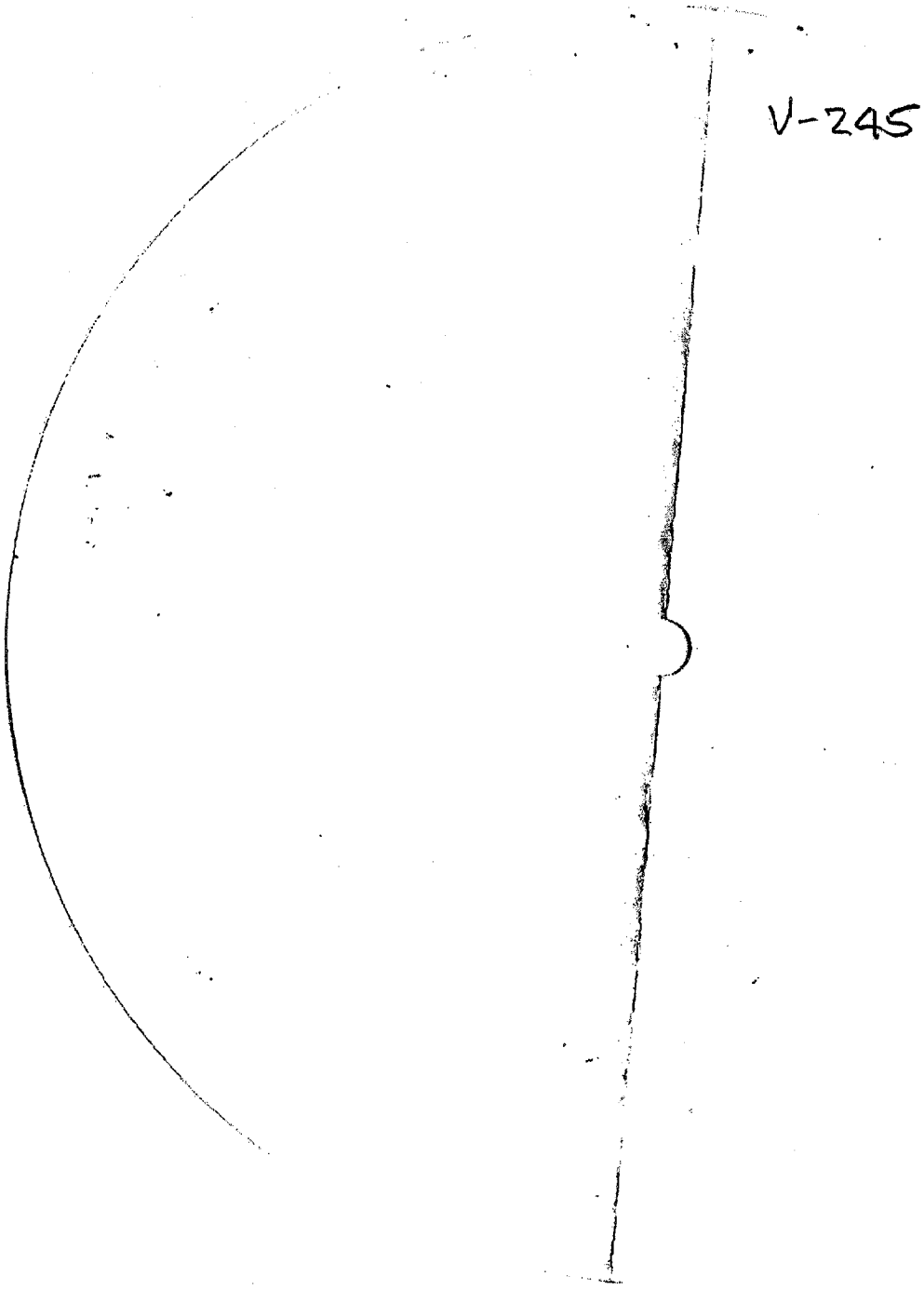
V-245

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No. 215A250
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10 PM
8 PM
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