MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244, 246, 247, 262 C.V. D.V.

CG 03 CODE KY-795-D PKG.

→ MAR-8 34766

EST. WGT. 1178 LBS.

STD. HRS. 11.1 TIME 7:1 M

PUNCHED & CHECKED OK

MAR 13 1980

KP

PROCESSES		APPROVED BY
( ) KY-795-D	(I)	EWK 10/5/76
( ) ALTERNATE	( )	DCG 10/7/76
( )	( )	MTW 10/11/76
( )	( )	
TYPED BY		
NE 3/3/77		

14 YC-2-B 93 4 Lot 24471, 2000
14 YC-2-B 93 4 Lot 24478, 1700
14 YC-2-B 93 4 Lot ____, ____

Homog # 4 - 1st Pass
" # 4 - 2nd "

Total Wgt. 4878#

NON-BLEEDING

QUIPMENT		NAME: "KROLOR" YELLOW - MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1	Run ~~26" (410 G)~~ 60" (1990 G) water in V-203. RUN AGITATOR ON HIGH SPEED.			
	2	Weigh in drum & pour in	500	32-D	500
	3	Dump in & stir 5 min Lot	74x50	YC-2-B	3700
		Record: Start 24471	2000		
		Fin 24478	1700		
	4	Adj to ~~78" (1328 G)~~ 75" (1275 G) 2400-2600			
	5	Pump V-203 thru Homog # 3 at ~~1800-2200~~ psi into V-205			
	6	When V-203 MTY wash color thru Homog at 1800-2200 psi using minimum water			
	7	Record: V-205 Vol 40 " & adj to 51" (1874 G)			
	8	Inspect homog. strainer & clean if necessary			
		DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED.			
SV & 205 2	9	Run 5 "(514 G) water into V-262 install temp charts & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into SV			
		Record: Time Start 7:15AM Total Min 150			
		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 3	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	2830	32-D	2830
	15	Run ±1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 29" (1372 G) & stir 15 min or longer			
	17	Record: Be' 1.072 ~~(9.85 ± 0.2)~~ (1.070-1.073) g/mL			
SV 4	18	When S 11 Homog complete, adj. to 35 " (3495 G)			
	19	Record: pH 10.6 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	25	7-D	13
		Siphon into SV & Record: pH 11.3			
	20	Heat to 190-194°F in 55-65 min & Record: HT 190°F & Rec 194°F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 69" (1898 G) water into V-343			
	22	Meter in from V-386 M21 9.18 #/Gal 453 Gal		27-D	416
	23	Stir 15 min or longer			
	24	Record: Be' 1.013 ~~(2.3 ± 0.1)~~ (1.014-1.015) g/mL			
SV 6	25	When S 20 heating complete Record: pH 9.8 (9.5-10.0)			
	26	Set V-343 acid pump at 96 setting (±225 min)			
	27	Set V-349 Silicate pump at 82 setting (± 180 min)			
	28	Immediately meter in V-343 & V-349. Maintain SV at			

13829 REV.

N 2627

V-262

EQUIPMENT		PAGE 2 CG 03 CODE KY-795-D(I) ALT EST. WGT. 4878 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6 Cont.	29	Record: Start / Finish / Minutes V-343 4.15PM / 8.30PM / 255 V-349 / 7.30PM / 180			

Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	4.35P	(64) 64	(26) 26	9.7	9.0-10.0
40 min	4.55P	(58) 58	(23) 23	9.7	9.0-10.0
1 hr	5.15P	(51) 51½	(19) 19½	9.7	9.0-10.0
2 hrs	6.15P	(33) 36½	(10) 11½	9.7	9.0-10.0
3 hrs	7.15P	(14) 18	(0) 2	9.6	9.0-10.0
Finish	8.00PM	(0) 5	—	6.6	7.5-8.5

Note: If pH drops below 9.0 in 1st. hr. stop pumps & see Supv.
If pH, above 8.5 at final adj to 7.5-8.5
Record: pH Assume 77% — 27-D

357 7	30	Run 15" (108 G) water into V-357 & heat to 135-140°F			
	31	Dump in & stir to dissolve for S 38	220	15-A	220
Drum 8	32	Weigh into 55 Gal Drum Assume 50%	60	7-D	30
	33	Fill with water & stir 2 min for S 40			
SV	34	When V-349 MTY, rinse in with minimum water then set pump to zero setting			
	35	When V-343 MTY, rinse in with minimum water then turn off pump motor			
9	36	Turn off steam			
	37	Sift in 3 bags	150	128-A	150
	38	Run in V-357 from S 31 & stir 5 min			
	39	Record: pH 3.2 (3.3-3.7) & if necessary adj (down only) to 3.3-3.7 & Record: pH		15-A	
		Note: Dissolve extra N-15-A in water at 135-140°F in drum. Use ± 40 Gal water to 50# N-15-A. Stir SV 5 min after each addition.			
	40	Siphon in N-7-D from S 33 in 4-6 min & stir 5 min			
	41	Record: pH 3.6 (4.0-4.2) & if necessary adj to pH 4.0-4.2 & Record: pH 4.0 Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	46	7-D	23
		Siphon N-7-D into SV			
	42	Pour in & Stir 15 min	45	978-A	45
	43	Stop agitator			

Start	Fin	Optr
7:00AM	3:00PM	438-409
7:00AM	3:10PM	409-381
3:00PM	10:55PM	144-145

Step	V-262 (20 RPM)	V-243, 244, 247
9	5"	10"
18	35"	68"

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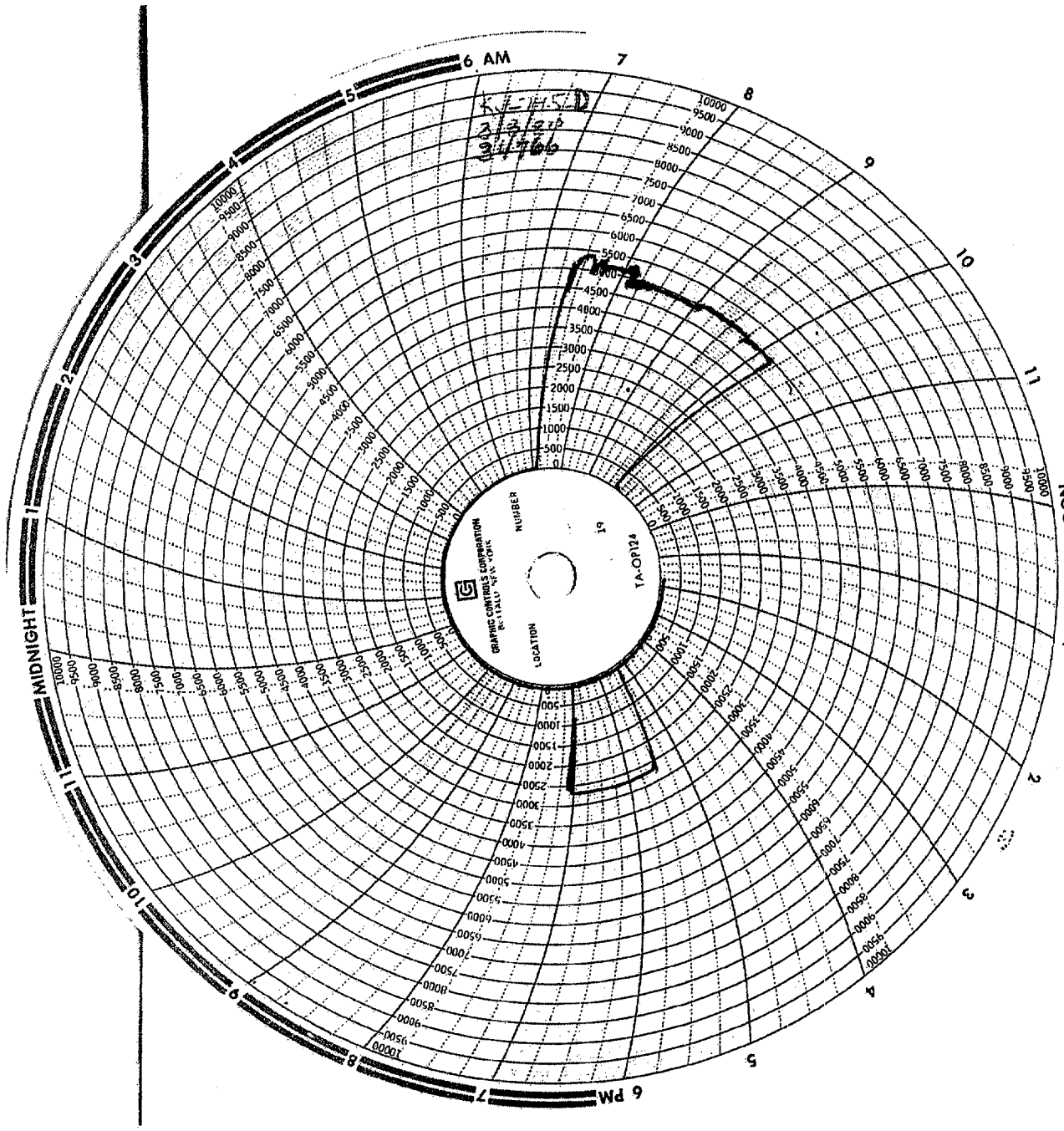

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