

DEC 18 1979

MAKING INSTRUCTIONS: BATCH UNIT

V. 246 247

C.V.

D.V.

04 CODE KO-786-D PKG.

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

01	YC-10-B	93	4	32904	4100	#
01	YC-10-B	93	4			#
01	YC-10-B	93	4			#

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

Total Weight 4962# (Req.)

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211 & 208	1 Run 60" (990 G) water in V-211 and add Assume 50%	2020	7-D	1015
1	2 Weigh in drum and pour in V-211	270	32-D	270
	3 Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
	Record: Start 5:30 PM 32904	4100		
	Fin 7:15 PM			
	75" (1275 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 43 " and adjust to 50" (1840 G)			
	8 Inspect homog strainer and clean if necessary			
208 & SV 2	9 Run 15" (771 G) water into V-246 and start agitator and install temperature chart			
	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
	Record: Time Start 11:30 AM 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	12 While Homog, run 6" (284 G) water into V-349			
3	13 Run 1000# water into V-384 and heat to 110-120°F			
	14 Weigh into V-384 and pump to V-349	2400	32-D	2400
	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: pH 10.8 (10.9 ± 0.2) 1.028 - 1.081			
SV 4	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
	19 Record: pH 10.8 and adjust to 10.4-10.8 using N-7-D diluted to 8% (10 parts water to 1 part N-7-D) Assume 50%		7-D	
	Siphon N-7-D into SV and Record: pH			
	20 Heat to 190-194°F in 55-65 minutes & Record: HT 92 F and Rec 192 F			
	Note: Strike must be started immediately on completion of heating			
343 & 386	21 While heating SV, run 51" (1400 G) water into V-343			
5	22 Meter in from V-386 M 8.3 #/Gal 700 Gal 3.5.9		27-D	355
	23 Stir 15 minutes or longer			
	24 Record: pH 10.1 (10.2 ± 0.1) 1.012 - 1.019			

2/m2

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IPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACTY. LBS.
SV 6	2	04	K0-786-D (H)	4962				
	23	When S 20 heating complete, Record: pH <u>10.1</u> (9.6-10.2)						
	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	6:00 P	8:50 P	230			
		V-349	6:00 P	9:00 P	180			
		Record:	Time	V-343	V-349	SV	Normal	
				Inches	Inches	pH	pH	
		at 20 min	6:20 P	(47) 47	(20) 20	9.8	9.3-10.0	
		40 min	6:40 P	(43) 43	(17) 17	9.8	9.3-10.0	
		1 hr	7:00 P	(38) 38	(15) 15	9.8	9.3-10.0	
		2 hrs	8:00 P	(24) 24	(7) 7	9.8	9.3-10.0	
		3 hrs	9:00 P	(10) 12	(0) 10	9.8	9.3-10.0	
		Finish	9:45 P	(0)		7.4	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 7	30	Run 21" (150 G) water into V-357 and heat to 135-140°F						
	31	Dump in and stir to dissolve						
						300	15-A	300
302 8	32	Add 42" (514 G) water to V-302						
	33	Add and stir 2 minutes Assume 50%						
						150	7-D	75
SV 9	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						
	36	TURN OFF STEAM						
	37	Run in V-357 from S 31 and stir 5 minutes						
	38	Record: pH <u>3.3</u> (3.3-3.7)						
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH						
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes						
	41	Record: pH <u>4.1</u> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH Assume 77%						
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%						
		Siphon N-7-D into SV						
	42	Stop agitator						
		START	FINISH	OPTR				
		7:00 P	8:00 P	235-347				
		3:45 P	7:30 P	27-126				



