

243, 244, 245, 247, (262)

C.V.

D.V.

CG 03 CODE KY-787-D PKG.

PUNCHED & CHECKED

→ MAY 12 95711

EST. WGT. 1090 LBS.

MAY 15 1980

STD. HRS. TIME

14 YC-2-B 93 4 Lot 24874, 2000 #
14 YC-2-B 93 4 Lot 24474, 400 #
14 YC-2-B 93 4 Lot , #

PROCESSES		APPROVED BY	
() KY-787-D	(R)	EWK 10-19-77	
() Alternate	()	DCG 10-25-77	
()	()	MTW 10-26-77	
()	()	FWP 02-16-79	
TYPED BY			
emw021679			

MAY 13 1980

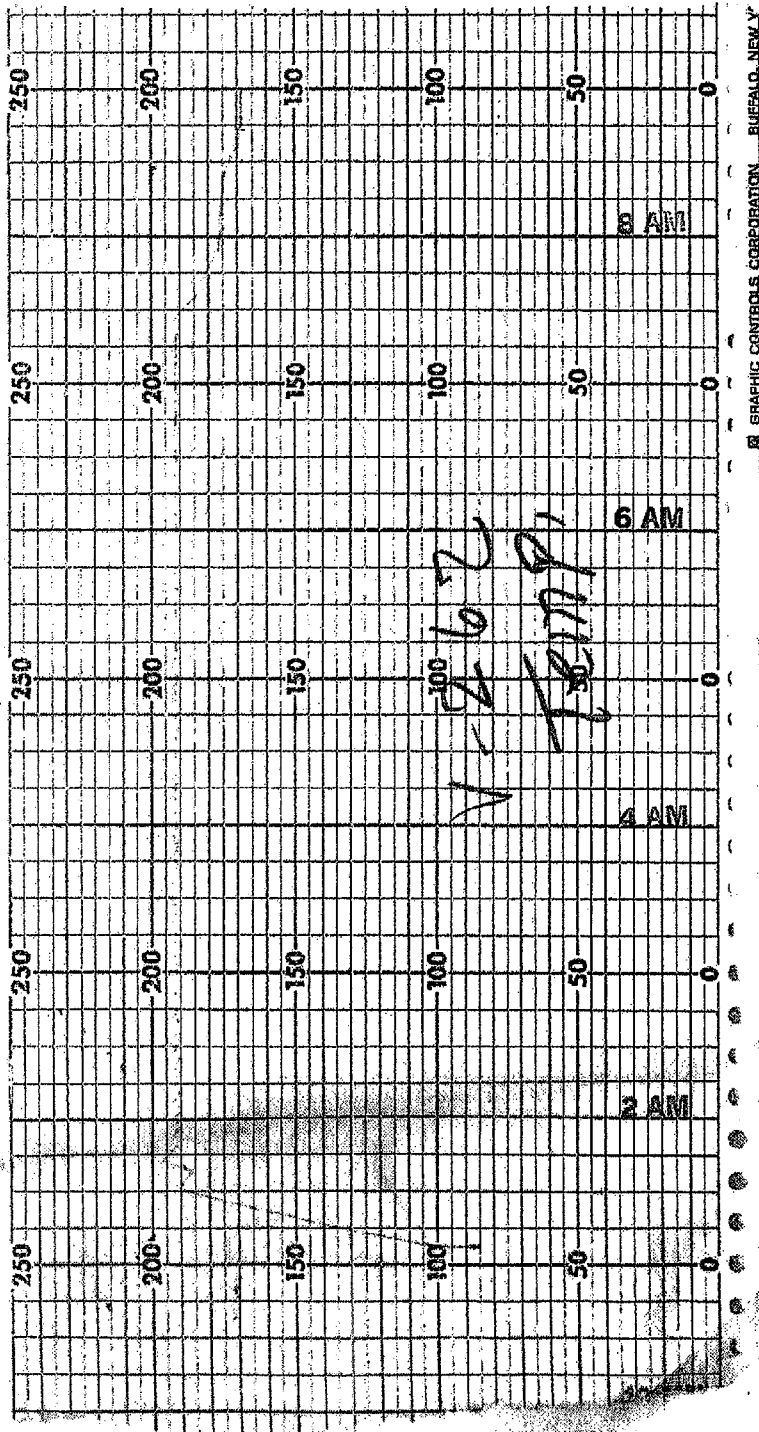
Total Wgt 3490# (Req)

NON-BLEEDING

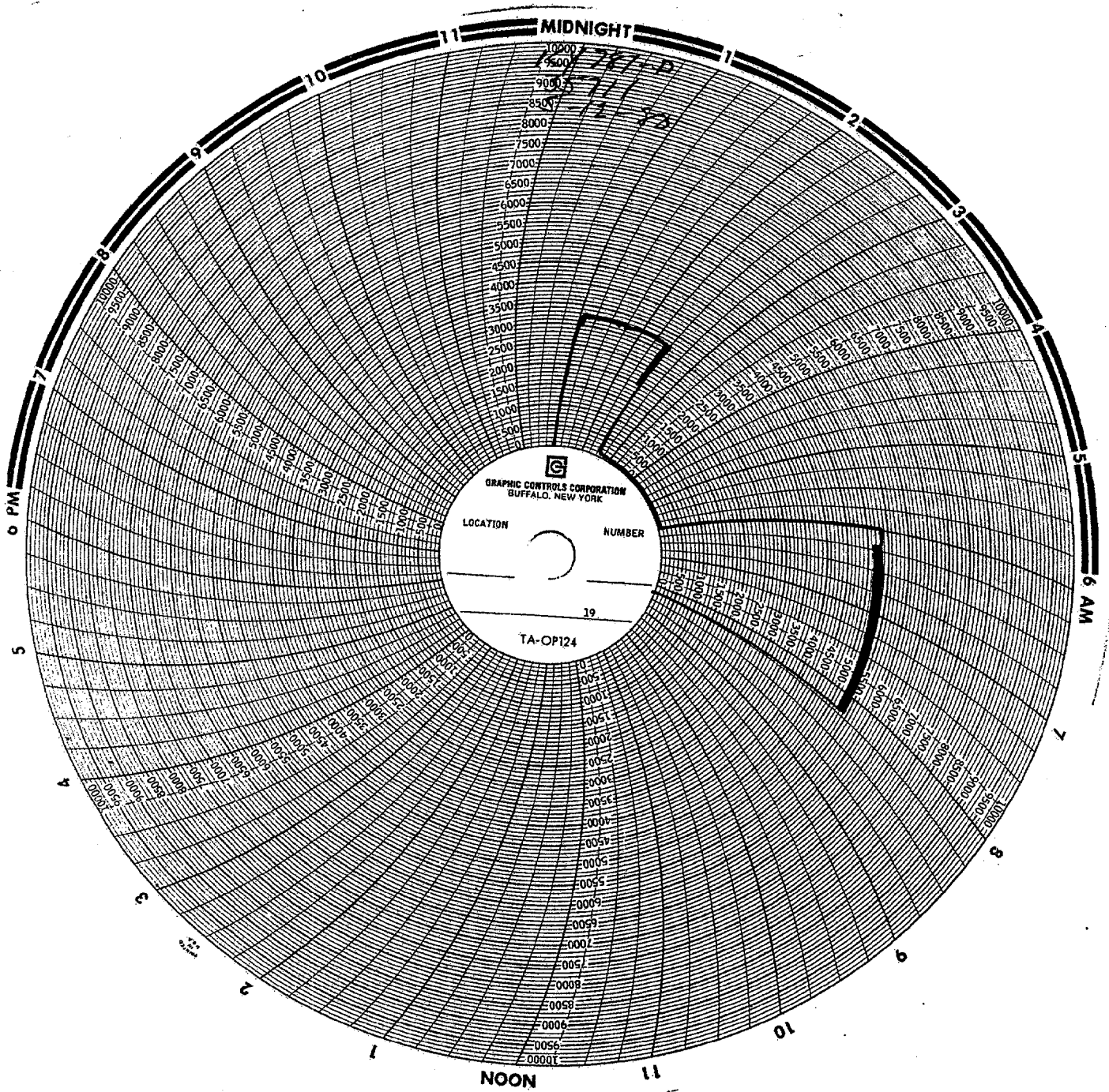
MENT	NAME	USE LBS.	N CODE	ACCT. LBS.
203	1 Run 60" (992 G) water into V-203			
&	2 Weigh in drum & pour in	320	32-D	320
205	3 Dump in & stir 5 min	48 x 50	YC-2-B	2400
1	Record: Start			
	Fin			
	75" (127.5 G)			
	4 Adj to 80" (1360 G)			
	5 Pump V-203 thru Homog at 2400-2600 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7 Record: V-205 Vol. 19" & adj to 54" (1900 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
SV	9 Run 2" (200 G) water into V-262 & install temp chart			
&	10 & start agitator			
205	10 Pump V-205 thru Homog at 4800-5200 psi into SV-262			
2	Record: Time Start 5:55 AM Total Min 120			
	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. Rinse in using Hot Water			
349	12 While Homog, run 6" (284 G) water into V-349			
&	13 Run ± 1000 # water into V-384 & heat to 110-120°F			
384	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 22" (1020 G) & stir 15 min or longer			
	17 Record: 0.062 (8.7 ± 0.2) (1.060 - 1.064)			
SV	18 When S 11 Homog complete, adj SV to 26" (2100 G)			
4	19 Record: pH 10.5 & 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	10
	Siphon into SV & Record: pH 11.1			
	20 Heat to 190-194°F in 35-45 min (V-262) or in 55-65 min (V-243, 244, 246, 247) &			
	Record: HT OF & Rec 190 OF			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 49" (1355 G) water into V-343			
&	22 Meter in from V-386 M 33, 10.50 #/Gal 26.7 Gal		27-D	275
386	23 Stir 15 min or longer			
5	24 Record: 0.061 (2.2 ± 0.1) (1.012 - 1.015)			

V-262

EQUIPMENT	PAGE 2 CG 03 CODE KY-787-D (R) EST. WGT.	3490 LBS.	USE LBS.	N CODE	A
SV 25	When S 20 heating complete, Record: pH <u>9.9</u> (9.6-10.2)				
6 26	Set V-343 acid pump at 62 setting (± 255 min)				
27	Set V-349 silicate pump at 52 setting (± 210 min)				
28	Immediately meter in V-343 & 349, maintain SV at 190-194°F during strike				
29	Record:	Start	Fin	Min	
	V-343	<u>1:40 PM</u>	<u>6:20 PM</u>	<u>2:00</u>	
	V-349		<u>8:30 PM</u>	<u>2:30</u>	
	Record:	Time	V-343 in	V-349 in	SV pH Normal pH
	at 20 min	<u>2:00 PM</u> (47)	(20)	-	<u>9.9</u> 9.3-10.0
	40 min	<u>2:20</u> (43)	(18)	-	<u>9.9</u> 9.3-10.0
	1 hr	<u>2:40</u> (39)	<u>31+</u> (15)	<u>45</u>	<u>10.0</u> 9.3-10.0
	2 1/2 hrs	<u>3:55</u> (24)	<u>28</u> (8)	<u>9</u>	<u>10.0</u> 9.3-10.0
	3 1/2 hrs	<u>5:10</u> (9)	<u>19</u> (0)	<u>2</u>	<u>10.0</u> 9.3-10.0
	Finish	<u>6:20</u> (0)	-	-	<u>8.3</u> 7.5-8.5
	NOTE: 1) If pH not as specified, notify Supervisor & note in log				
	2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH Assume 78%				
	27-D				
NOTE: 330 30 7	29A Stir 1 hr at 190-194°F at end of strike				
	30 Run 35" (600 G) water into V-330 & heat to 160-170°F				
	31 Add in 12-13 min			350	530-A 350
	32 Stir 5 min & Record: pH <u>10.1</u> (9.5-10.5)				
	33 Stir 20 min or longer to dissolve for S 46				
356 357 8	34 Run 11" (80 G) water into V-357 & heat to 135-140°F				
	35 Dump in & stir to dissolve for S 42			160	15-A 160
302 9	36 Run 42" (513 G) water into V-302				
	37 Add & stir 2 min for S 44			Assume 50%	160 7-D 80
SV 10	38 When V-349 MTY, rinse in with minimum water then set pump to zero setting				
	39 When V-343 MTY, rinse in with minimum water then turn off pump motor				
	40 Turn off steam				
	41 Stir in			100	N-65 120-A 100
	42 Run in V-357 from S 35 & stir 5 min				
	43 Record: pH <u>4.0</u> (3.7-4.2)				
	44 Run in N-7-D from S 37 in 10-12 min & stir 5 min				
	45 Record: pH <u>9.3</u> (9.0-9.5) & if necessary, adj to pH 9.0-9.5 & Record: pH Assume 78%				27-D
	(Dilute 10 parts water to 1 part N-7-D)			Assume 50%	7-D
	Siphon N-7-D into SV				
	46 Run in V-330 thru 20 mesh screen & stir 20 min				
330 11	47 Run 11" (216 G) water into V-330 & dump in			135	20-A 135
	48 Stir 5 min to dissolve for S 49				
SV 12	49 Run V-313 into SV in 15-20 min				
	50 Stir 15 min				
	51 Record: pH <u>9.3</u> (9.0-10.0)				
	52 Do not stop agitator				
	Step V-262 (20 RPM) V-243, 244, 246, 247				
	9 2" 4"				
	18 26" 50"				
	START	FIN	OPTR		
	<u>1:230</u>	<u>7 AM</u>	<u>2:22</u>		
	<u>3:00 PM</u>	<u>3:00 PM</u>	<u>3:01</u>		
	<u>3:00 PM</u>	<u>8:45 PM</u>	<u>2:55</u>		



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



N32030.02

DUP050456305

V-262

DUP050456306

N32030.03