

MAKING INSTRUCTIONS: BATCH UNIT

S.V.

C.V.

D.V.

04 CODE KO-786-D PKG.

DEC 18 33568

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 11:15 M

01 YC-10-B 93 4 33369 4100 # Bay 2
01 YC-10-B 93 4 #
01 YC-10-B 93 4 #

PROCESSES		APPROVED BY	
() KO-786-D	(P)	ENK 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	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 Record: Start 100 AM 33369 Fin 300 AM 4100 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. 50" and adjust to 50" (1840 G) 8 Inspect homog strainer and clean if necessary	30 270 82 x 50 4100	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 7:30 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 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: 0Be 1.081 (10.9 ±0.2) (1.078-1.081) g/mL	2400	32-D	2400
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 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 190 F and Rec 194 F Note: Strike must be started immediately on completion of heating		7-D	
343 & 386 5	21 While heating SV, run 51" (1400 G) water into V-343 22 Meter in from V-386 M 8.3 #/Gal 9.88 Gal 36.2 23 Stir 15 minutes or longer 24 Record: 0Be 1.072 (2.8 ±0.1) (1.017-1.019) g/mL		27-D	355

247.

QUIPMENT	PAGE	CG 04	CODE	K0-786-D (R)	EST. WGT.	4962	LBS.	USE	N	ADJ.
								LBS.	CODE	LBS.
SV 6	25	When S 20 heating complete. Record: pH 10.0 (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		1:30 PM		5:25 PM		235		
		V-349		1:30 PM		4:30 PM		180		
		Record:	Time	V-343	V-349	SV	Normal			
				Inches	Inches	pH	pH			
		at 20 min	1:50 PM	(47) 4 7	(20) 20	9.5	9.3-10.0			
		40 min	2:10	(43) 43	(17) 17	9.5	9.3-10.0			
		1 hr	2:30	(38) 38	(15) 15	9.5	9.3-10.0			
		2 hrs	3:30	(24) 24	(7) 7	9.5	9.3-10.0			
		3 hrs	4:30	(10) 10	(0) 0	9.5	9.3-10.0			
		Finish	5:15 PM	(0) 0	(0) 0	8.3	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 3.5 (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 4.1 (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						
		3:00 AM	7:00 AM	322-126						
		7:00 AM	3:00 PM	237-120						
		3:00 PM	6:30 PM	223						

REQUEST NO.

0503

DATE 12/27/79

DELIVER TO Making Area BLDG. 6 FLOOR 3RD BY 2/28/79 11⁴⁵ AM

FOR CODE 809860 LOT 33568

WRITTEN BY _____ **Production Control**

DUP050095490

PICK UP AND RETURN TO STORAGE THE FOLLOWING:

LOCATED IN _____ BLDG., _____ FLOOR.

FLOOR.

[illegible]

***Each Supervisor must explain weight differences on reverse side.**

PRODUCTION CONTROL COPY
-- WHITE
-- YELLOW
-- GREEN
WAREHOUSE FILE COPY
-- BLUE
RAW MATERIAL FILE COPY
-- PINK
PRODUCTION CONTROL FILE COPY -- PINK

PLACED IN LOCATION BY: OPER. # _____ DATE _____ SUPVR. _____



