

INVENT		PAGE 2 CG 04 CODE K0-789-D (1) EST. WGT. 5199 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	25	When S 20 heating complete, Record: pH <u>10.0</u> (9.6-10.2)			
	26	Set V-343 acid pump at 76 setting (± 225 minutes)			
	27	Set V-349 silicate pump at 60 setting (± 180 minutes)			
	28	Immediately meter in V-343 and V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start Finish Minutes			
		V-343 <u>11:35</u> <u>330 P</u> <u>215</u>			
		V-349 <u>11:35</u> <u>235</u> <u>180</u>			
		Record: TIME V-343 V-349 SV NORMAL			
		INCHES INCHES pH pH			
		at 20 min <u>11:57</u> (56) = (19) = <u>9.9</u> 9.3-10.0			
		40 min <u>12:15</u> (45) = (18) = <u>9.9</u> 9.3-10.0			
		1 hr <u>12:35</u> (40) = (14) = <u>9.8</u> 9.3-10.0			
		2 hrs <u>1:35</u> (26) = (7) = <u>9.8</u> 9.3-10.0			
		3 hrs <u>2:35</u> (18) <u>10</u> (0) = <u>9.6</u> 9.3-10.0			
		Finish <u>3:20</u> (0) <u>7.9</u> 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	
	30	Run 33" (238 G) water into V-357 and heat to 135-140°F			
	31	Dump in and stir to dissolve	530	15-A	530
302	32	Add 42" (514 G) water to V-302			
8	33	Add and stir 2 minutes Assume 50%	330	7-D	165
SV	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 60 minutes at 190-194°F then turn off steam			
		Record: Start <u>330 P</u>			
	37	Run in V-357 from S 31 and stir 5 minutes			
	38	Record: pH <u>3.2</u> (3.4-3.8) and if necessary, adjust (down only) to 3.4-3.8 and Record: pH		15-A	
		Note: Dissolve extra N-15-A in water at 135-140°F in drum, use ± 30 Gal water to 50# N-15-A. Stir SV 5 minutes after each addition			
	39	Run in N-7-D from S 33 in 10-12 minutes and stir 5 minutes			
	40	Record: pH <u>6.2</u> (6.2-6.4) and if necessary, adjust to pH 6.2-6.4 and Record: pH Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV			
	41	Pour in and stir 15 minutes	✓ 50	978-A	50
	42	Stop agitator			
		START FIN OPTR			
		<u>3:00 P</u> <u>11:00 P</u> <u>2:35-33</u>			
		<u>11:00 PM</u> <u>2:00 PM</u> <u>201-227</u>			
		<u>1:00 PM</u> <u>5:30 P</u> <u>282-701</u>			
		<u>3:00 P</u> <u>5:30 P</u> <u>259-175</u>			

N32314

MAKING INSTRUCTIONS: BATCH UNIT

246, 247

C.V.

D.V.

QA CODE KO-789-D

PKG.

API 24

35492

PUNCHED & CHECKED

EST. NO. 1199

LBS. ~

APR 29 1980

STD. HRS. 10.8

TIME

7A M

PROCESSES		APPROVED BY	
()	KO-789-D	()	EWK 9-21-76
()		()	DCG 9-21-76
()		()	MTW 10-2-76
TYPED BY			
JIC 10-8-76			

01 YC-16-B 93 4

33978

550

01 YC-16-B 93

34837

1600#

01 YC-16-B 93 4

34833

650

01 YC-16-B 98

72335

40#

01 YC-16-B 93 4

34835

1200

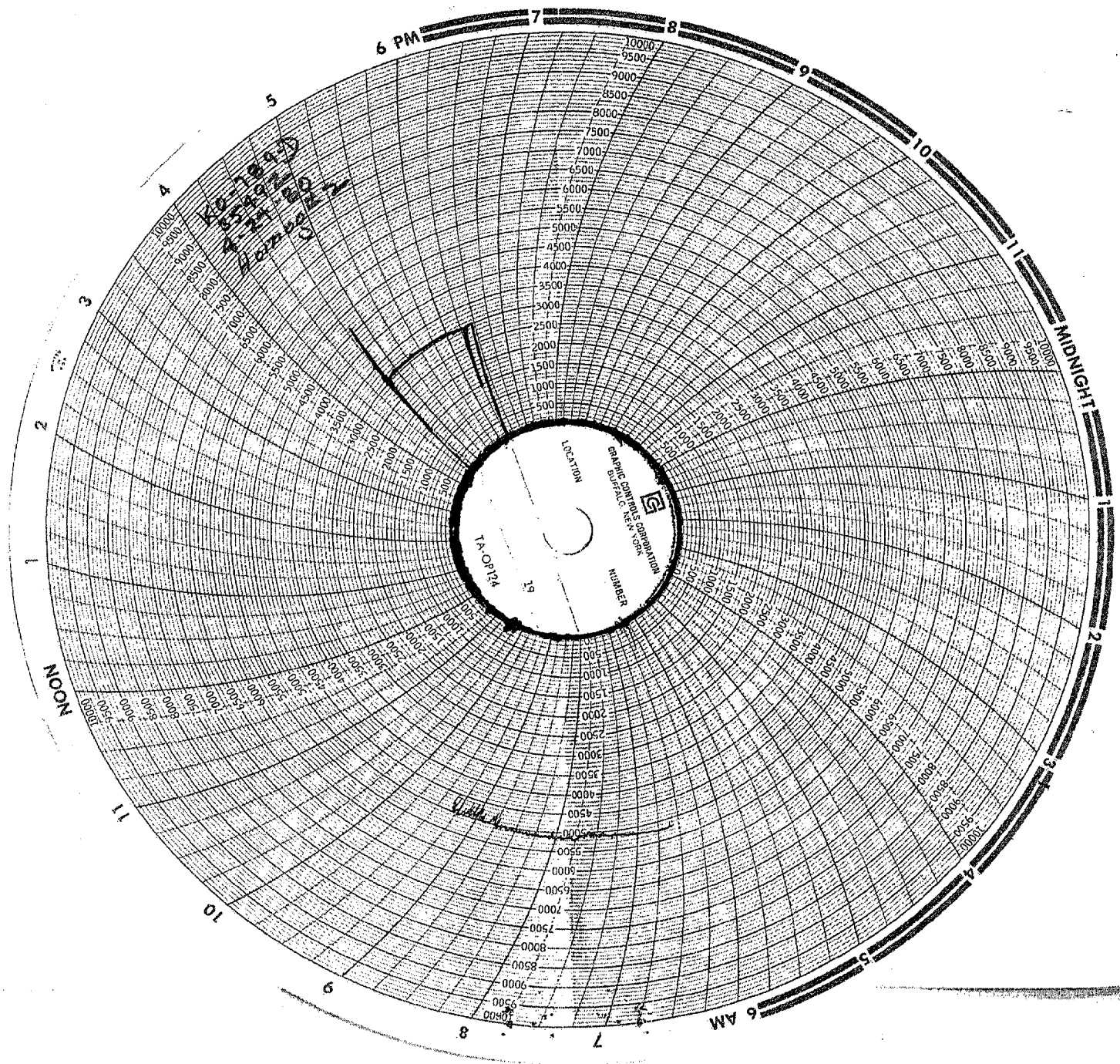
5239

Total Weight 5199 # (Req.

APR 29 1980

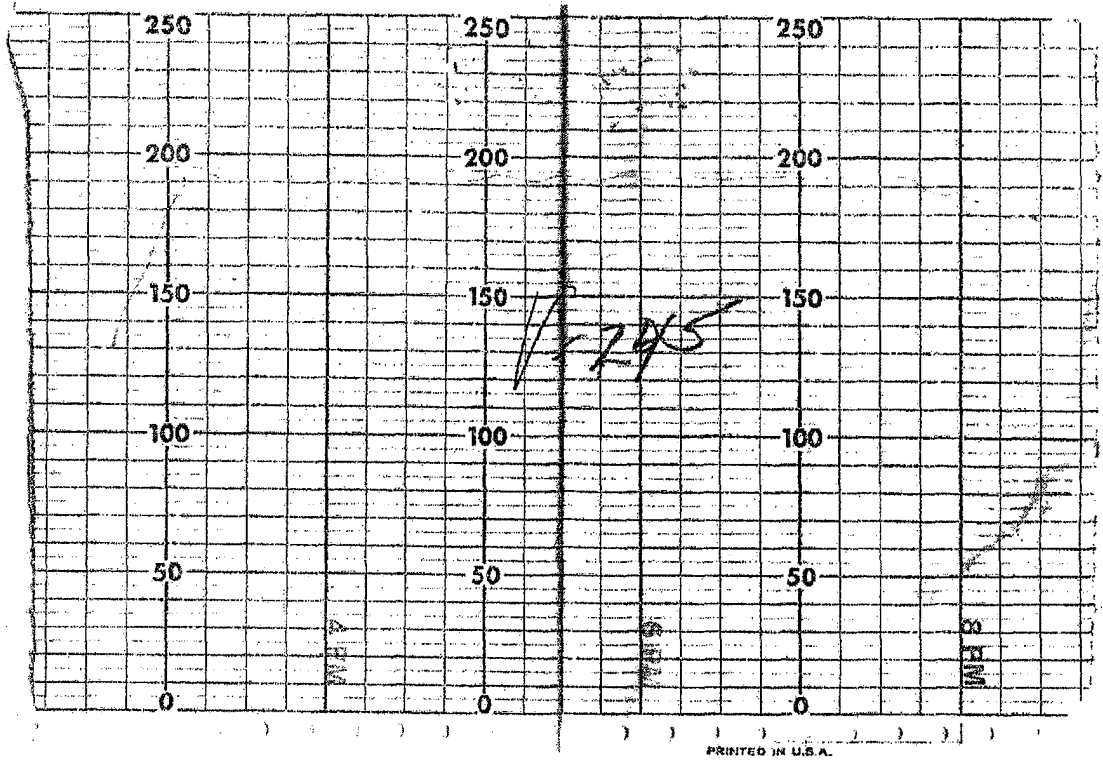
NON-BLEEDING

UPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
211	60" (9106) "KROLOR" ORANGE Y			
208	Run 24" (560 G) water into V-211. SET AGITATOR ON HIGH SPEED.			
1	Weight in drum and pour in	530	32-D	530
	Pump in and stir 5 minutes			
	Record: Start 9:15 AM	72335		
	Fin 12:30 PM	33978		
	78" (12756)	34833		
	Add to 70" (1200 G)	2800-3200 34835		
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208	1600		
	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	Record: V-208 Vol 46 " and adjust to 60" (2100 G)			
	Inspect homog strainer and clean if necessary			
	STARTING HOMOG, RUN V-211 AGITATOR ON LOW SPEED			
208	Run 10" (514 G) water into V-208 and start agitator and			
SV	install temperature chart			
2	Pump V-208 thru Homog at 4800-5200 psi into SV. 24.5			
	Record: Time Start 11:29 Total Minutes 160			
	Note: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349	While Homog, run 6" (284 G) water into V-349			
384	Run 1000# water into V-384 and heat to 110-120°F			
3	Weight into V-384 and pump to V-349	3085	32-D	3085
	Run 1000# water into V-384 and pump to V-349			
	Add V-349 to 21" (1000 G) and stir 15 minutes or longer			
	Record: 98.1/1178 (14.3 ± 0.2) (V.106-1.108)			
SV	When S 10/4 Homog complete, adjust SV to 66" (3392 G)			
4	Record: pH 10.8 and adjust to 11.1-11.3 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 11.1	10	7-D	5
	Heat to 190-194°F in 55-65 minutes and Record: HT 192 F and Rec 194 F			
	Note: Strike must be started immediately on completion of heating			
	While heating SV, run 54" (1485 G) water into V-343			
	Water in from V-386 M30 75024/Gal 48.4		27-D	460
	Stir 15 minutes or longer			
	Record: 1023 (14.3 ± 0.3) (1.021-1.023)			



N32314.01

DUP050457537



N32314.02

DUP050457538