

MAKING INSTRUCTIONS: BATCH UNIT

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

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Total Weight 4962# (Req. _____)

NON-BLEEDING

W/MENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	Run 60" (990 G) water in V-211 and add	Assume 50%	7-D	1015
&	Weigh in drum and pour in V-211	270	32-D	270
208	Dump in and stir 5 minutes	82 x 50	YC-10-B	4100
1	Record: Start 5:30 PM	LOT 32904		
	Fin 7:15 PM			
	75" (1275 G)			
	Adjust to 80" (1370 G)			
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	Record: V-208 Vol 43 " and adjust to 50" (1840 G)			
	Inspect homog strainer and clean if necessary			
208	Run 15" (771 G) water into V-246 and start agitator and			
&	install temperature chart			
SV	Pump V-208 thru Homog at 4800-5200 psi into SV			
2	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			
	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			
&	Run 1000# water into V-384 and heat to 110-120°F			
384	Weigh into V-384 and pump to V-349	2400	32-D	2400
3	Run 1000# water into V-384 and pump to V-349			
	Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	Record: pH 10.6 (10.9 ± 0.2) 1.078 - 1.081			
	9/20/1			
SV	When S-11 Homog complete, adjust to 66" (3400 G) in SV			
4	Record: pH 10.6 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%		7-D	
	Siphon N-7-D into SV and Record: pH			
	Heat to 190-194°F in 55-65 minutes & Record: HT 72 F and			
	Rec 192 F			
	Note: Strike must be started immediately on completion of heating			
343	While heating SV, run 51" (1400 G) water into V-343			
&	Water in from V-386 M 8.5 #/Gal 7.08 Gal 35.9		27-D	355
386	Stir 15 minutes or longer			
5	Record: pH 10.1 (10.2 ± 0.1) 1.017 - 1.019			
	9/20/1			

OK

AP

(JN)

Homog #2

(JN)

245

IPMENT	PAGE	CG 04	CODE	K0-786-D (R)	EST. WGT.	4962	LBS.	USE	N	AMTY.
								LBS.	CODE	LBS.
SV	6	23	When S-20 heating complete, Record: pH <u>10.1</u> (9.6-10.2)							
		24	Set V-343 acid pump at 72 setting (± 25 minutes)							
		25	Set V-349 silicate pump at 66 setting (± 180 minutes)							
		26	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike							
		27	Record: Start Finish Minutes							
			V-343 <u>6:00 P</u> <u>8:50 P</u> <u>230</u>							
			V-349 <u>6:00 P</u> <u>9:00 P</u> <u>180</u>							
			Record: Time V-343 V-349 SV Normal							
			at 20 min <u>6:20 P</u> (47) <u>47</u> (20) <u>20</u> <u>9.8</u> <u>9.3-10.0</u>							
			40 min <u>6:40 P</u> (43) <u>43</u> (17) <u>17</u> <u>9.8</u> <u>9.3-10.0</u>							
			1 hr <u>7:00 P</u> (38) <u>38</u> (15) <u>15</u> <u>9.8</u> <u>9.3-10.0</u>							
			2 hrs <u>8:00 P</u> (24) <u>24</u> (7) <u>7</u> <u>9.8</u> <u>9.3-10.0</u>							
			3 hrs <u>9:00 P</u> (10) <u>12</u> (0) <u>12</u> <u>9.8</u> <u>9.3-10.0</u>							
			Finish <u>9:45 P</u> (0) <u>0</u> <u>0</u> <u>7.4</u> <u>7.5-8.5</u>							
			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)						15-A	
		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%						27-D	
			(Dilute 10 parts water to 1 part N-7-D) Assume 50%						7-D	
			Siphon N-7-D into SV.							
		42	Stop agitator							
			START FINISH OPTR							
			<u>7:00 P</u> <u>3:00 PM</u> <u>235-342</u>							
			<u>3:00 P</u> <u>7:30 P</u> <u>27-126</u>							

0670

BLDG. 6 FLOOR 3RD BY 12/20/79 11P M.

DATE _____

12/05/79

WRITTEN BY

Production Control

[illegible]

FOLLOWING

FLOOR

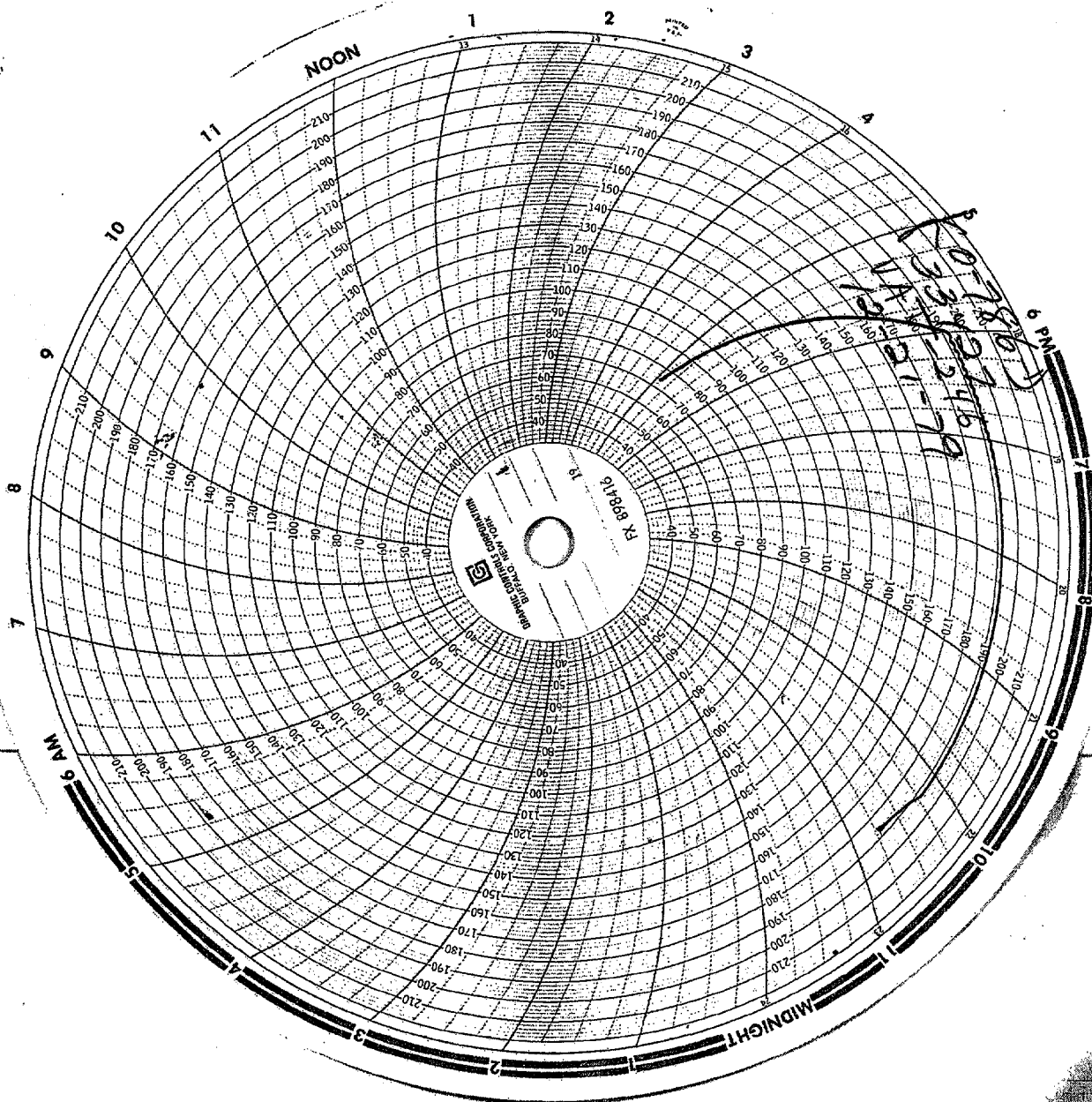
No. of Packages	Net Weight	Whse. Loc.

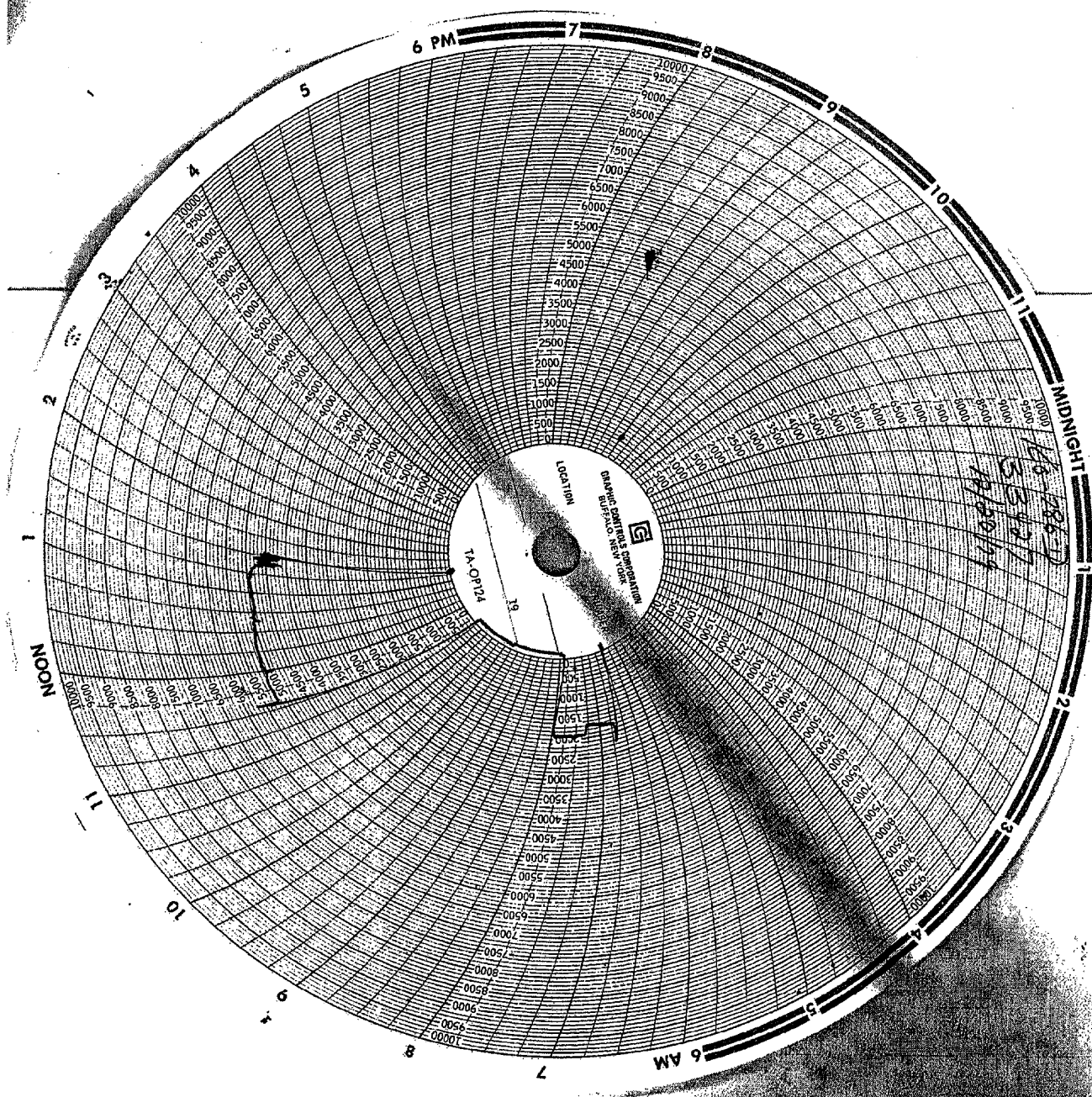
DATE _____ SUPVR. _____

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

*Each Supervisor must explain weight differences on reverse side.

DUP050095429





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