

243, 244, 246, 247, (262)

CG 03 CODE KY-787-D

Nov 18 32463
EST. WGT. 2230 LBS

STD. HRS

14 YC-2-B 93 4 Lot 23963, 5000
14 YC-2-B 93 4 Lot _____, _____
14 YC-2-B 93 4 Lot _____, _____

D.V.

PROCESSES	APPROVED BY
() KY-787-D (S)	EWK 10-19-77
() Alternate ()	DCG 10-25-77
() ()	MTW 10-26-77
() ()	FWP 02-01-79
TYPED BY emw020179	

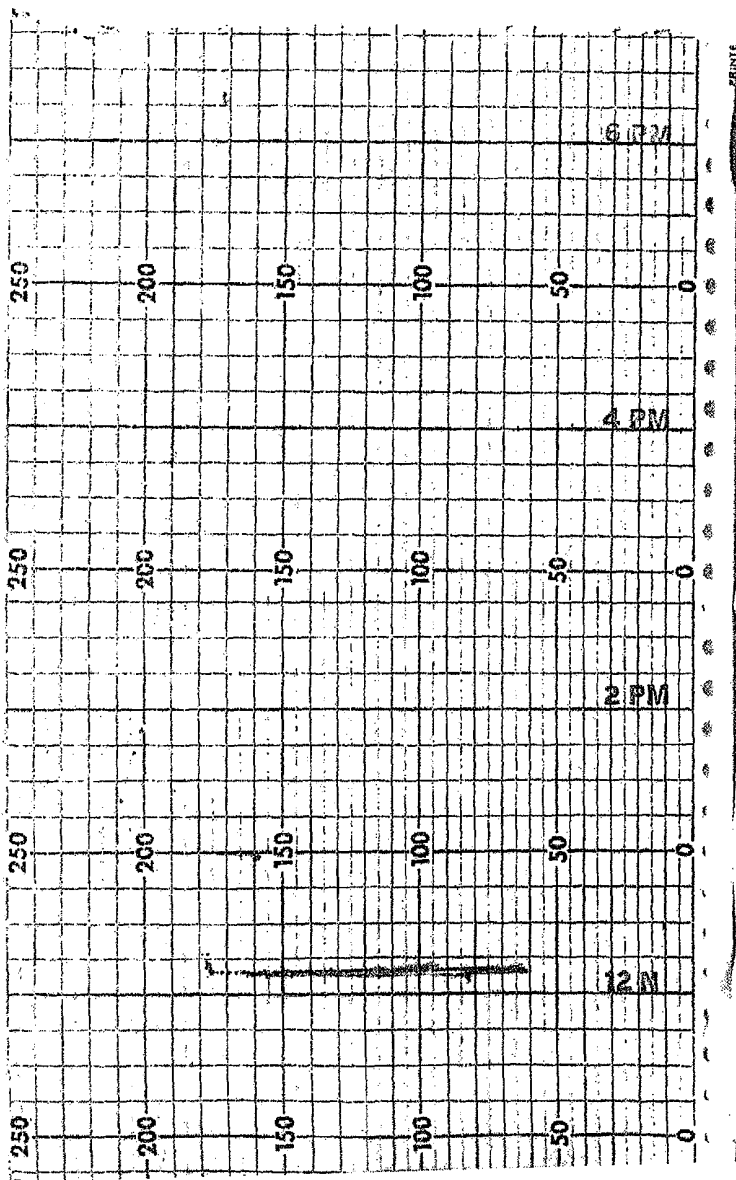
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NON-BLEEDING

LEMENT	NAME	USE LBS.	N CODE	ACC LBS.
203	1 Run 50" (827 G) water into V-203			
&	2 Weigh in drum & pour in	670	32-D	670
203	3 Pump in & stir 5 min	Lot 100 x 50	YC-2-B	5000
1	Record: Start <u>3:14</u> Fin <u>6:14</u>	<u>23963</u>	<u>100 x 50</u>	<u>5000</u>
	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			
	Record: V-205 Vol <u>56</u> " & adj to 54" (1900 G)			
<u>263</u>	8 Inspect Homog strainer & clean if necessary			
SV	9 Run <u>2</u> " (200 G) water into V- <u>262</u> & install temp chart			
&	& start agitator			
203	10 Pump V-205 thru Homog at 4800-5200 psi into SV- <u>262</u>			
<u>263</u>	Record: Time Start <u>2 PM</u> , Total Min <u>1:20</u>			
	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	3830	32-D	3830
3	15 Run 1000 # water into V-384 & pump to V-349			
	16 Adj V-349 to 25" (1163 G) & stir 15 min or longer			
	17 Record: <u>Obs 11:14</u> (15.2 ± 0.2) (1.113 - 1.117)			
SV	18 When 5 11 Homog complete, adj SV to <u>26</u> " (2100 G)			
4	19 Record: pH <u>10.7</u> & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	<u>30</u>	7-D	<u>15</u>
	Siphon into SV & Record: pH <u>11.3</u>			
	20 Heat to 190-194°F in 35-45 min (V-262) or in 55-65 min (V-243, 244, 246, 247) & Record: HT <u>190°F</u> & Rec <u>15:00</u>			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 56" (1520 G) water into V-343			
&	22 Meter in from V-386	M <u>116.75</u> #/Gal <u>59.8</u> Gal	27-D	573
386	23 Stir 15 min or longer			
5	24 Record: <u>Obs 10:28</u> (4.1 ± 0.1) (1.037 - 1.038)			

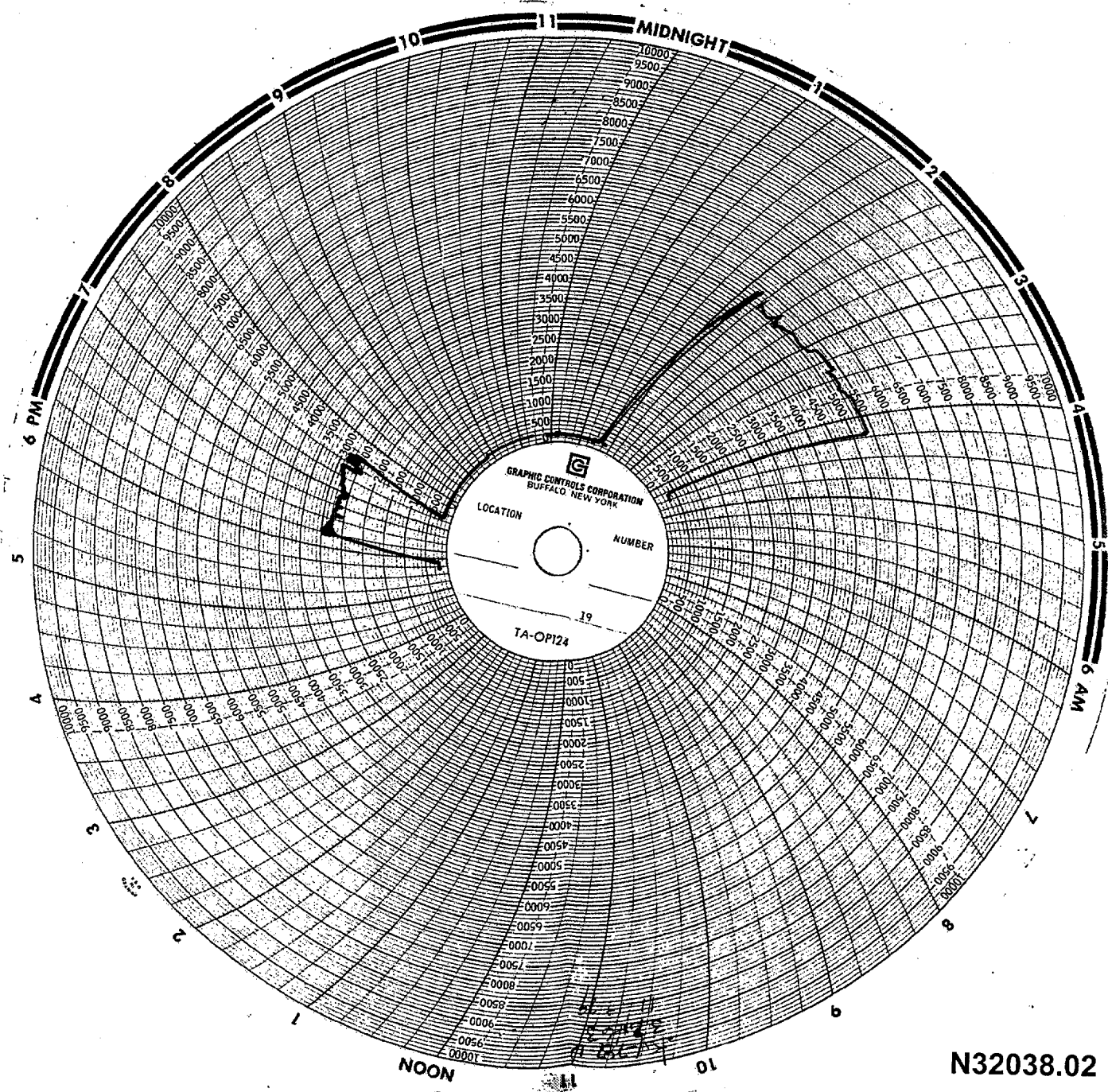
V.M.

EQUIPMENT	PAGE 2	CG 03	CODE KY-787-D (S)	EST. WGT.	7230 LBS.	USE LBS.	N CODE	AC
SV	25	When S 20 heating complete, Record: pH <u>10.0</u> (9.6-10.2)						
6	26	Set V-343 acid pump at 69 setting (1255 min)						
27	27	Set V-349 alkali pump at 60 setting (1210 min)						
28	28	Immediately after in V-343 & 349, maintain SV at 190-1940F during strike						
29	29	Record:	Start	Fin	Min			
		V-343	<u>5:15 P</u>					
		V-349						
		Record:	Time	V-343 in	V-349 in	SV pH	Normal pH	
		at 20 min	<u>5:35 P</u>	(52)	(22)	<u>9.5</u>	9.3-10.0	
		40 min	<u>5:45 P</u>	(48)	(20)	<u>9.4</u>	9.3-10.0	
		1 hr	<u>6:15 P</u>	(43)	(18)	<u>9.4</u>	9.3-10.0	
		2 1/2 hrs	<u>7:30 P</u>	(27)	(7)	<u>9.8</u>	9.3-10.0	
		3 1/2 hrs	<u>8:45 P</u>	(10)	(0)	<u>9.8</u>	9.3-10.0	
		Finish	<u>9:30 P</u>	(0)		<u>9.8</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
330	30	Run 22" (431 G) water into V-330 & heat to 160-170°F						
7	31	Add in 12-13 min				700	530-A	700
	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						
357	34	Run 29" (210 G) water into V-357 & heat to 135-140°F						
8	35	Dump in & stir to dissolve for S 42				350	15-A	350
302	36	Run 36" (440 G) water into V-302						
9	37	Add & stir 2 min for S 44				Assume 50%	380	7-D 190
SV	38	When V-349 MTY, rinse in with minimum water then set pump to zero setting						
10	39	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	40	Turn off steam						
	41	Sift in				250	128-A	250
	42	Run in V-357 from S 35 & stir 5 min						
	43	Record: pH <u>9.3</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						
313	47	Run 15" (222 G) water into V-313 & dump in				270	20-A	270
11	48	Stir 5 min to dissolve for S 49						
SV	49	Run V-313 into SV in 15-20 min						
12	50	Stir 15 min						
	51	Record: pH <u>9.4</u> (9.0-10.0)						
	52	Stop agitator <i>Do not stop in V-262</i>						
		Step	V-262 (20 RPM)	V-243, 244, 246, 247				
		9	2"	4"				
		18	26"	50"				
		START	FIN	OPTR				
		<u>3:00 P</u>	<u>10:35 P</u>	<u>27-126</u>				



N32038.01

DUP050456345



N32038.02

DUP050456346