

S.V. 246 (247)

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 04 CODE KO-906-D PKG.

PUNCHED & CHECKED

PROCESSES		APPROVED BY	
()	KO-906-D	()	EWK 1/24/78
()		()	DCG 1/26/78
()		()	MW 1/26/78
()		()	
TYPED BY			
ri 3/2/78			

EST. WGT. 1377

LBS.

35718

MAY 12 1980

STD. HRS

TIME

11: P.m.

01 YC-10-B 93 4 35462 3700#
 01 YC-10-B 93 4
 01 YC-10-B 93 4

TOTAL WEIGHT 5077# (Req.)

MAY 9 1980

NON-BLEEDING

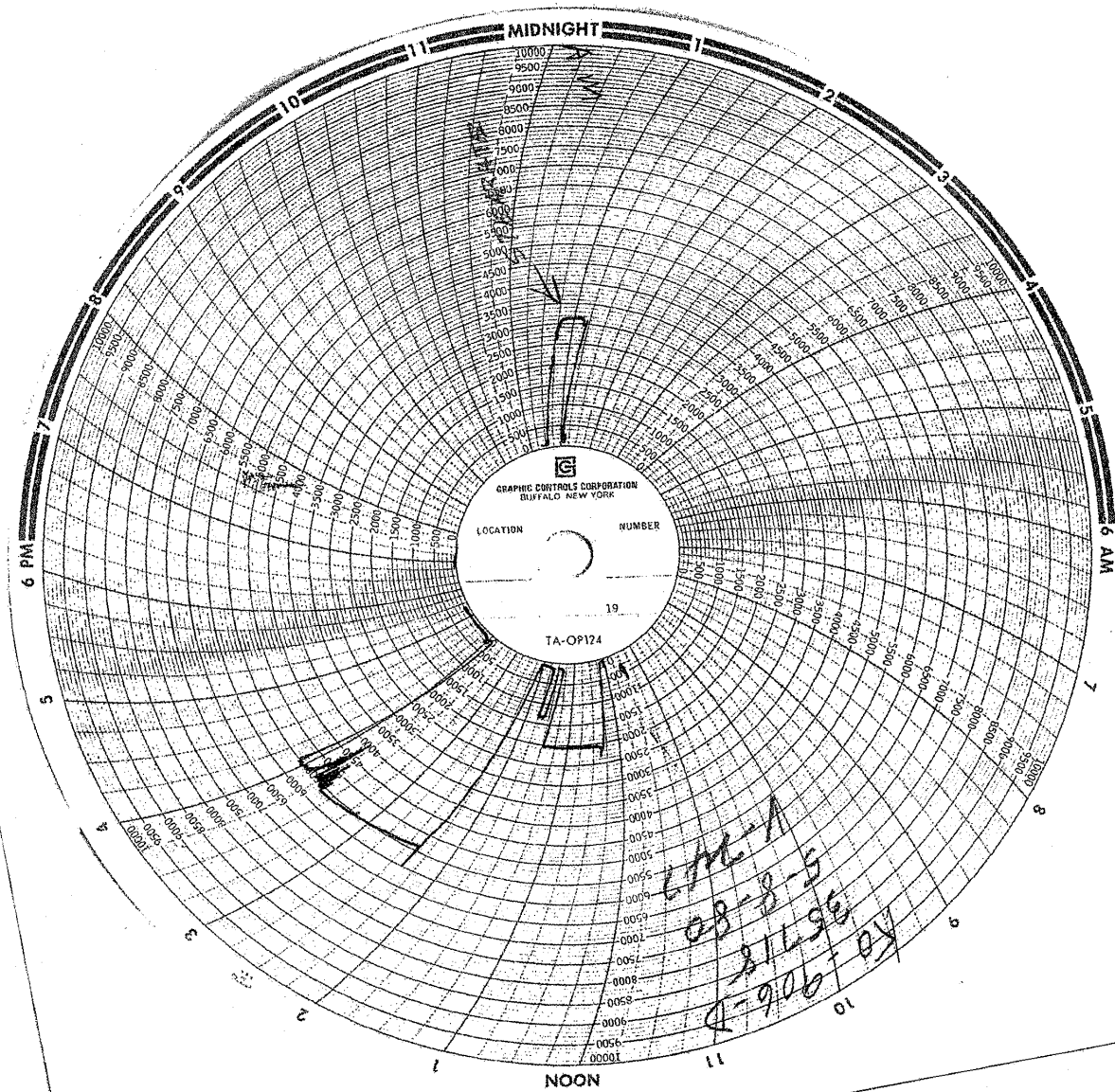
EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
211 & 208	Run 31" (505 G) water in V-211 and add. Assume 50%	26	7-D	13
	Weigh in drum and pour in	245	32-D	245
	Dump in and stir 5 min	Lot 74 x 50	YC-10-B	3700
	Record: Start 10:00 P.m. 35462	3700		
	Finish 12:20 A.M.			
	80" (1360 G)			
	Adjust to 64" (1082 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 40 " & adjust to 45" (1662 G)			
	Inspect Homog strainer and clean if necessary			
208 & SV	Run 15" (793 G) water into V-247 & start agitator			
	Pump V-208 thru Homog at 4800-5200 psi into SV			
	Record: Time Start 2:30 Total Min 1/3			
	Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384	While Homog, run 5" (237 G) water into V-349			
	Run 1000# water into V-384 and heat to 110-120°F			
	Weigh into V-384 and pump to V-349	2165	32-D	2165
	Run 1000# water into V-384 and pump to V-349			
	Adjust V-349 to 20" (946 G) and stir 15 min or longer			
	Record: 98° 1.080 (10.9 ± 0.2) (1.078-1.081)			
SV	When S12 Homog complete, adj to 59" (3033 G) in SV			
	Record: pH 10.9 & adj 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, stir 5 min & record: pH			
	Heat to 190-194°F in 55-65 min & Record: HT 188 Rec 194 OF			
	Note: Strike must be started immediately on completion of heating			
343 & 386	While heating SV, run 46" (1265 G) water into V-343			
	Meter in from V-386 M 23 10.50 #/Gal. 30.5 Gal		27-D	320
	Stir 15 min or longer			
	Record: 98° 1.018 (2.9 ± 0.1) (1.018-1.019)			

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EQUIPMENT		PAGE 2	CG 04	CODE K0-906-D (C)	EST. WGT.	5077	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	6	26	When S20 heating complete, Record: pH 9.9 (9.6-10.2)							
		27	Set V-343 acid pump at 65 setting (+225 min)							
		28	Set V-349 Silicate pump at 57 setting (+180 min)							
		29	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike							
		30	Record: Start Finish Minutes							
			V-343	8:35 AM	12:30 P	240				
			V-349	8:45 AM	11:45 A	190				
			Record:	Time	V-343	V-349	SV pH	Normal pH		
				8:35 AM	4.4	2.0	9.7	9.3-10.0		
			at 20 min	8:55	(43) 4.4	(18)	9.7	9.3-10.0		
			40 min	9:15	(39) 4.0	(16)	9.7	9.3-10.0		
			1 hr	9:35	(35) 3.4	(13) 1.4	9.7	9.3-10.0		
			2 hrs	10:35	(22) 2.4	(7) 0.5	9.75	9.3-10.0		
			3 hrs	11:35	(10) 1.3	(0) 1	9.8	9.3-10.0		
			Finish	12:30	(0)		7.2	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 to 7.5-8.5 and							
			Record:	pH	Assume 78%					
		31	Sift in 1 bag					50	27-D 128-A 65	50
357	7	32	Run 19" (137 G) water into V-357 & heat to 135-140°F							
		33	Bump in & stir to dissolve for S61					270	15-A	270
302	8	34	Run 24" (294 G) water into V-302							
		35	Add & stir 2 min for S64					Assume 50%	136	7-D 68
PT	9	36	During strike pump into PT					464	169-A	464
		37	Pump in					52	155-A	52
		38	Pump in					52	160-A	52
		39	Stir 10 min with lightning mixer for S43							
356	10	40	During strike, run 22" (268 G) water into V-356							
		41	Turn on steam							
		42	Adj to 30% (366 G) at 178-182°F 81-82°C							
		43	Pump PT, mixture from S39 thru undersurface Distributor AFAP							
		44	Rinse PT with hot water from hot water mixer & pump in							
		45	Shutoff pump 81-82°C							
		46	Stir 30 min at 178-182°F for S55							
		47	Do not shutoff agitator							
SV	11	48	When V-349 MTY, rinse in with minimum water then set pump to zero setting							
		49	When V-343 MTY, rinse in with minimum water then turn off pump motor							
		50	Heat to 198-200°F in 5-10 min							
		51	Close water line & discharge valves at stearate pump							
		52	Open V-356 Discharge valves to stearate pump inlet							
		53	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer							
		54	While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & close valve to sewer							
		55	Immediately open stearate pump Discharge valve, Turn on pump & Homog V 356 to SV at 2900-3100 psi Maintain SV at 198-200°F							
		56	While Homog V-356 to SV, shutoff water valve at Stearate pump ASAP							

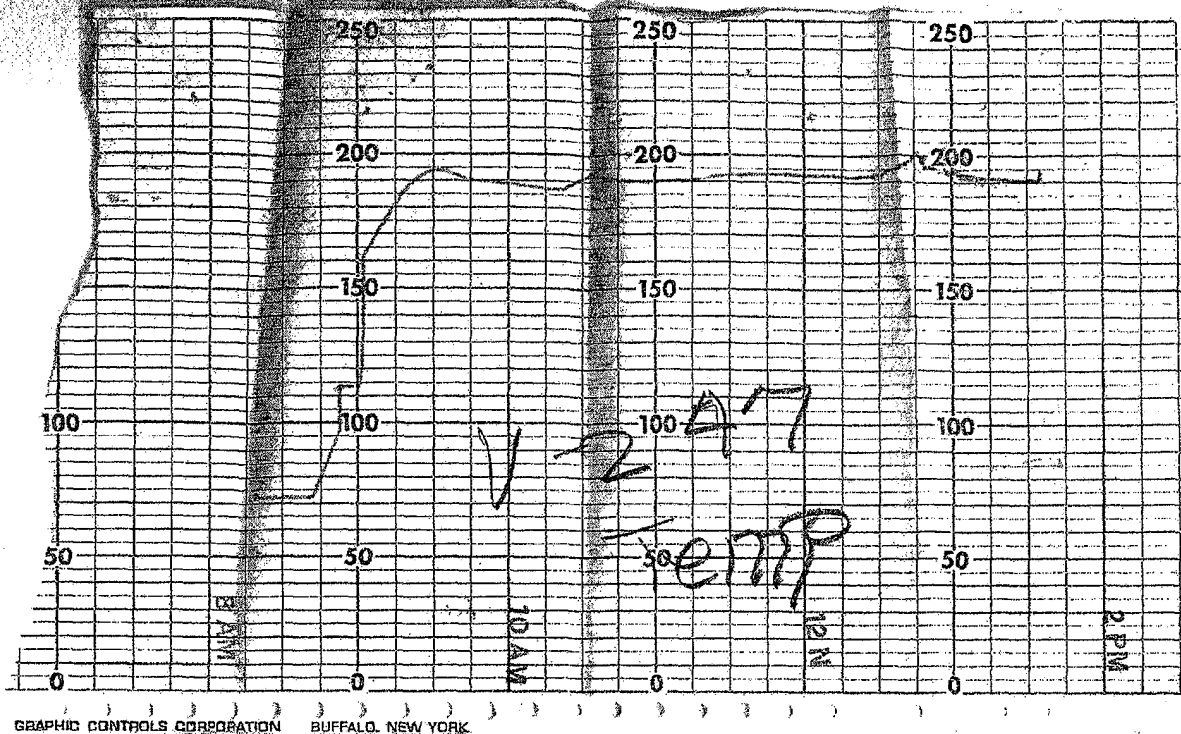
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SV	57	When Homog complete, rinse in V-356 with hot water									
	58	From hot water mixer									
Con'T'	59	When S57 complete, turn off Homog & stearate pump									
	60	Stir 5 min at 198-200°F									
	61	Shut off steam									
	62	Run in V-357 from S33 and stir 5 min									
	63	Record: pH <u>3.6</u> (3.3-3.7)									
	64	If necessary, adj pH to 3.3-3.7 (Downward only) and									
	65	Record: pH <u>4.4</u> (4.0-4.2) and if necessary, adj to									
	66	pH 4.0-4.2 and Record: pH <u>4.2</u> Assume 78%									
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%									
		Siphon N-7-D into SV									
		Do not stop agitator									
		START		FIN		OPTR					
		11 PM		7 AM		170					
		7:00A		2:15 PM		235					



DUP050457910
N32412.01

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DUP050457912

N32412.02