

MAR 24 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 245 (247)

C.V.

D.V.

04 CODE KO-786-D

PKG.

PUNCHED & CHECKED

MAR 26 35064

EST. WGT. 862 LBS.

APR 1 1980

STD. HRS. 10.5 TIME

01 YC-10-B 93 4 33481 900#
 01 YC-10-B 93 4 34404 2550#
 01 YC-10-B 93 4 34718 650#

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			

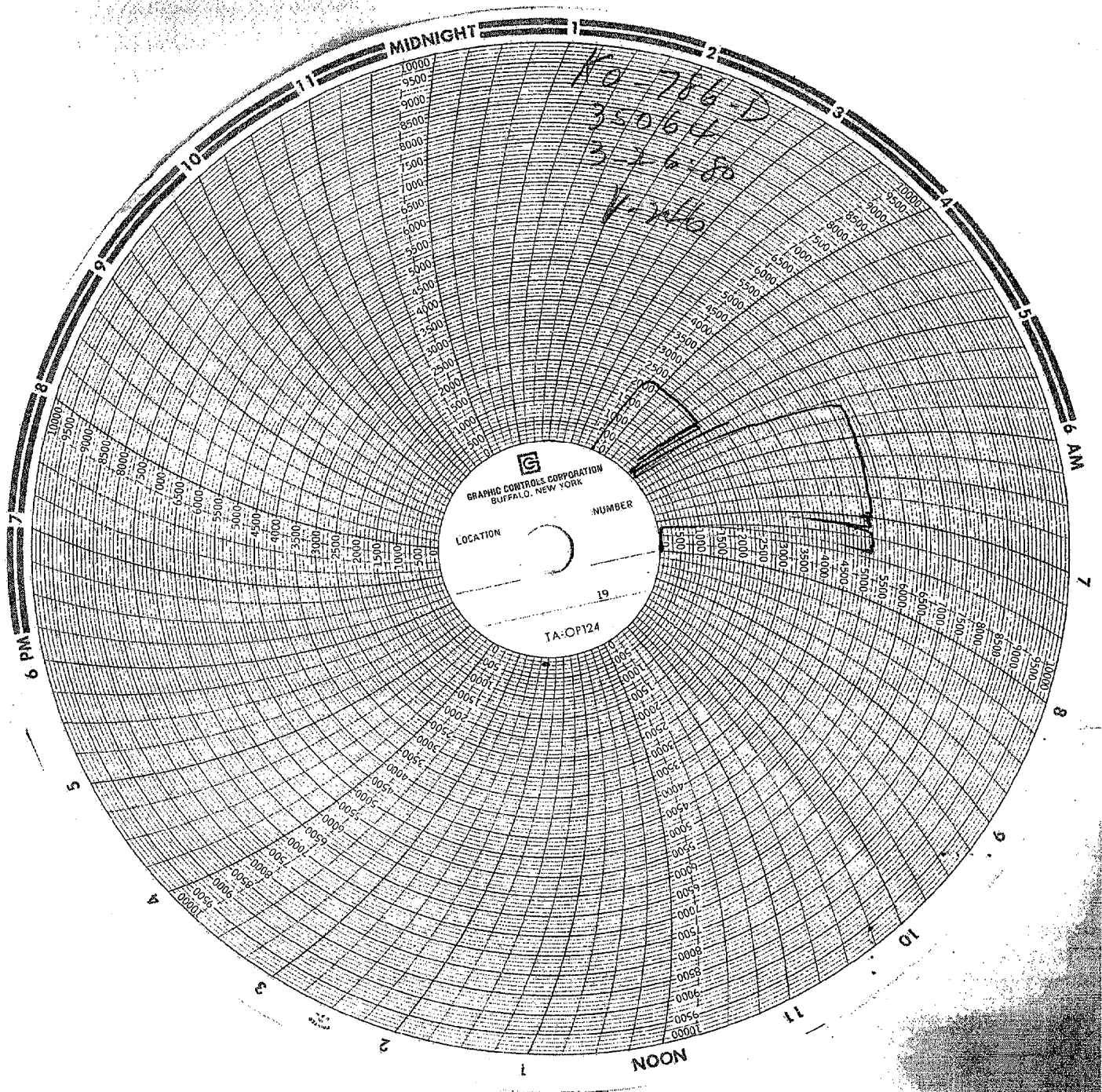
Total Weight 4962# (Req.)

NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
211 & 208	"KROLOR" ORANGE R SET AGITATOR ON HIGH SPEED			
1	Run 60" (990 G) water in V-211 and add Assume 50%	30	7-D	15
	Weigh in drum and pour in V-211	270	32-D	270
	Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
	Record: Start 8:30 33481			
	Fin 10:41 34404			
	75" (12756) 34718			
	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 40 " and adjust to 50" (1840 G)			
	Inspect homog strainer and clean if necessary			
208 & SV	DURING HOMOG RUN V-211 AGITATOR ON LOW SPEED			
2	Run 15" (771 G) water into V-208 and start agitator and install temperature chart			
	Pump V-208 thru Homog at 4800-5200 psi into SV			
	Record: Time Start 1:20 Total Minutes 110			
	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 & 384	While Homog, run 6" (284 G) water into V-349			
3	Run 1000# water into V-384 and heat to 110-120°F			
	Weigh into V-384 and pump to V-349	2400	32-D	2400
	Run 1000# water into V-384 and pump to V-349			
	Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	Record: 284 1.079 (1.078-1.081)			
SV	8/mL			
4	When S 11 Homog complete, adjust to 66" (3400 G) in SV			
	Record: pH 10.5 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 192°F and Rec 14.7 F			
	Note: Strike must be started immediately on completion of heating			
343 & 386	While heating SV, run 51" (1400 G) water into V-343			
5	Meter in from V-386 M 7.5 #/Gal 9.16 Gal 38.8		27-D	355
	Stir 15 minutes or longer			
	Record: 284 1.017 (1.016-1.018) 1.017-1.019			
	8/mL			

V-246

EQUIPMENT	PAGE	CG 04	CODE	KO-786-D (B)	EST. WGT.	4962	LBS.	USE	N	CODE	LBS.
SV 6	25	When S 20 heating complete. Record: pH 9.6 (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	0 05	10.10 AM	245						
		V-349	0 AM	9:15 AM	190						
		Record:	Time	V-343	V-349	SV	Normal				
				Inches	Inches	pH	pH				
		at 20 min	6 35	(47) +	(20) ✓	9.6	9.3-10.0				
		40 min	6 45	(43)	(17)	9.7	9.3-10.0				
		1 hr	7 05	(38) 43	(15) 105	9.8	9.3-10.0				
		2 hrs	8 05	(24) 29	(7) 85	9.8	9.3-10.0				
		3 hrs	9 05	(10) 15	(0) 2	9.8	9.3-10.0				
		Finish	9 50	(0) —	—	6.1	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 3.1 (3.3-3.7)									
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH 10 15-A									
	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							
		11 PM	7 AM	120							
		7:00 AM	11:30 AM	145							



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