

PUNCHED & CHECKED

APR 17 1969

MAKING INSTRUCTIONS BATCH UNIT

REF CODE	K0-786-D	PKG.	
APR 17	35370		
EST WGT	852	LBS	
STD. HRS	10.5	TIME	
01	Y-298D	93	4
01	Y-298D	93	4
01	Y-298D	93	4

PROCESSES	APPROVED BY
K0-786-D	ENC 9-21-78
	ENC 9-21-78
	MTN 10-1-78
TYPED BY	
ENC 11-10-78	

Total Weight 4962# (Req)

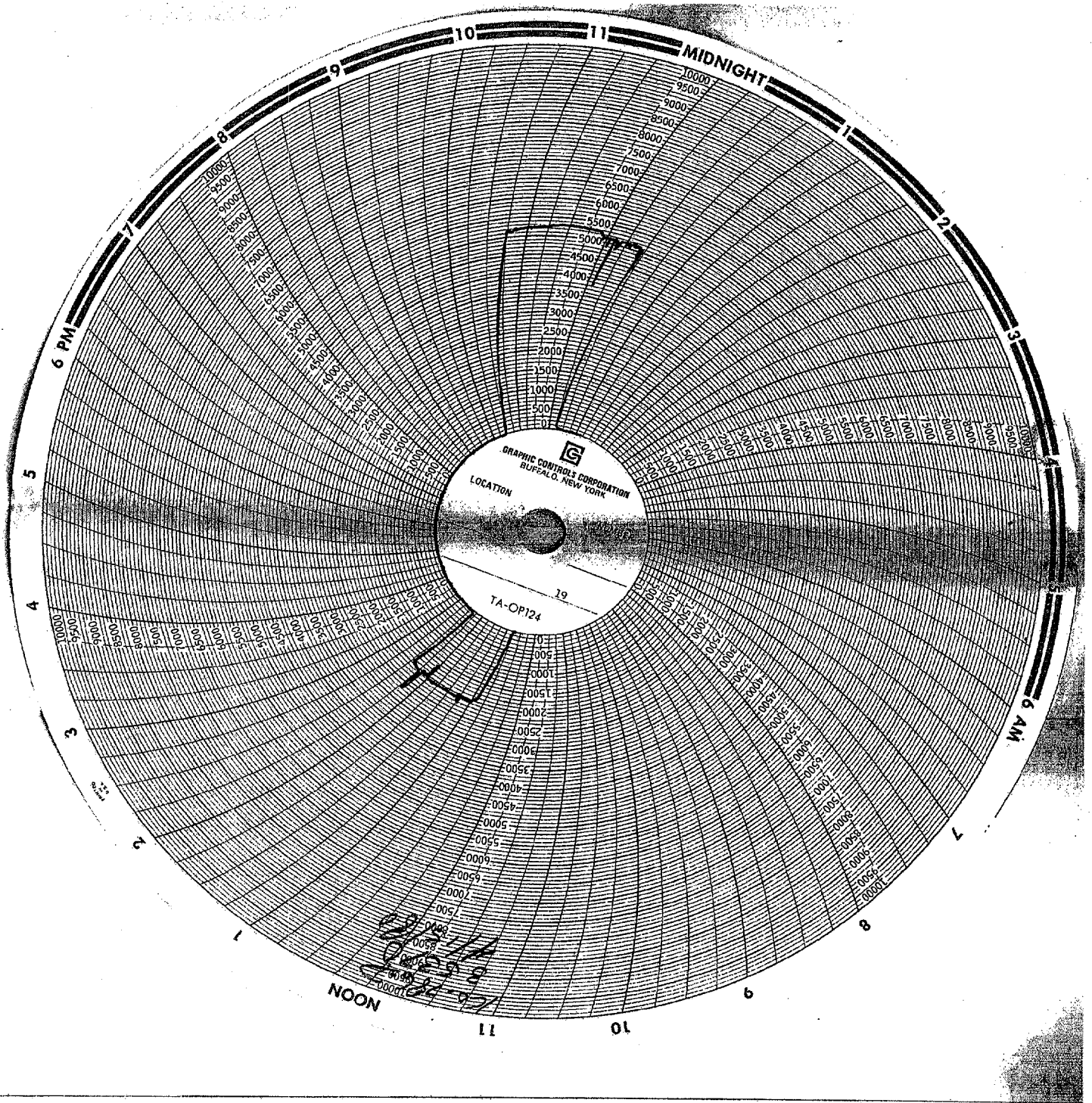
NON-BLEEDING

EQUIPMENT	NAME	USE LBS	N CODE	ACCT LBS
211	"KROLOR" ORANGE R			
208	Run 15" (990 G) water in V-211 and add	30	7-D	30
1	2. Weigh in drum and pour in V-211	216	32-D	216
	3. Pump in and stir 5 minutes	82 x 50	Y-298-D	4100
	Record: Start	33219		
	Fin	3496		
	Adjust to 30" (1370 G)	33219		
	4. Pump V-211 thru Homod #2 at 1800-2200 psi into V-208			
	5. When V-211 MTY, wash color thru Homod at 1800-2200 psi using			
	6. 50% full water			
	7. Record V-208 Vol 41 and adjust to 50" (1840 G)			
	8. Inspect Homod strainer and clean if necessary			
208	9. Run 15" (771 G) water into V-208 and start agitation and			
SV	10. Pump V-208 thru Homod at 4800-5200 psi into SV			
2	Record: Time Start 10:20 Total Minutes 110			
	Note: If homod pressure falls below 4800 psi, 3/4 way valve			
	will recirculate slurry to V-208			
	11. When V-208 MTY, run in 5" (240 G) water and pump thru Homod			
	at 4800-5200 psi			
349	12. While Homod, run 6" (284 G) water into V-349			
8	13. Run 2100# water into V-384 and heat to 110-120°F			
384	14. Weigh into V-384 and pump to V-349	2400	32-D	2400
3	15. Run 2100# water into V-384 and pump to V-349			
	16. Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	17. Record: 1.081 (2.8 to 3.1) (1.078-1.081)			
SV	18. When S-11 Homod complete, adjust to 66" (3400 G) in SV			
4	19. Record: pH 11.2 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%			
	Siphon N-7-D into SV and Record: pH 11.2			
	20. Heat to 190-194°F in 65-68 minutes & Record: pH 10.8 F and			
	Rec: 1.08 F			
	Note: Strike must be started immediately on completion			
	of heating			
343	21. While heating SV, run 51" (1400 G) water into V-343			
8	22. Meter in from V-386 M 79 #/Gal 9.15 Gal 38.9			
386	23. Stir 15 minutes or longer			
5	24. Record: 1.018 (2.8 to 3.1) (1.017-1.019)			

27-D 1355

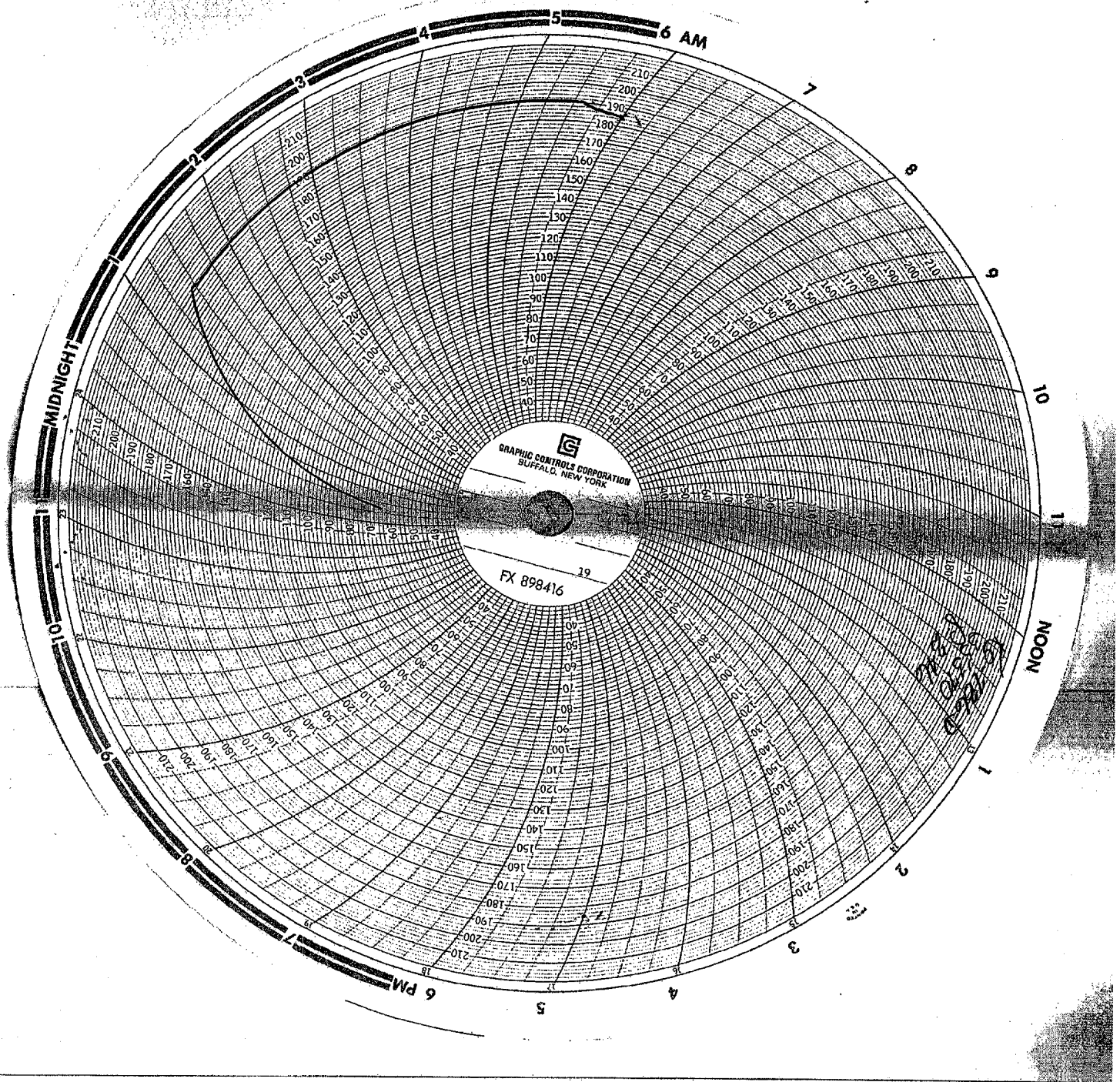
WLB

EQUIPMENT	PAGE	CC 04	CODE	K0-786-D (H)	EST WGT	4962	CBS	USE	N	CODE	ACT
SV 6	25	When S-20 heating complete, Record pH <i>10.15</i> (9.6-10.2)									
	26	Set V-343 acid pump at 72 setting (1225 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 <i>1:05 AM</i> <i>5:10 AM</i> <i>2:35</i>									
		V-349 <i>1:14 AM</i> <i>4:55 AM</i> <i>1:90</i>									
		Record: Time V-343 V-349 SV Normal									
		at 20 min <i>2:09 AM</i> (47) (20) <i>9.9</i> (9.3-10.0)									
		40 min <i>2:26 AM</i> (43) (17) <i>9.9</i> (9.3-10.0)									
		1 hr <i>2:45 AM</i> (38) (15) <i>9.9</i> (9.3-10.0)									
		2 hrs <i>3:15 AM</i> (24) (7) <i>9.9</i> (9.3-10.0)									
		3 hrs <i>4:45 AM</i> (10) (0) <i>9.9</i> (9.3-10.0)									
		Finish <i>5:30 AM</i> (0) <i>7.5</i> (7.5-8.5)									
		Note: If pH drops below 9.3 in 1st hour, stop pumps and call 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 185-190°F									
	31	Dump in and stir to dissolve						300	15-A		300
302 8	32	Add 42" (614 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 <i>5.7</i> (3.3-3.7)									
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record pH								15-A	
	40	Run in N-7-D from S-33 in 4-6 minutes and stir 5 minutes									
	41	Record: pH <i>4.0</i> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH <i>4.0</i> 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									
		<i>12:30 P</i> <i>2:00 P</i> <i>235-144</i>									
		<i>11:00 P</i> <i>6:15 P</i> <i>150-401</i>									



N32497.01

DUP050461495



N32497.02

DUP050461496