S.V. 243, 244, 246, 247, 262 **PUNCHED & CHECKED** D.V.

CG 03 CODE KY-787-D PKG. MAR - 4 1980

→ MAR-3 34685

EST. WGT. ~~1090~~ 990 LBS.

STD. HRS. 10.6 TIME 7 P M

14 YC-2-B 93 4 Lot 24479, 2000#
14 YC-2-B 93 4 Lot 24066, 350#
14 YC-2-B 93 4 Lot 24080 50#

OK
HP

EG.

#3 1ST PASS
#4 2ND "

PROCESSES		APPROVED BY
( ) KY-787-D	(R)	
( ) Alternate	( )	
( )	( )	FWK 9/22/76
( )	( )	DCG 9/22/76
TYPED BY		MTW 9/30/76
NE 2/12/77		

Total Wgt. ~~3490~~ 3390# Req( )

NON-BLEEDING

EQUIPMENT		NAME: 60" (990G) "KROLOR" YELLOW-MEDIUM	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	1	Run ~~33" (560 G)~~ water into V-203. SET AGITATOR ON HIGH SPEED			
	2	Weigh in drum & pour in	320	32-D	320
	3	Dump in & stir 5 min Lot	48 x 50	YC-2-B	2400
		Record: Start 9.15 24479	40		
		Fin 10.30 24066	9		
		75" (1275G) 24080	1		
	4	Adj to ~~70" (1200 G)~~ 2400-2600	48		
	5	Pump V-203 thru Homog # 3 at ~~1800-2200~~ psi into V-205			
	6	When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimun water			
	7	Record: V-205 Vol 42" & adj to 60" (2100 G)			
	8	Inspect Homog strainer & clean if Necessary			
		DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED.			
SV & 205 2	9	Run 5" (514 G) water into V-262 Install temp chart & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into SV- 262			
		Record: Time Start 4:40 AM Total Min 180			
		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			
349 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ± 1000# water into V-384 & heat to 110-120F			
	14	Weigh into V-384 & Pump to V-349	1840	32-D	1840
	15	Run ± 1000# water into V-384 & pump to V-349			
	16	Adj V-349 to 17" (805 G) & stir 15 min or longer			
	17	Record: Be' 1.079 ~~(10.5 ± 0.2)~~ (1.079-1.082) g/mL			
SV 4	18	When S 11/Homog complete, Adj SV to 25" (2470 G)			
	19	Record: pH 10.7 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 Parts water to 1 part N-7-D) Assume 50%	16	7-D	8
		Siphon into SV & Record: pH 11.2			
	20	Heat to 190-194 F in 55-65 min & Record: HT ___ F & Rec ___ F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 39" (1070 G) water into V-343			
	22	Meter in from V-386 M 79, 9.19 #/Gal 29.9 Gal		27-D	275
	23	Stir 15 min or longer			
	24	Record: Be' 1.018 ~~(2.8±0.1)~~ (1.017-1.018) g/mL			

JW

N 2630

C13829 REV.

V-262

EQUIPMENT		PAGE 2 CG03 CODE KY-787-D (R) EST. WGT. 3490 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete Record: pH 9.9 (9.5-10.0)			
	26	Set V-343 acid pump at 82 setting (± 150 min)			
	27	Set V-349 silicate pump at 72 setting (±120 min)			
	28	Immediately meter in V-343 & 349, Maintain SV at 190-193F during strike			
	29	Record: Start / Finish / Minutes V-343 8:20 / 11:00 A / 160 V-349 8 AM / 10:20 A / 120			

Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	8:40	(35)	(14)	9.8	9.3-10.0
40 min	9:00	(30)	(11)	9.8	9.3-10.0
1 hr	9:20	(24)	(9)	9.8	9.3-10.0
2 hrs	10:20	(8)	(0)	9.8	9.3-10.0
Finish	10:50	0		7.5	7.5-8.5

Note: If pH drops below 9.0 in 1st hr, stop pumps & see Supv.
If final pH is above 8.5 adj to 7.5-8.5 & Record: pH
Assume 77 % — 27-D

330 7	30	Run 20" (392 G) water into V-330 & heat to 80-100 °F			
	31	Add in 7-8 min	350	530-A	350
	32	Stir 5 min & Record: pH 10.2 (9.5-10.5)			
	33	Stir 20 min or longer to dissolve for S 46			
357 8	34	Run 11" (80 G) water into V-357 & heat to 135-140 °F			
	35	Dump in & stir to dissolve for S-42	160	15-A	160
302 9	36	Run 30" (360 G) water into V-302			
	37	Add & stir 2 min for S44 Assume 50%	180	7-D	90
SV 10	38	When V-349 MTY, Rinse in with minimum water then set pump to zero setting			
	39	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	40	Turn off steam			
	41	Sift in 2 bags	100	128-A	100
	42	Run in V-357 from S 35 & stir 5 min			
	43	Record: pH 3.4 (3.7-4.2)			
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min			
	45	Record: pH 7.3 (9.0-9.5) & if necessary adj to pH 9.0-9.5 & Record: pH Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7 into SV			
	46	Run in V-330 thru 20 mesh screen & stir 20 min			
313 11	47	Run 10" (128 G) water into V-313 & dump in	135	20-A	135
	48	Stir 5 min to dissolve for S 49			
SV 12	49	Run V-313 into SV in 15-20 min			
	50	Stir 15 min			
	51	Record: pH 9.2 (9.0-10.0)			
	52	Stop agitator			

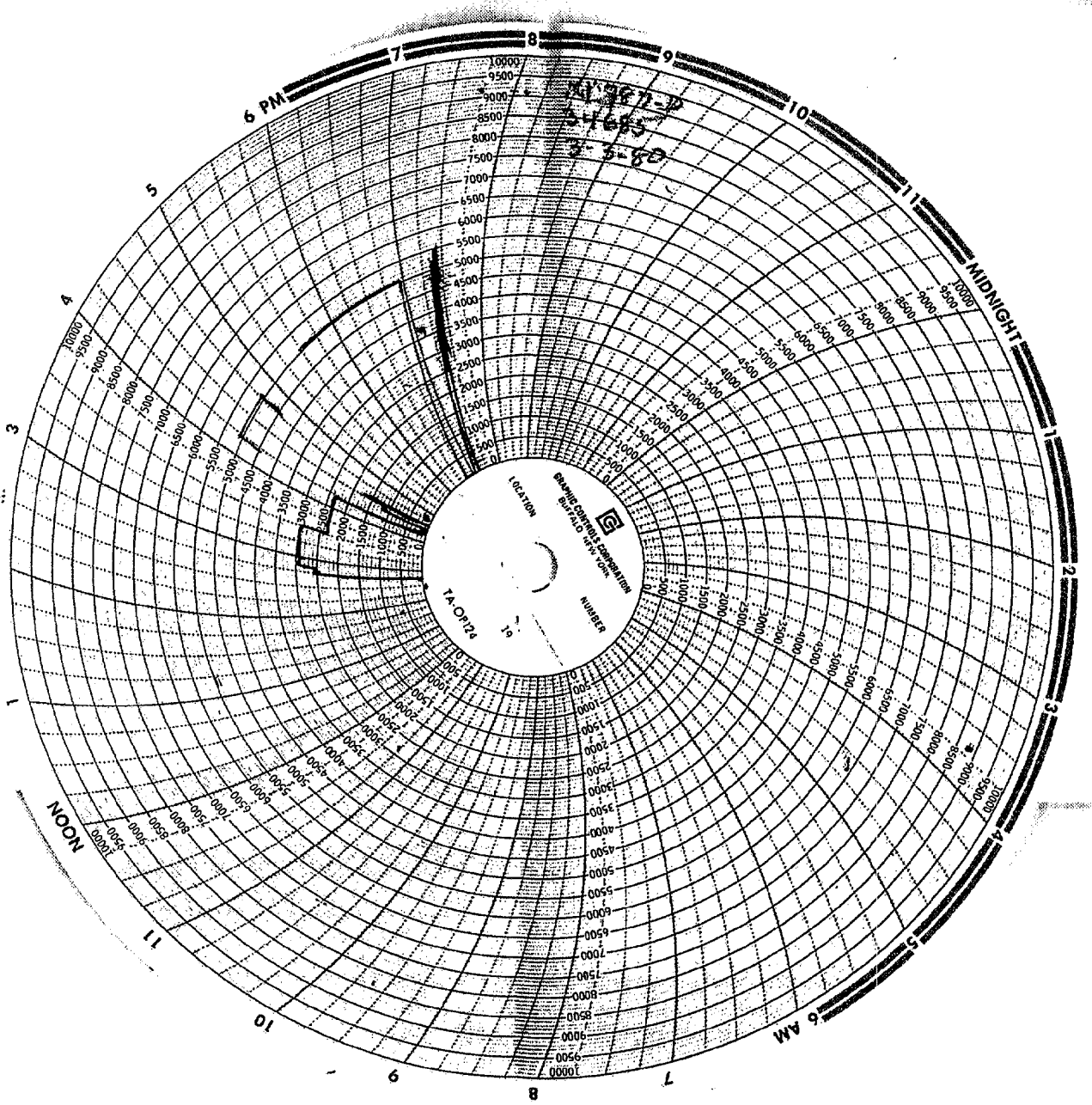
Do not

START	FINISH	OPTR
11:00 PM	7:00 AM	408-409
7:00 A	7:00 A	27

Step	V-262 (20 RPM)	V-243, 244, 246, 247
9	5"	10"
18	25"	48"

K 13520 REV.

DUP050093777



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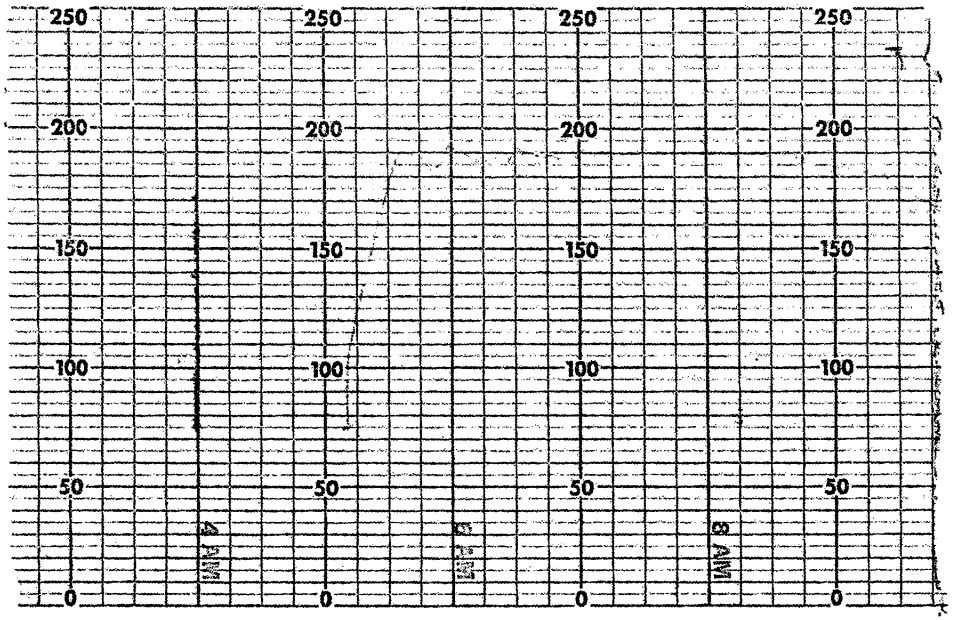

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