

APR 11 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 243, 244, 246, 247 (262)

C.V.

D.V.

CG 03 CODE KY-908-D PKG.

APR 14 35349
EST. WGT. 949 LBS.

PUNCHED & CHECKED

STD. HRS. TIME

APR 11 1980

PROCESSES		APPROVED BY	
() KY-908-D	(E)	EWK	12/12/77
() Alternate	()	DCG	12/14/77
()	()	MW	12/19/77
TYPED BY			
RJ 2/8/77			

14 YC-3-B 93 4 Lot 24733, 650#13
 14 YC-3-B 93 4 Lot 24699, 200#4
 14 YC-3-B 93 4 Lot 24695, 1750#35

Total Weight 3549# (Req.)

APR 11 1980

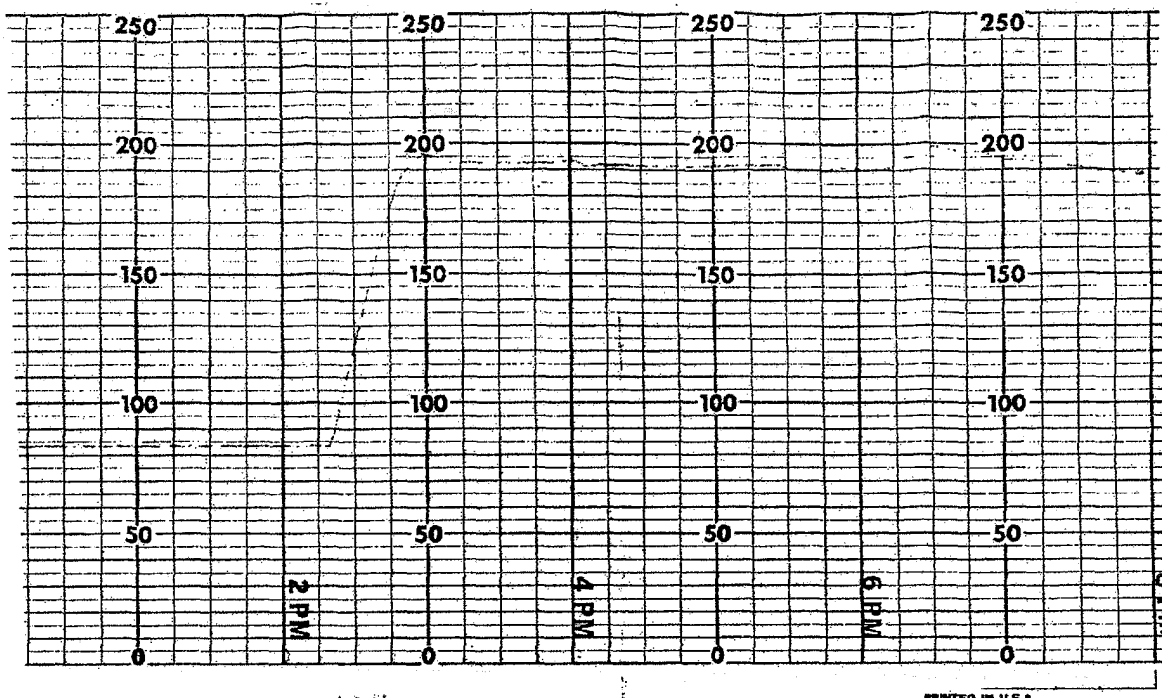
NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
	KROLORO YELLOW - LIGHT			
203 & 205	1 Run 83" (360 G) water into V-203. SET AGITATOR ON HIGH SPEED.			
	2 Pour in	345	32-D	345
	3 Dump in	52 x 50	YC-3-B	2600
	Record: Start 3:30 AM	24733		650
	Fin 5:40 AM	24699		200
	60" (1990 G) 75" (1275 G)	24695		1750
	4 Adj to 70" (2000 G) 2400-2600			
	5 Pump V-203 thru Homog at 1800-2200 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-205 Vol 4.5" & adj to 60" (2100 G)			
	8 Inspect Homog strainer & clean if necessary			
	DURING HOMOG, RUN V-203 AGITATOR ON LOW SPEED			
SV & 205	9 Run 10" (514 G) into V-262. Install temp chart & start agitator			
	10 Pump V-205 thru Homog at 4800-5200 psi into SV			
	Record: Time Start 2:25 PM Min 160			
	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	12 While Homog, run 6" (248 G) water into V-349			
	13 Run +1000# water into V-384 & heat to 110-120°F			
	14 Weigh into V-384 & pump to V-349	1215	32-D	1215
	15 Run +1000# water into V-384 & pump to V-349			
	16 Adj V-349 to 14" (660 G) & stir 15 min or longer			
	17 Record: 1.063 (5.0-0.2) 1.063-1.066			
SV	18 When S 11 Homog complete, adj SV to 4" (2420 G) 2" V-262			
	19 Record: pH 10.0 & adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		7-D	20
	Siphon into SV & Record: pH 11.2			
	20 Heat to 190-194°F in 55-65 min. Record: HT 10°F & Rec 10°F			
	Note: Strike must be started immediately on completion of heating			
343 & 386	21 While heating SV, run 31" (850 G) water into V-343			
	22 Meter in from V-386 M29 9.7 Gal 19.7 Gal		27-D	180
	23 Stir 16 min or longer			
	24 Record: 2.410 (2.4-10.1) 2.410-2.416			

✓ 262

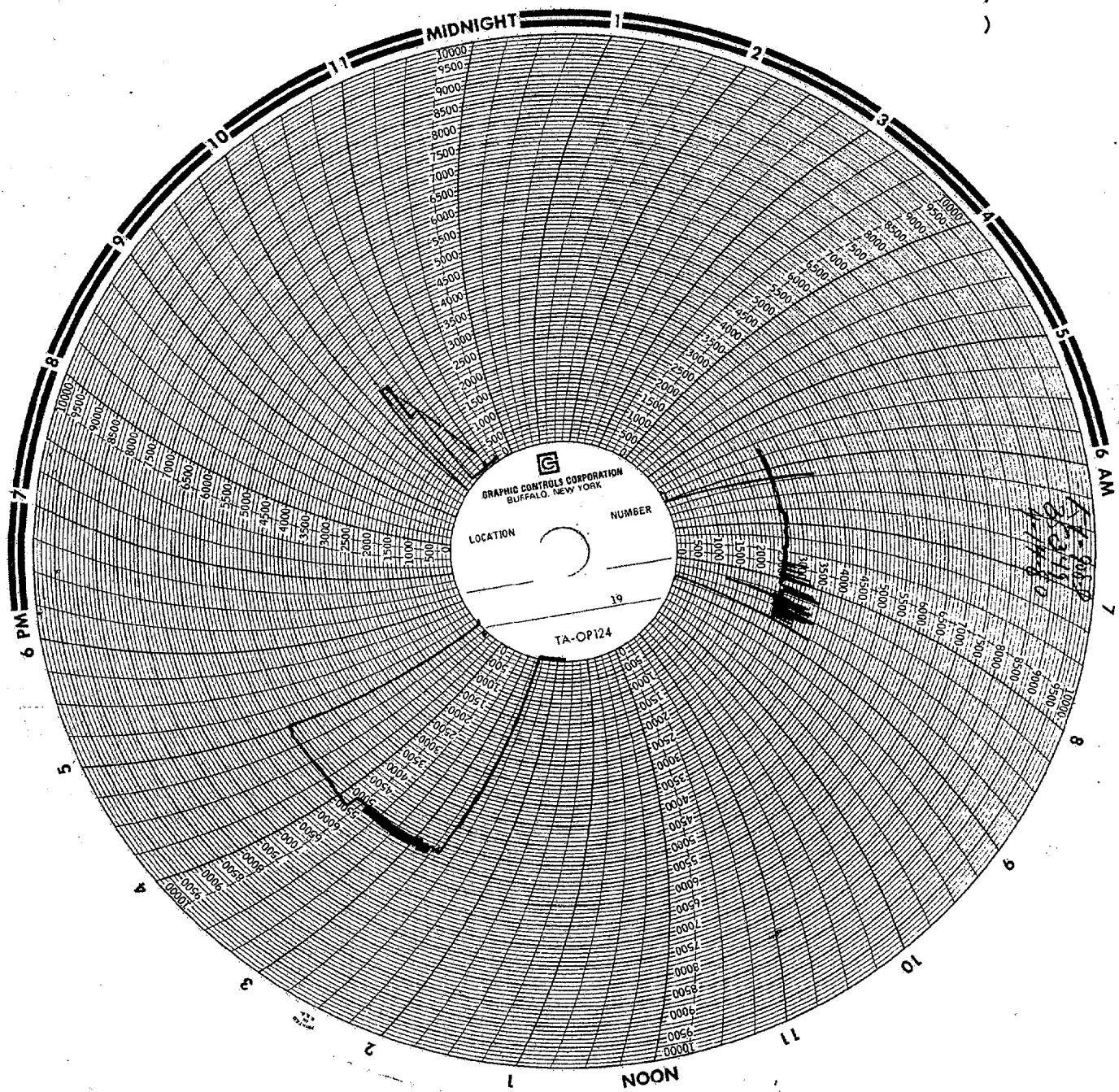
EQUIPMENT	PAGE 2 CG 03 CODE KY-908-D (E) EST. WGT. 3549 LBS.	USE LBS.	N CODE	ACCT LBS.
SV 6	25 When S 20 heating complete Record: pH 9.7 (9.5-10.0) 26 Set V-343 acid pump at 56 setting (+180 min) 27 Set V-349 silicate pump at 49 setting (+145 min) 28 Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike 29 Record: Start Finish Minutes V-343 8:45 P.M. 11:40 P.M. 180 V-349 8:45 P.M. 11:55 P.M. 195 Record: Time V-343 in V-349 in SV pH Normal pH at 20 min 9:00 P.M. (28) 27 (12) 12 9.3 9.3-10.0 40 min 9:20 P.M. (24) 23 (10) 10 9.5 9.3-10.0 1 hr 9:40 P.M. (21) 21 (8) 8 9.2 9.3-10.0 2 hrs 10:40 P.M. (10) 9 (3) 3 8.5 9.3-10.0 Finish 11:40 P.M. (0) 0 (0) 0 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 & Assume 78% 30 Sift in Record: pH 27-D 50 128-A 50			
357 7	31 Run 29" (210 G) water into V-357 and heat to 135-140°F 32 Dump in and stir to dissolve for S60	415	15-A	415
302 8	33 Add 24" (294 G) water to V-302 34 Add and stir 2 min for S63 Assume 50%	100	7-D	50
PT 9	35 During strike pump into PT 36 Pump in 37 Pump in 38 Stir 10 min with lightning mixer for S42	312 36 36	169-A 155-A 160-A	312 36 36
356 10	39 During Strike, run 20" (244 G) water into V-356 40 Turn on steam 41 Adj to 26" (317 G) at 178-182°F 21-22°C 42 Pump PT, mixture from S38 thru undersurface Distributor AFAP 43 Rinse PT with hot water from hot water mixer & pump in 44 Shutoff pump 21-22°C 45 Stir 30 min at 178-182°F for S54 46 Do not shutoff agitator			
SV 11	47 When V-349 MTY, rinse in with minimum water then set pump to zero setting 48 When V-343 MTY, rinse in with minimum water then turn off pump motor 49 Heat to 198-200°F in 5-10 min 50 Close water line & Discharge valves at stearate pump 51 Open V-356 Discharge valves to stearate pump inlet 52 Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer 53 While Homog water at 2900-3100 psi, open Homog Discharge valve to SV & rinse valve to sewer			

SHUT OFF ACID LOW PH 15 MIN. PH 7M.



N32263.01

DUP050457335



N32263.02

DUP050457336