PUNCHED & CHECKED

APR - 8 1980

MAR 24 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 2461/247 C.V. D.V.

PROCESSES		APPROVED BY
( ) KO-786-D	(P)	EWK 9-21-76
( )	( )	DCG 9-21-76
( )	( )	MTW 10-1-76
( )	( )	
TYPED BY		
jlc 11-16-76		

CG 04 CODE KO-786-D PKG. _____

→ MAR 27 35074

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 3P M

OK/AP

01	YC-10-B	93	4	~~34481~~ 33481	1000#
01	YC-10-B	93	4	33488	200#
01	YC-10-B	93	4	34403	1300#

01 YC-10-B 93 34720 1600

MAR 28 1980

Total Weight 4962# (Req. _____)

NON-BLEEDING

EQUIPMENT		NAME: "KROLOR" ORANGE R (SET AGITATOR ON HIGH SPEED)	USE LBS.	N CODE	ACCT. LBS.
211	1	Run 60" (990 G) water in V-211 and add Assume 50%	30	7-D	15
&	2	Weigh in drum and pour in V-211	270	32-D	270
208	3	Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
1	4	Record: Start 1140 - P.M. 33481			
		Fin 1245 - P.M. 33488			
		75" (1256) 34403			
	5	Adjust to 80" (1370 G) 34720			
	6	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	7	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	8	Record: V-208 Vol 46 " and adjust to 50" (1840 G)			
	9	Inspect homog strainer and clean if necessary			
		DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED.			
208	9	Run 15" (771 G) water into V-247 and start agitator and			
&		install temperature chart			
SV	10	Pump V-208 thru Homog at 4800-5200 psi into SV			
2		Record: Time Start 1:25 P.M. Total Minutes 1 2 5			
		Note: If homog pressure falls below 4800 psi, 3-Way valve will recirculate slurry to V-208			
	11	When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349	12	While Homog, run 6" (284 G) water into V-349			
&	13	Run ±1000# 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 ±1000# water into V-384 and pump to V-349			
	16	Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	17	Record: °Be' 1.079 ~~(10.9 ±0.2)~~ (1.078 - 1.081) g/mL			
SV	18	When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	19	Record: pH 10.85 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 _____			
	20	Heat to 190-194°F in 55-65 minutes & Record: HT 192 °F and Rec 192 °F			
		Note: Strike must be started immediately on completion of heating			
343	21	While heating SV, run 51" (1400 G) water into V-343			
&	22	Meter in from V-386 M 25 #/Gal 9.16 Gal 38.8		27-D	355
386	23	Stir 15 minutes or longer			
5	24	Record: °Be' 1.018 ~~(2.8 ±0.1)~~ 1.017 - 1.019 g/mL			

V-247

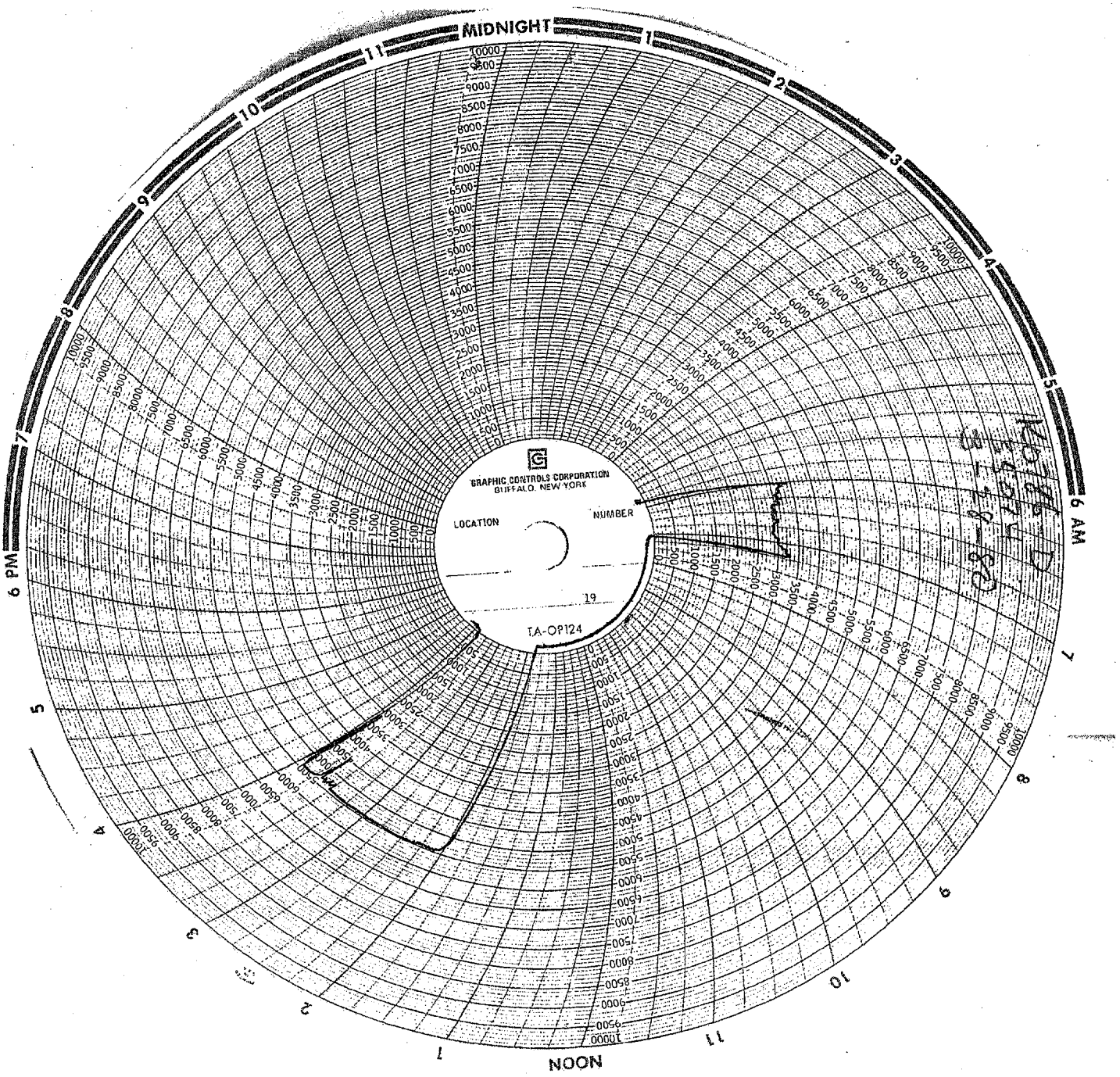
EQUIPMENT		PAGE 2 CG 04 CODE K0-786-D (R) EST. WGT. 4962 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete, Record: pH 9.9 (9.6-10.2)			
	26	Set V-343 acid pump at 72 setting (±225 minutes)			
	27	Set V-349 silicate pump at 66 setting (±180 minutes)			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike			
	29	Record: Start Finish Minutes			
		V-343 7:15 PM 10:20P 185			
		V-349			

Record:	Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
	7:15	53	22		
at 20 min	7:35	(47) 49+	(20)	9.7	9.3-10.0
40 min	7:55	(43) 45	(17) +	9.7	9.3-10.0
1 hr	8:15	(38) 40+	(15) +	9.65	9.3-10.0
2 hrs	9:15	(24) 26-	(7) 8	9.7	9.3-10.0
3 hrs	10:15	(10) 12	(0) 1-	9.7	9.3-10.0
Finish	11:00	(0) —	—	6.6	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 3.6 (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 4.1 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH _____ 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
3:00P 11PM	11:00PM 12:30	235 282

DUP050457934



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N32418.01

V-247