

S.V. (245) 247

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 04 CODE KO-906-D PKG.

→ JAT -4 33623

EST. WGT. 1377 LBS.

STD. HRS. TIME 11P M

01 YC-10-B	93	4	33486	500
01 YC-10-B	93	4	33360	2150
01 YC-10-B	93	4	33487	1050

TOTAL WEIGHT 5077# (Req.)

PROCESSES		APPROVED BY	
()	KO-906-D	(C)	EWK 1/24/78
()		()	DCG 1/26/78
()		()	MW 1/26/78
()		()	
TYPED BY			
ET 3/2/78			

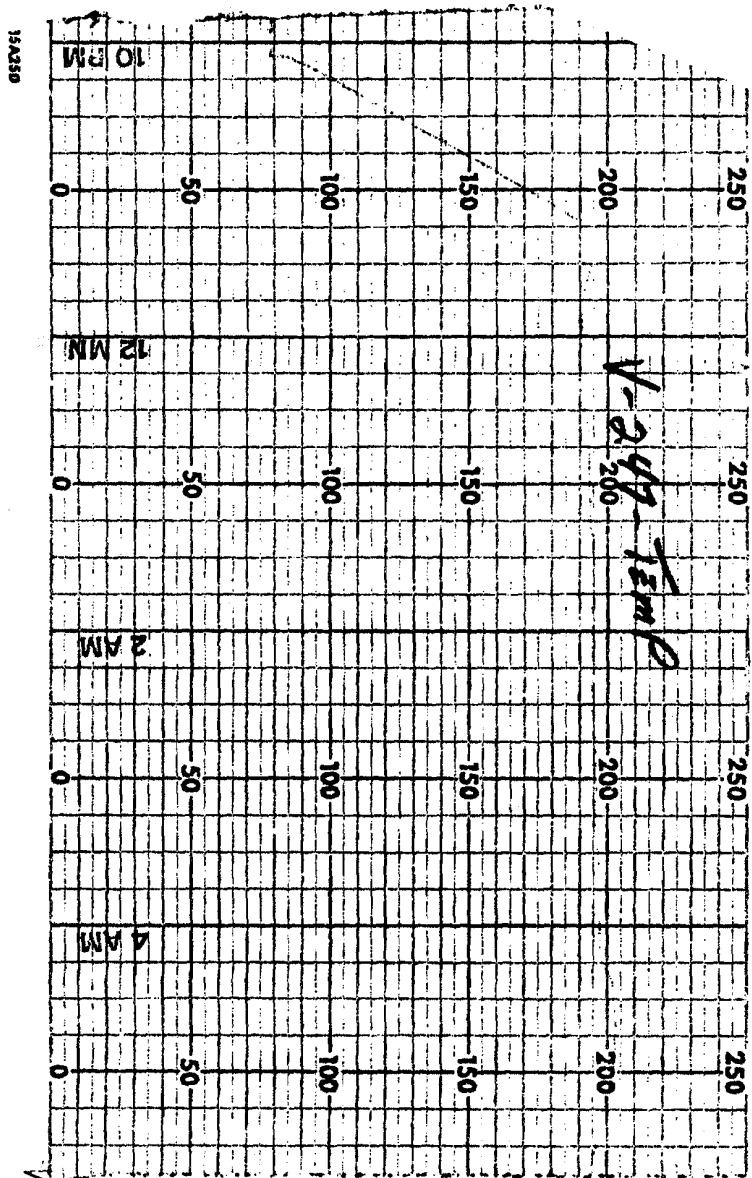
Homog #2 - 1st Pass
 " #2 - 2nd Pass
 " #4 - 2nd Pass
 NON-BLEEDING

QUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
211 & 208	10" 990 G KROLOD ORANGE R			
1	1 Run 21" (505 G) water in V-211 and add Assume 50%	26	7-D	13
	2 Weigh in drum and pour in	245	32-D	245
	3 Dump in and stir 5 min Lot	74 x 50	YC-10-B	3700
	Record: Start 2:30 AM 33486			
	Finish 3:15 AM 33360			
	80" 13600 33487			
75" (1075 G)	4 Adjust to 64" (1082 G)			
	5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-208 Vol 41 " & adjust to 45" (1662 G)			
	8 Inspect Homog strainer and clean if necessary			
208 & SV	9 Run 15" (793 G) water into V-208 & start agitator			
2	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
	11 Record: Time Start 1:45 Total Min			
	Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	12 When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384	13 While Homog, run 5" (237 G) water into V-349			
3	14 Run 1000# water into V-384 and heat to 110-120°F			
	15 Weigh into V-384 and pump to V-349	2165	32-D	2165
	16 Run 1000# water into V-384 and pump to V-349			
	17 Adjust V-349 to 20" (946 G) and stir 15 min or longer			
	18 Record: 1078 (10.9 ± 0.2) (1.078-1.081) g/ml			
SV	19 When S12 Homog complete, adj to 59" (3033 G) in SV			
4	20 Record: pH 10.7 & adj 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, stir 5 min & record: pH			
	21 Heat to 190-194°F in 55-65 min & Record: HT 192, Rec 192 OF			
	Note: Strike must be started immediately on completion of heating			
343 & 386	22 While heating SV, run 46" (1265 G) water into V-343			
5	23 Meter in from V-386 M 1- 9.70#/Gal, 33.0 Gal		27-D	320
	24 Stir 15 min or longer			
	25 Record: 1012 (2.9 ± 0.1)			

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EQUIPMENT		PAGE <u>2</u> CG <u>04</u> CODE <u>K0-906-D (C)</u> EST. WGT. <u>5077</u> LBS.	USE LBS.	N CODE	ACCT LBS.
SV	6	26 When S20 heating complete, Record: pH <u>9.8</u> (9.6-10.2)			
		27 Set V-343 acid pump at 65 setting (± 225 min)			
		28 Set V-349 Silicate pump at 57 setting (± 180 min)			
		29 Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
		30 Record: Start Finish Minutes			
		V-343 <u>12:00 PM</u> <u>3:45 AM</u> <u>225</u>			
		V-349 <u>12:00 PM</u> <u>3:00 AM</u> <u>180</u>			
		Record: Time V-343 V-349 SV pH Normal pH			
		Inches Inches			
		at 20 min <u>12:20 AM</u> (43) <u>43</u> (18) <u>18</u> <u>9.6</u> 9.3-10.0			
		40 min <u>12:40 AM</u> (39) <u>39</u> (16) <u>16</u> <u>9.6</u> 9.3-10.0			
		1 hr <u>1:00 AM</u> (35) <u>35</u> (13) <u>13</u> <u>9.6</u> 9.3-10.0			
		2 hrs <u>2:00 AM</u> (22) <u>22</u> (7) <u>7</u> <u>9.6</u> 9.3-10.0			
		3 hrs <u>3:00 AM</u> (10) <u>10</u> (0) <u>0</u> <u>9.5</u> 9.3-10.0			
		Finish <u>3:45 AM</u> (0) <u>0</u> (0) <u>0</u> <u>8.1</u> 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 to 7.5-8.5 and			
		Record: pH Assume 78%			
	✓ 31	Sift in 1 bag	✓ 50	27-D 128-A	50
357	✓ 32	Run 19" (137 G) water into V-357 & heat to 135-140°F			
	✓ 33	Bump in & stir to dissolve for S61	✓ 270	15-A	270
302	34	Run 24" (294 G) water into V-302			
8	35	Add & stir 2 min for S64 Assume 50%	136	7-D	68
PT	36	During strike pump into PT	464	169-A	464
9	37	Pump in	52	155-A	52
	38	Pump in	52	160-A	52
	39	Stir 10 min with lightning mixer for S43			
356	40	During strike, run <u>15"</u> 22" (268 G) water into V-356			
10	41	Turn on steam			
	42	Adj to 90% (366 G) at <u>178-182°F</u> <u>81-82°C</u>			
	43	Pump PT mixture from S39 thru undersurface Distributor AFAP			
	44	Rinse PT with hot water from hot water mixer & pump in			
	45	Shutoff pump <u>81-82°C</u>			
	46	Stir 30 min at <u>178-182°F</u> for S55			
	47	Do not shutoff agitator			
SV	11	48 When V-349 MTY, rinse in with minimum water then set pump to zero setting			
	49	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	50	Heat to 198-200°F in 5-10 min			
	51	Close water line & discharge valves at stearate pump			
	52	Open V-356 Discharge valves to stearate pump inlet			
	53	Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer			
	54	While Homog water at 2900-3100 psi, open Homog discharge valve to SV & close valve to sewer			
	55	Immediately open stearate pump Discharge valve. Turn on pump & Homog V-356 to SV at 2900-3100 psi			
		Maintain SV at 198-200°F			
	56	While Homog V-356 to SV, shutoff water valve at Stearate pump ASAP			

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SV	11	Con'T'	57	When Homog complete, rinse in V-356 with hot water							
				From hot water mixer							
			58	When 857 complete, turn off Homog & stearate pump							
			59	Stir 5 min at 198-200°F							
			60	Shut off steam							
			61	Run in V-357 from S33 and stir 5 min							
			62	Record: pH <u>3.3</u> (3.3-3.7)							
			63	If necessary, adj pH to 3.3-3.7 (Downward only) and							
				Record: pH						15-A	
			64	Run in N-7-D from S35 in 4-6 min and stir 5 min							
			65	Record: pH <u>4.2</u> (4.0-4.2) and if necessary, adj to							
				pH 4.0-4.2 and Record: pH						27-D	
				(Dilute 10 parts water to 1 part N-7-D) Assume 50%						7 D	
				Siphon N-7-D into SV							
			66	Do not stop agitator							
				START	FIN	OPTR					
				11:00 P	11:00 P	120-126					
				3:00 P		235-323					
				11: Pm		223-282					



15A330

