

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

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

CG 03 CODE KY-788-D

PKG.

PUNCHED & CHECKED

→ FEB 23 34504
EST. WGT. 960-860 LBS.

FEB 26 1980

OIR
KP

PROCESSES		APPROVED BY
() KY-788-D	(K)	
() ALTERNATE	()	
()	()	EWK 9/22/76
()	()	DCG 9/27/76
TYPED BY		MTW 9/30/76
NE 2/24/77		

STD. HRS. 11.2 TIME

5 P M

14 YC-3-B 93 4 Lot 24410, 2000 #
 14 YC-3-B 93 4 Lot 23864, 300 #
 14 YC-3-B 93 4 Lot 24403, 300 #

Total Wgt. 3560# 3460

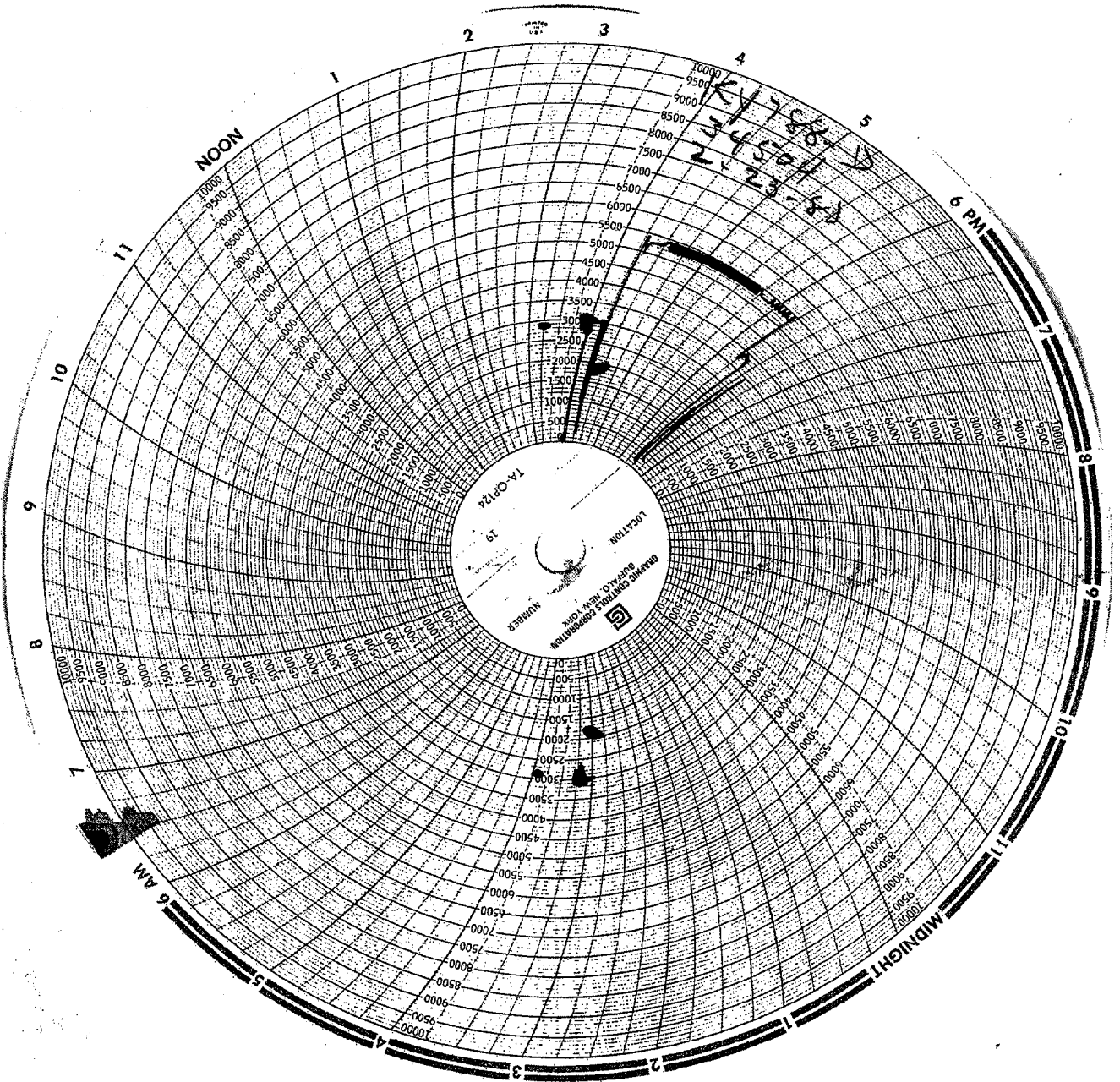
NON-BLEEDING

EQUIPMENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
203 & 205 1	6" "KROLOR" YELLOW - LIGHT 1 Run 6" (300 G) water into V-203 with agitator on high speed. 2 Weigh in drum & pour in 3 Dump in & stir 5 min Record: start 24410 2000 Fin 23864 300 24403 300 4 Adj to 70" (1200 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 56 " & adj to 60" (2100 G) 8 Inspect Homog strainer & clean if necessary 9 During homog, run V-203 agitator on low speed. SV 9 Run 9" (514 G) into V-205 install temp chart & start agitator 10 Pump V-205 thru Homog at 4800-5200 psi into SV 262 205 10 Record: Time Start 10:15 PM Total Min 135 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 110-120 °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" (662 G) & Stir 15 min or longer 114 17 Record: Bg 1.066 (8:95 ± 0.2) (1.063-1.066) 8/mL SV 4 18 When S 11 Homog complete, adj SV to 24 " (2420 G) 19 Record: pH 10.4 & adj to 11.0-11.2 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon into SV & Record: pH 11.1 16 7-D 8 20 Heat to 190-194F 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 31" (850 G) water into V-343 31 22 Meter in from V-386 M 19, 9.19 #/Gal 19.6 Gal 27-D 180 23 Stir 15 min or longer 24 Record: Bg 1.015 (2.35 ± 0.1) (1.014-1.016) 8/mL			

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EQUIPMENT	PAGE 2	CO-03	CODE KY-788-D	EST. WGT.	3560	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete Record: pH <u>7.8</u> (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 190-194F during strike							
SV	29	Record: <u>Start</u> <u>Finish</u> <u>Minutes</u>							
		V-343	<u>1:15A</u>	<u>4:15A</u>	<u>3:00</u>				
		V-349	<u>1:15A</u>	<u>3:30A</u>	<u>2:15</u>				
		Record:	Time	V-343	V-349	SV	Normal		
				in	in	pH	pH		
		at 20 min	<u>1:35A</u> (28)	<u>4:25</u> (22)	<u>9.6</u>		9.3-10.0		
		40 min	<u>1:55A</u> (24)	<u>4:45</u> (20)	<u>9.6</u>		9.3-10.0		
		1 hr	<u>2:15A</u> (20)	<u>5:05</u> (18)	<u>9.6</u>		9.3-10.0		
		2 hrs	<u>3:15A</u> (10)	<u>6:05</u> (18)	<u>9.6</u>		9.3-10.0		
		Finish	<u>4:15A</u> (0)	<u>6:15</u> (10)	<u>8.0</u>		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 <u>10.2</u> (9.5-10.5)							
	33	Stir 20 min or longer to dissolve for S 46							
357 8	34	Run 29" (210 G) water into V-357 & heat to 135-140°F							
	35	pump in & stir to dissolve for S 42					415	15-A	415
302 9	36	Run 30" (360 G) water into V-302							
	37	Add & stir 2 min for S 44 Assume 50%					360	7-D	180
SV 10	38	When V-349 MTX, rinse in with minimum water then set pump							
	39	at zero setting							
	40	When V-343 MTX, rinse in with minimum water then turn off							
	41	pump motor							
	42	Turn off steam							
	43	Sift in 2 bags					100	128-A	100
	44	Run in V-357 from S 35 & stir 5 min							
	45	Record: pH <u>3.4</u> (3.7-4.2)							
	46	Run in N-7-D from S 37 in 10-12 min & stir 5 min							
	47	Record: pH <u>7.4</u> (9.0-9.5) & if necessary adj to pH 9.0-9.5							
	48	& Record: pH Assume 77%						27-D	
	49	Dilute 10 parts water to 1 part N-7-D Assume 50%						7-D	
	50	Siphon N-7-D into SV							
	51	Run in V-330 thru 20 mesh screen & stir 20 min							
343 11	52	Run 10" (128 G) water into V-313 & dump in					135	20-A	135
	53	Stir 5 min to dissolve for S 49							
SV 12	54	Run V-313 into SV in 15-20 min							
	55	Stir 15 min							
	56	Record: pH <u>9.2</u> (9.0-10.0)							
	57	Stop agitator <u>Do not stop - V-262</u>							
START <u>3:20 PM</u> <u>7:00 PM</u> FINISH <u>11:15 PM</u> <u>6:30 PM</u> OPTR <u>282458</u> <u>27</u>									
Step V-262 (20 RPM) V-243, 244, 246, 247									
9 5" 10"									
18 24" 47"									

K 13830 REV.



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