

243, 244, 246, 247, 262

C.V.

D.V.

CG 03 CODE KY-787-D PKG.

EST. WGT. 1921 LBS. 33310

STD. HRS. TIME 7 A M

14 YC-2-B 93 4 Lot #
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PROCESSES		APPROVED BY	
()	KY-787-D (S)	()	EWK 10-19-77
()	Alternate ()	()	DCG 10-25-77
()	()	()	MTW 10-26-77
()	()	()	
TYPED BY			
JIC 11-4-77			

Total Wgt 6121# (REQ.)

NON-BLEEDING

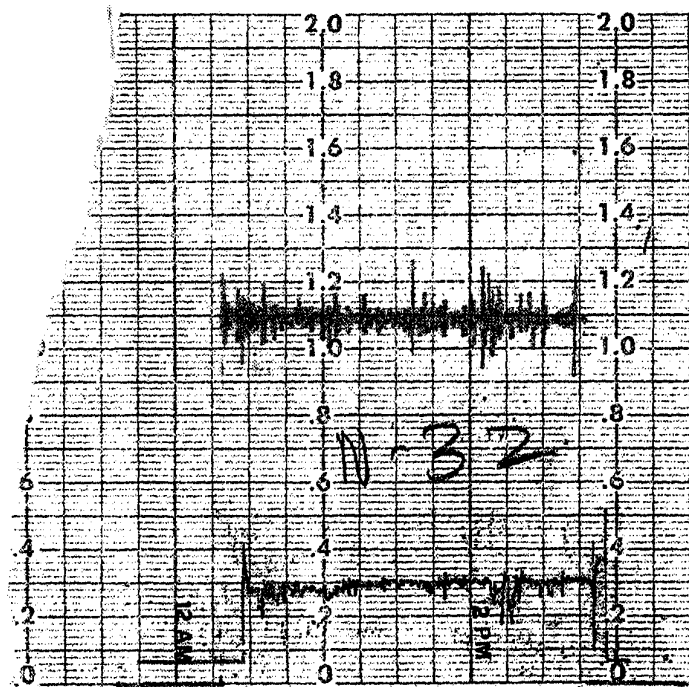
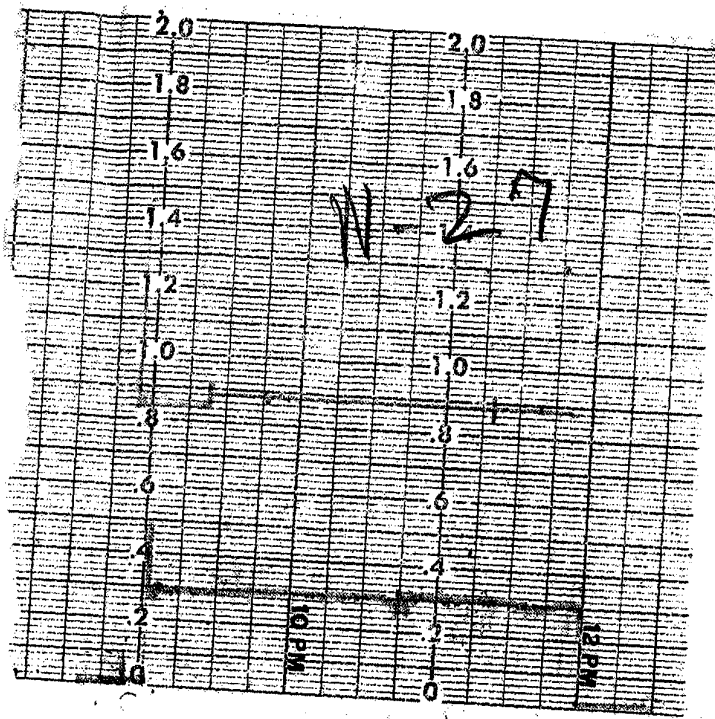
IPMENT		NAME: KROLO® YELLOW-MEDIUM	USE LBS.	N CODE	ACCT LBS.
203 & 205 1	1	Run 39" (645 G) water into V-203 & pour in Assume 50%	40	7-D	20
	2	Weigh in drum & pour in	560	32-D	560
	3	Dump in & stir 5 min LOT	84 x 50	YC-2-B	4200
		Record: Start			
		Fin			
	4	Adj to 75" (1275 G)			
	5	Pump V-203 thru Homog 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. " & adj to 60" (2100 G)			
	8	Inspect Homog strainer & clean if necessary			
SV & 205 2	9	Run " (200 G) water into V- install temp chart & start agitator			
	10	Pump V-205 thru Homog at 4800-5200 psi into SV- Record: Time Start Total Min			
		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	3220	32-D	3220
	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' (18.0 ± 0.2)			
SV 4	18	When S 11 Homog complete, add SV to " (2570 G)			
	19	Record: pH & adj to 11.4-11.6 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon into SV & Record: pH			
	20	Heat to 190-194°F in 35-45 min (V-262) or in 55-65 min (V-243, 244, 246, 247) & 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 #/G Gal		27-D	481
	23	Stir 15 min or longer			
	24	Record: Be' (4.8 ± 0.1)			

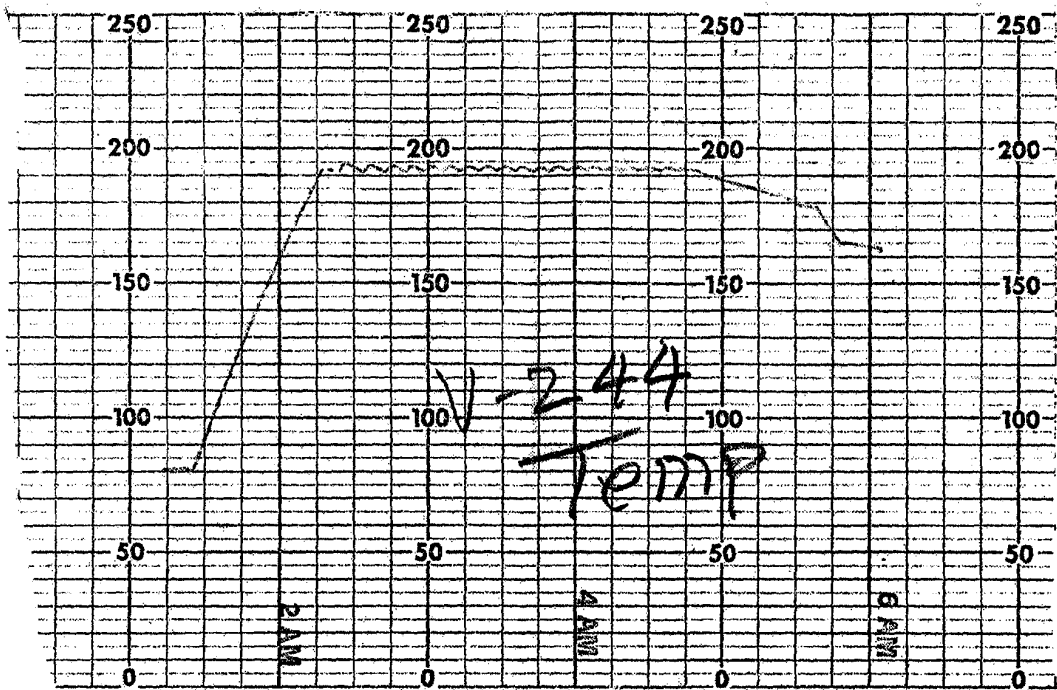
N 26222

V-244

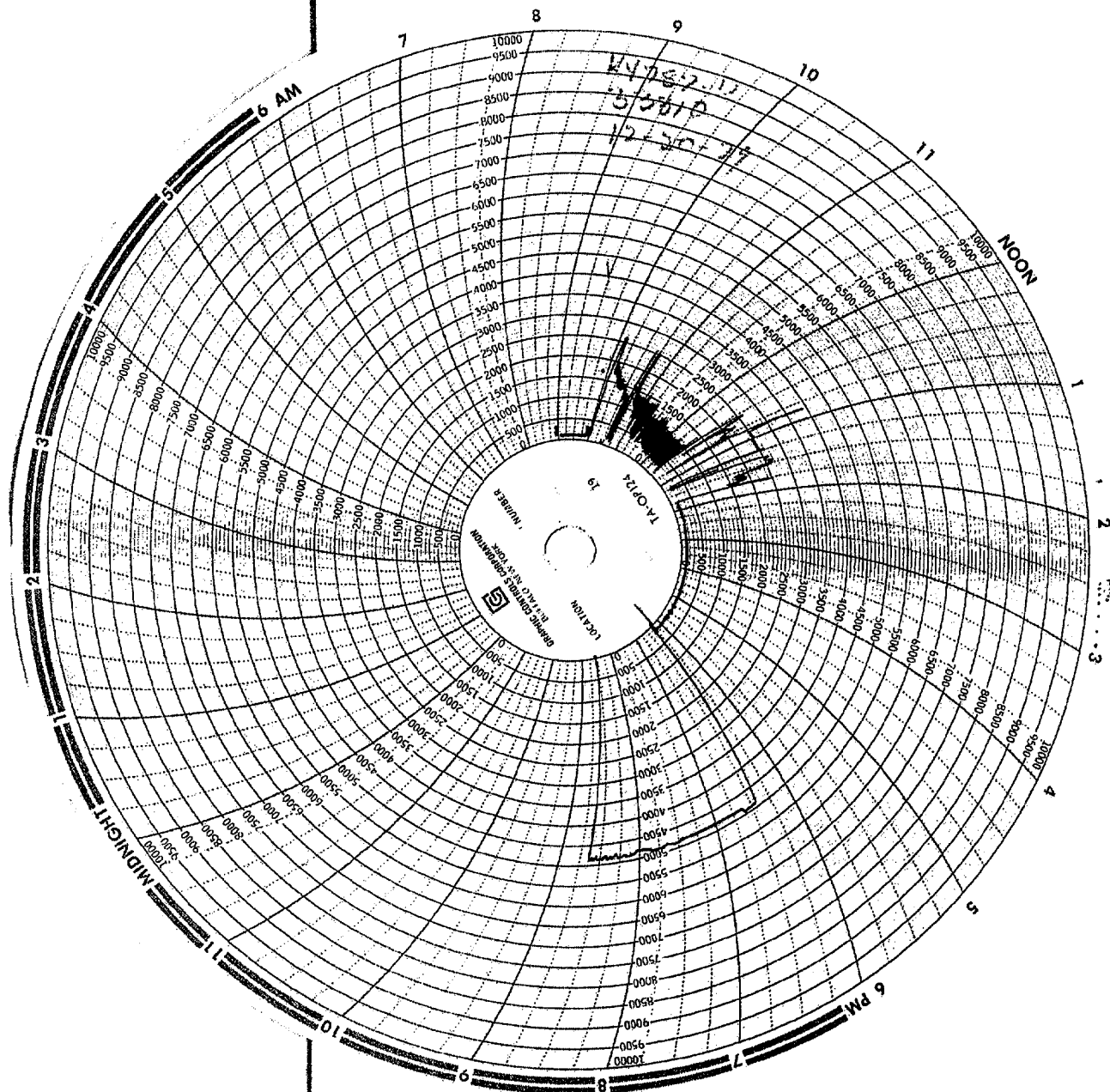
JIPMENT	PAGE 2	CG 03	CODE KY-787-D	EST. WGT. 3490	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	22	SP Step 06/89 - After heat up Record: pH <u>10.0</u> (9.5-10.0)						
SP	23	Switch 3FC20, 8FC10, 8FC20 to Auto						
&	24	Operator Step PB						
CP	25	SP Step 10/43 - When 3FC20, 8FC10, 8FC20 water flows in limits						
5		Switch 3FC10 to Auto. Operator Step PB						
	26	SP Step 11/44 - When 3FC10, 3FC20 flows in limits, switch 3FC20 to Remote.						
	27	Operator Step PB						
	28	During strike, record pH & time as follows:						
		SP STEP						
		V-243/V-244	pH	Range	Time	INCREASED N.27		
		13/46 (30 min)	<u>10.0</u>	9.0-10.0	<u>10:55</u>	<u>0.86</u>		
		14/47 (60 min)	<u>10.0</u>	9.0-10.0	<u>11:25</u>			
		15/48 (2 hrs)	<u>9.9</u>	9.0-10.0	<u>12:25</u>			
		16/49 (2 hrs 25 min)	<u>9.85</u>	9.0-10.0	<u>12:50</u>			
		17/50 (3 hrs Final)	<u>7.6</u>	7.5-8.5	<u>1:25</u>			
		NOTE: If not as specified notify Supervisor & note in log						
		If final pH is above 8.5, add pH to 7.5-8.5 &						
		Record: pH Assume 77%					27-D	
339	29	White striking, run 30" (234 G) water into V-339						
6	30	Add in 7-8 min				350	530-A	350
	31	Add to 49" (382 G) at 80 - 1000F						
	32	Stir 5 min & record pH <u>10.2</u> (9.5-10.5)						
	33	Stir 15 min or longer to dissolve for SP Step 26						
	34	Record Vol <u>49</u> & calculate <u>49</u> (Vol) x 0.78 = <u>38.2</u> G						
	35	Set preset #8 to <u>38.2</u> G from S 34						
302	36	Add 30" (360 G) water to V-302						
7	37	Add & stir 2 min For S 41 Assume 50%				160	7-D	80
243	38	SP Step 17/50 - After checking pH, Operator Step PB						
	39	SIFT in 2 Bags				100	120-A	100
SP	40	SP Step 23/53 - Record: pH <u>3.4</u> (3.7-4.2)						
&	41	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
CP	42	Record: pH <u>9.2</u> (9.0-9.5) & if necessary add pH 9.0-9.5						
8		& 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						
	43	Operator Step PB						
	44	SP Step 29/58 Record: pH <u>9.0</u> (9.0-10.0) Time <u>2:30</u> PM						
	45	Operator Step PB						
	46	SP Step 60 - Batch complete						
		Start	Finish	Optr				
		Time	Time	SP Step				
		<u>2:00A</u>				<u>2:30</u>	<u>342</u>	

UIPMENT	PAGE	CG	03	CODE	KY-787-D (S)	EST. WGT.	6121	LBS.	USE	N	ACC
									LBS.	CODE	LB.
SV 6	25	When S 20 heating complete, Record: pH (9.6-10.2)									
	26	Set V-343 acid pump at 57 setting ($\pm$ 225 min)									
	27	Set V-349 silicate pump at 48 setting ($\pm$ 180 min)									
	28	Immediately meter in V-343 & 349, maintain SV at 190-194°F during strike									
	29	Record: START FIN MIN									
		V-343									
		V-349									
		Record:	TIME	V-343	V-349	SV	NORMAL				
				in	in	pH	pH				
		at 20 min		(37)	(15)		9.3-10.0				
		40 min		(34)	(13)		9.3-10.0				
		1 hr		(30)	(11)		9.3-10.0				
		2 hrs		(19)	(6)		9.3-10.0				
		3 hrs		(8)	(0)		9.3-10.0				
		Finish		(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 & Record: pH Assume 78%									
										27-D	
330 7	30	Run 35" (600 G) water into V-330 & heat to 160-170°F									
	31	Add in 12-13 min									
	32	Stir 5 min & Record: pH (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									
								280		15-A	280
302 9	36	Run 42" (513 G) water into V-302									
	37	Add & stir 2 min for S 44 Assume 50%									
								320		7-D	160
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 4 bags									
	42	Run in V-357 from S 35 & stir 5 min									
	43	Record: pH (3.7-4.2)									
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min									
	45	Record: pH (9.0-9.5) & if necessary, adj to pH 9.0-9.5 & Record: pH Assume 78%									
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%									
		Siphon N-7-D into SV									
	46	Run in V-330 thru 20 mesh screen & stir 20 min									
330 11	47	Run 11" (216 G) water into V-330 & dump in									
	48	Stir 5 min to dissolve for S 49									
								230		20-A	230
SV 12	49	Run V-313 into SV in 15-20 min									
	50	Stir 15 min									
	51	Record: pH (9.0-10.0)									
	52	Stop agitator									
			START		FIN		OPTR				
		Step	V-262 (20 RPM)		V-243, 244, 246, 247						
		9	2"		4"						
		18	26"		50"						





GRAPHIC C



V-244