

DEC 27 1978

MAKING INSTRUCTIONS: BATCH UNIT

V-246-247

C.V.

D.V.

CG 04 CODE KO-906-D PKG.

→ DEC 29 33571
EST. WGT. 1377 LBS.

STD. HRS. TIME 11 P M

01 YC-10-B	93	4	33355	150
01 YC-10-B	93	4	31677	1500
01 YC-10-B	93	4	31686	750

01 YC-10-B 93 33361 1300 #

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

TOTAL WEIGHT 5077# (Req. _____)

NON-BLEEDING

UIMPENT	NAME:	USE LBS.	N CODE	ACCT. LBS.
211 & 208	60" KROLOR® ORANGE R			
1	Run 20" (505 G) water in V-211 and add	Assume 50%	26	7-D 13
	Weigh in drum and pour in		245	32-D 245
	Dump in and stir 5 min	Lot	74 x 50	YC-10-B 3700
	Record: Start 8:40-PM	33355		
	Finish 9:40-PM	31677		
	25" (1275 G) 80" 1316 G	31686		
	Adjust to 64" (1082 G)	33361		
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	Record: V-208 Vol 3Y " & adjust to 45" (1662 G)			
	Inspect Homog strainer and clean if necessary			
208 & SV	Run 15" (793 G) water into V- 147 & start agitator			
2	Pump V-208 thru Homog at 4800-5200 psi into SV			
	Record: Time Start 8:50 PM Total Min 135			
	Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384	While Homog, run 5" (237 G) water into V-349			
3	Run 1000# water into V-384 and heat to 110-120°F			
	Weigh into V-384 and pump to V-349	2165	32-D	2165
	Run 1000# water into V-384 and pump to V-349			
	Adjust V-349 to 20" (946 G) and stir 15 min or longer			
	Record: 98" 1.079 (10.9 ± 0.2) (1.078-1.081)			
	9/mL			
SV	When 512 Homog complete, adj to 59" (3033 G) in SV			
4	Record: pH 10.6 & 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			
	Heat to 190-194°F in 55-65 min & Record: HT			
	Note: Strike must be started immediately on completion of heating			
343 & 386	While heating SV, run 46" (1265 G) water into V-343			
5	Meter in from V-386 M 82 98 8 #/Gal. 32.4 Gal	443	27-D	320
	Stir 15 min or longer			
	Record: 98" 1.019 (2.9 ± 0.1) 1.018-1.019			
	9/mL			

EQUIPMENT		PAGE 2	CG 04	CODE K0-906-D (C)	EST. WGT. 5077	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	6	26	When S20 heating complete, Record: pH <u>9.6</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>3:30 P.M.</u>						
			V-349						
			Record:	Time	V-343	V-349	SV pH	Normal pH	
					Inches	Inches			
			at 20 min	<u>3:50 P</u>	(43) <u>43</u>	(18) <u>18</u>	<u>9.5</u>	9.3-10.0	
			40 min	<u>4:10 P</u>	(39) <u>39</u>	(16) <u>16</u>	<u>9.5</u>	9.3-10.0	
			1 hr	<u>4:30 P</u>	(35) <u>35</u>	(13) <u>13</u>	<u>9.5</u>	9.3-10.0	
			2 hrs	<u>5:30 P</u>	(22) <u>22</u>	(7) <u>7</u>	<u>9.5</u>	9.3-10.0	
			3 hrs	<u>6:30 P</u>	(10) <u>15</u>	(0) <u>2</u>	<u>9.5</u>	9.3-10.0	
			Finish	<u>7:15 P</u>	(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 to 7.5-8.5 and						
			Record: pH Assume 78%						
		31	Sift in 1 bag				50	27-D 128-A	50
357	7	32	Run 19" (137 G) water into V-357 & heat to 135-140°F						
		33	Dump in & stir to dissolve for S61				270	15-A	270
302	8	34	Run 24" (294 G) water into V-302						
		35	Add & stir 2 min for S64 D Assume 50%				136	7-D	68
PT	9	36	During strike pump into PT				464	169-A	464
		37	Pump in				52	155-A	52
		38	Pump in				52	160-A	52
		39	Stir 10 min with lightning mixer for S43						
356	10	40	During strike, run ¹⁵ 22" (268 G) water into V-356						
		41	Turn on steam						
		42	Adj to 303° (366 G) at 178-182°F <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 178-182°F 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						

