PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 2 & 1 (247) — S.V. (3100 G) — O.V.

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

JOB 04 CODE KO-786-D PKG

BATCH 3 OF 01

EST. NET 4962 LBS.

STD. HRS. 10.5 TIME 7 AM

01 YC-10-B 93 4 33920# + 500# DI YC-10-B 93 33420# 1050 #

01 YC-10-B 93 4 35018 + 300# Homog #2 S.V. - 247 MTW 1-1-77

01 YC-10-B 93 4 33920 + 2450#

Total Weight 4962# (Req.)

NON-BLEEDING

EQUIPMENT		NAME: KROLOR ORANGE R- (Hold Sheet)	USE LBS.	N. CODE	AGET LBS.
211 & 208 1	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	12-D	270
	3	Dump drum and stir 5 minutes	82 x 50	YC-10-B	4100
		Record: Start 33924	500		
		Finish 35018	500		
		(2094) 33920	2050		
	4	Adjust to 80" (1320 G)	1050		
	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 43" and adjust to 60" (1800 G)			
	8	Inspect Homog strainer and clean if necessary			
		Initial Record Book Next Batch Size (Hold Sheet)			
208 & SV 2	9	Run 15" (771 G) water into V-247 and start agitator and install temperature chart			
	10	Pump V-208 thru Homog at 4800-5200 psi into SV			
		Record: Time Start 1:40 PM Final Minutes 150			
		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 & 384 3	12	While Homog. run 6" (284 G) water into V-349			
	13	Run 1000# water into V-384 and heat to 110-120°F			
	14	Weigh into V-384 and pump to V-349	2400	32-D	2400
	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: Sec 1.078 (10.5 to 22" (1.078-1.081) Final			
SV 4	18	When S.V. Homog complete, adjust to 66" (3400 G) in SV			
	19	Record: pH 10.7 and adjust to 10.4-10.8 using N-7-D diluted to 6% (10 parts water to 1 part N-7-D) Assume 50%	300	7-D	150
		Siphon N-7-D into SV and Record: pH 10.72 G and			
	20	Heat to 190-194°F in 35-65 minutes & Record: pH 10.2 G and Rec. 194 F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run 5" (1400 G) water into V-343			
	22	Meter in from V-386: M 23 #/Gal 329 Gal		27-D	350
	23	Stir 15 minutes or longer			
	24	Record: Sec 1.017 (2-8-77) (1.017-1.019) Final			

N32489

V-247

EQUIPMENT		PAGE 2 CG 04 CODE KO-786-D (A) TEST WGT. # 4962 LBS.	USE LBS.	IN CODE	ACCT LBS.
SV 6	25	When S 20 heating complete, Record: pH 10.0 (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 7:50 Pm / 1:35 Am / 275 V-349 7:50 Pm / 11:50 Pm / 180			

Record	Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
at 20 min	8:10 Pm	(47) 47	(20) 20	9.7	9.3-10.0
40 min	8:20 Pm	(43) 43	(17) 17	9.7	9.3-10.0
1 hr	8:52 Pm	(38) 38	(15) 15	9.7	9.3-10.0
2 hrs	9:50	(24) 25	(7) 7	9.7	9.3-10.0
3 hrs	10:50	(10) 14	(0) —	9.7	9.3-10.0
Finish	11:35 Pm	(0)		6.9	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	16-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 3.0 (3.3-3.7)			
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH 11		18-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
1:00 Am	7:00 Am	126-101
7:00 A	3:00 P	235-323
3 Pm	11 Pm	223-342
11:00 Pm	1:00 Am	201

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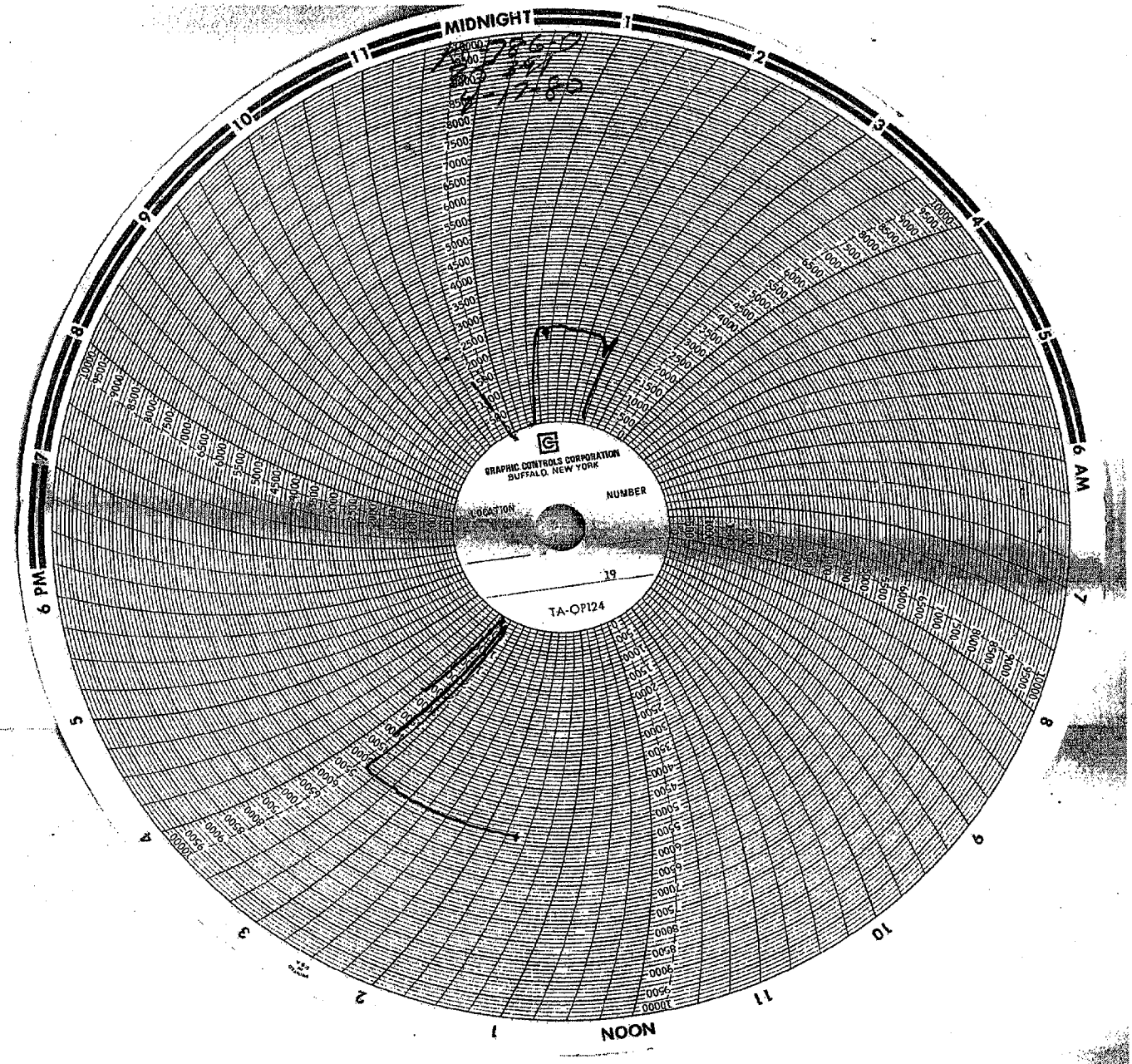

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