DEC 19 1979

MAKING INSTRUCTIONS: BATCH UNIT

V. 246 247 C.V. D.V.

CG 04 CODE KO-786-D PKG. _____

DEC 22 33460

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 7A M

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

OK

Bag 3

Homog #2

01 YC-10-B 93 4 33063, 4100 #
01 YC-10-B 93 4 _____, _____ #
01 YC-10-B 93 4 _____, _____ #

Total Weight 4962# (Req. _____)

NON-BLEEDING

EQUIPMENT		NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. 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	32-D	270
	3	Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
		Record: Start 10.30 33063	82		
		Fin 1.00			
		75" (12756)			
	4	Adjust to ~~80" (1370 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 34 " and adjust to 50" (1840 G)			
	8	Inspect homog strainer and clean if necessary			
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 3:45 AM Total Minutes 110			
		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: ~~°Be'~~ 1.081 ~~(10.9 ±0.2)~~ 1.078 - 1.081 G/mL			
SV 4	18	When S 11 Homog complete, adjust to 66" (3400 G) in SV			
	19	Record: pH 10.8 and adjust 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 and Record: pH			
	20	Heat to 190-194°F in 55-65 minutes & Record: HT 18 F and Rec 192 F			
		Note: Strike must be started immediately on completion of heating 25" #331 IN		355 331 24	
343 & 386 5	21	While heating SV, run 51" (1400 G) water into V-343			
	22	Meter in from V-386 M 83 #/Gal 9.8 Gal 2.4		27-D	355
	23	Stir 15 minutes or longer			
	24	Record: ~~°Be'~~ 1.019 ~~(2.8 ±0.1)~~ 1.017 - 1.019 G/mL			

V-247

EQUIPMENT		PAGE 2 CG 04 CODE KO-786-D (R) EST. WGT. 4962 LBS.	USE LBS.	N CODE	ADD'L L.B.
SV 6	25	When S 20 heating complete, Record: pH 10.1 (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 7:30 11:30AM 240 V-349 7 AM 10:35A 185			

Record:	Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
	7:30				
at 20 min	7:50	(47) +	(20) −	9.8	9.3-10.0
40 min	8:10	(43) 44	(17) +	9.8	9.3-10.0
1 hr	8:30	(38) 39+	(15) +	9.8	9.3-10.0
2 hrs	9:30	(24) 26+	(7) 8−	9.7	9.3-10.0
3 hrs	10:30	(10) 12+	(0) +	9.7	9.3-10.0
Finish	11:30	(0)		6.4	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	15-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 3.1 (3.3-3.7)			
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH		15-A	
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes			
	41	Record: pH 3.8 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH 4.0 Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	6	7-D	3
		Siphon N-7-D into SV			
	42	Stop agitator			

START	FINISH	OPTR
7:00A	12:30PM	235

DUP050095475

K-13836 Rev. 4/25/74

REQUEST FOR MATERIAL

REQUEST NO. 0495

DATE 12/20/79

DUP050095476

DELIVER TO Making Area BLDG. 6 FLOOR 3RD BY 12/22/79 ____ M.

FOR CODE K0786D LOT 33460

WRITTEN BY C. Hill
Production Control

Whse. Loc.	DELIVERY DATA							SUPERVISOR*		CONSUMPTION DATA						
	Code	Pkg./ Qual.	Lot	No. Pkg.	Net	Total Dry Weight	Lbs. Dry Received	Delivering Area	Receiving Area	Lbs. Pulp/Paste	Dry Content	Lbs. Dry	Consume Lbs./Hr.	Lbs. Consumed	Balance Remaining	Consuming Supv.
BAY 3	YC-10-B	93	33063	82	50	4100										

PICK UP AND RETURN TO STORAGE THE FOLLOWING:

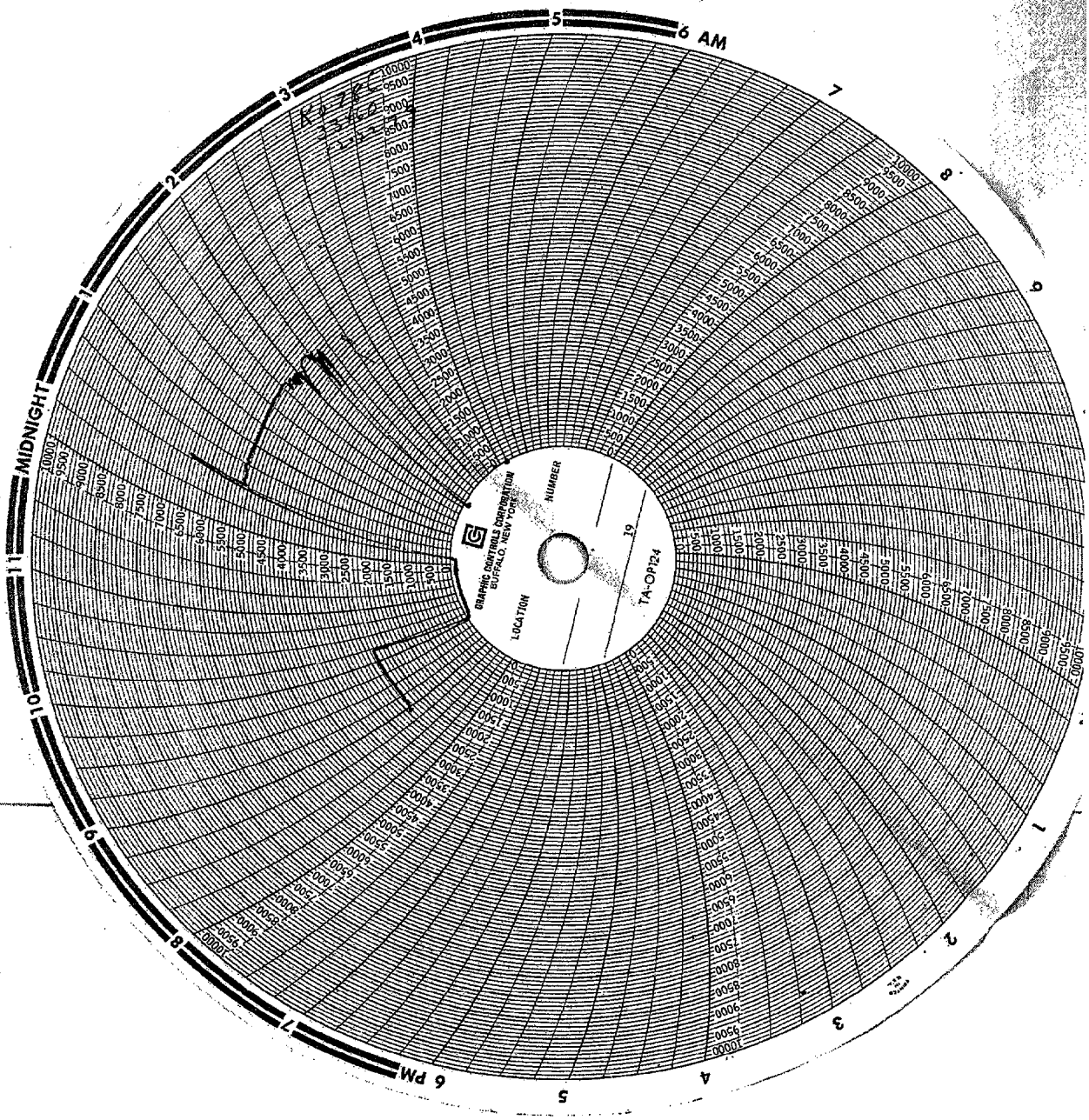
*Each Supervisor must explain weight differences on reverse side.

LOCATED IN _____ BLDG., _____ FLOOR.

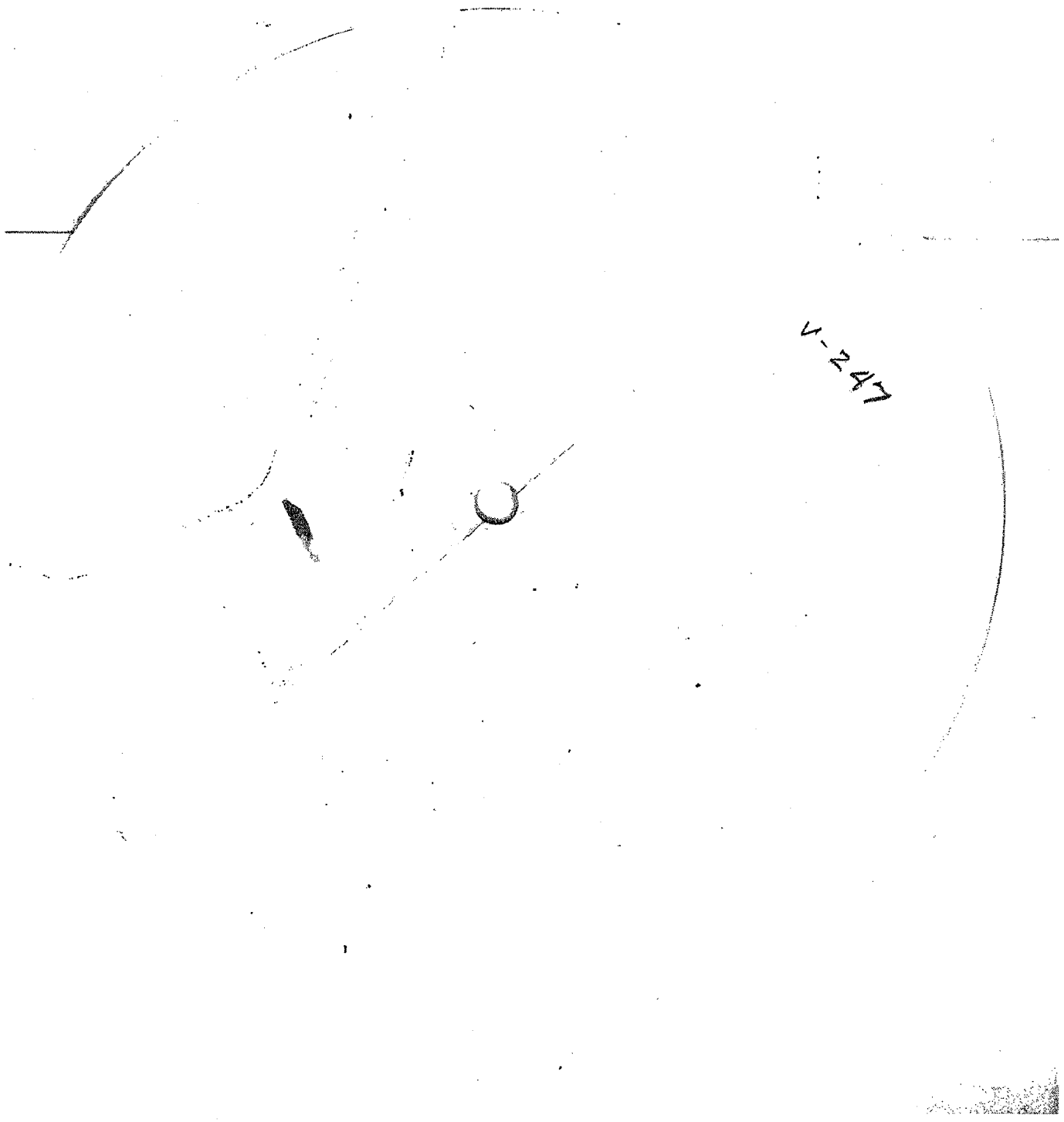
Code	Lot	Net	No. of Packages	Total Net Weight	Whse. Loc.

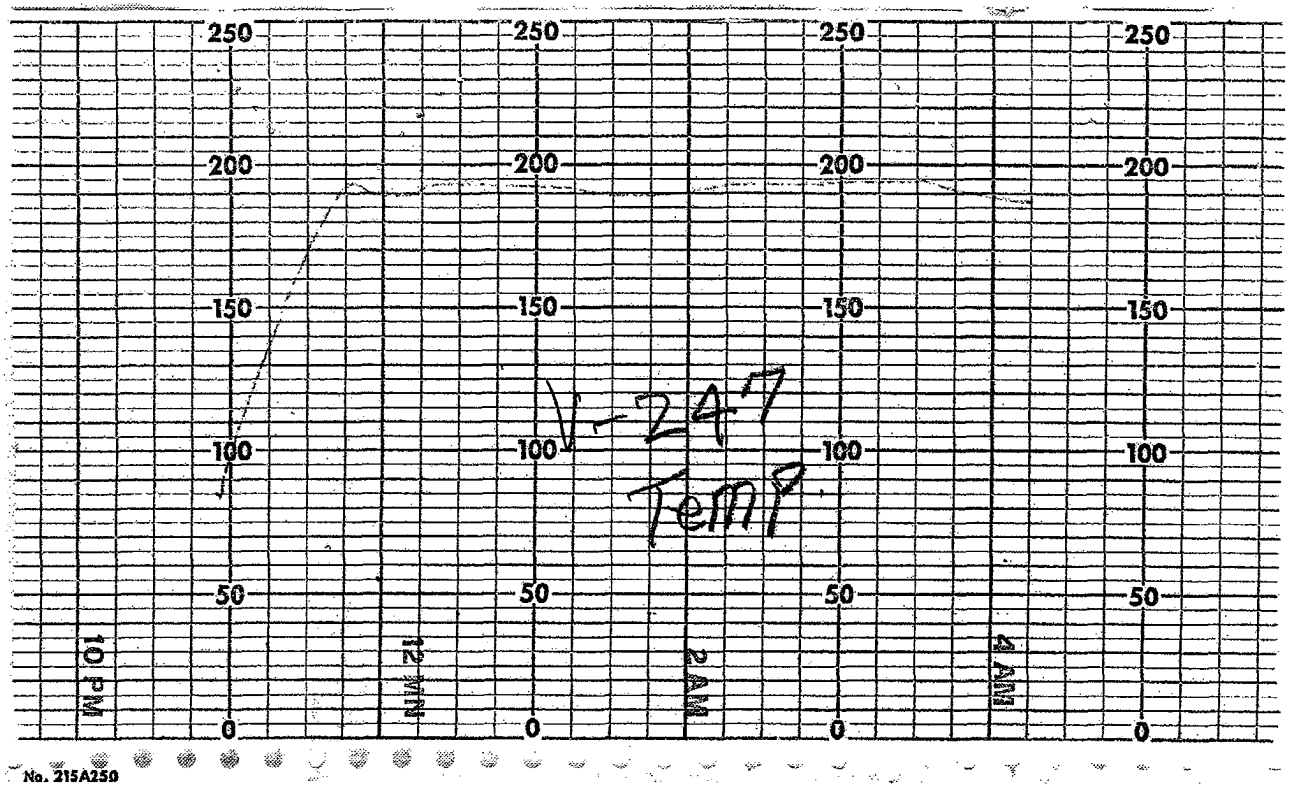
PRODUCTION CONTROL COPY — WHITE
OPERATING FILE COPY — YELLOW
WAREHOUSE FILE COPY — GREEN
RAW MATERIAL FILE COPY — BLUE
PRODUCTION CONTROL FILE COPY — PINK

PLACED IN LOCATION BY: OPER. # _____ DATE _____ SUPVR. _____



DUP050095477


V-247



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