

MAY 12 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 2467247

C.V.

D.V.

CG 04 Code KO-906-D PKG.

EST. WGT 1377 LBS.

STD. HRS TIME 7 P M

01 YC-10-B 98 4 30916 500#
 01 YC-10-B 98 4 33056 850#
 01 YC-10-B 93 4 33463 150#

TOTAL WEIGHT 5077# (Req.)

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

OK
HP

01 X#6923 98 35351 2200#
 Homog# ->

NON-BLEEDING

EQUIPMENT	NAME: 60" (9906) KROLO® ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211 & 208	1 Run 31" (505 G) water in V-211 and add Assume 50%	26	7-D	13
1	2 Weigh in drum and pour in	245	32-D	245
	3 Dump in and stir 5 min	74 x 50	YC-10-B	3700
	Record: Start 3:30 pm	35463		
	Finish 5:30 AM	33656		
	80" (13606) 75" (12756)	30916		
	4 Adjust to 64" (1082 G)	35381		
	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 4 " & adjust to 45" (1662 G)			
	8 Inspect Homog strainer and clean if necessary			
	9 DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED.			
208 & SV	9 Run 15" (793 G) water into V-208 & start agitator			
2	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
	11 Record: Time Start 5:00 PM Total Min 120			
	Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	12 When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384	13 While Homog, run 5" (237 G) water into V-349			
3	14 Run 1000# water into V-384 and heat to 110-120°F			
	15 Weigh into V-384 and pump to V-349	2165	32-D	2165
	16 Run 1000# water into V-384 and pump to V-349			
	17 Adjust V-349 to 20" (946 G) and stir 15 min or longer			
	18 Record: 1.081 (10.9 ± 0.2) (1.081-1.081)			
SV	19 When S12 Homog complete, adj to 59" (3033 G) in SV			
4	20 Record: pH 10.75 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			
	21 Heat to 190-194°F in 55-65 min & Record: HT 186, Rec 193 OF			
	Note: Strike must be started immediately on completion of heating			
343 & 386	22 While heating SV, run 46" (1265 G) water into V-343			
5	23 Meter in from V-386 M 23, 10.50 #/Gal, 30.5 Gal		27-D	320
	24 Stir 15 min or longer			
	25 Record: 1.019 (12.9 ± 0.7) (1.018-1.019)			

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EQUIPMENT	PAGE 2	CG 04	CODE KO-906-D (C)	EST. WGT.	5077	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	26	When S20 heating complete, Record: pH 10.1 (9.6-10.2)							
6	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 10:45 2:45 PM 240							
		V-349 10:45 PM 1:45 AM 180							
		Record: Time	V-343	V-349	SV pH	Normal pH			
		10:45	Inches	Inches					
		at 20 min 11:05	(43) 43	(18) 18	9.9	9.3-10.0			
		40 min 11:25	(39) 39	(16) 16	9.9	9.3-10.0			
		1 hr 11:45	(35) 35	(13) 13	9.9	9.3-10.0			
		2 hrs 12:45	(22) 22	(7) 7	9.9	9.3-10.0			
		3 hrs 1:45	(10) 10	(0) 0	9.7	9.3-10.0			
		Finish 2:30	(0) 0		8.1	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
356	32	Run 19" (137 G) water into V-356 & heat to 135-140°F					270	15-A	270
7	33	Dump in & stir to dissolve for S61							
302	34	Run 24" (294 G) water into V-302							
8	35	Add & stir 2 min for S64					136	7-D	68
		Assume 50%							
PT	36	During strike pump into PT					464	169-A	464
9	37	Pump in					52	155-A	52
	38	Pump in					52	160-A	52
	39	Stir 10 min with lightning mixer for S43							
		15"							
356	40	During strike, run 22" (268 G) water into V-356							
10	41	Turn on steam							
	42	Adj to 363" (366 G) at 178-182°F 81-82°C							
	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 81-82°C							
	46	Stir 30 min at 178-182°F for S55							
	47	Do not shutoff agitator							
SV	48	When V-349 MTY, rinse in with minimum water then set pump to zero setting							
11	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							

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SV	✓	57	When Homog complete, rinse in V-356 with hot water								
11			From hot water mixer								
Con T	✓	58	When S57 complete, turn off Homog & stearate pump								
	✓	59	Stir 5 min at 198-200°F								
	✓	60	Shut off steam								
	✓	61	Run in V-357 from S33 and stir 5 min.								
	✓	62	Record: pH <u>3.6</u> (3.3-3.7)								
	✓	63	If necessary, adj pH to 3.3-3.7 (Downward only) and Record: pH							15-A	
	✓	64	Run in N-7-D from S35 in 4-6 min and stir 5 min								
	✓	65	Record: pH <u>4.2</u> (4.0-4.2) and if necessary, adj to pH 4.0-4.2 and Record: pH Assume 78% (Dilute 10 parts water to 1 part N-7-D) Assume 50%							27-D 7 D	
	✓	66	Siphon N-7-D into SV								
			Do not stop agitator								
			START	FIN	OPTR						
			11:45 A.M.	3:1 P.M.	54-120						
			3:00 P	11:00 P	235						
			11: P.m	7: A.m	223-						

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