[redacted]

MAKING INSTRUCTIONS: BATCH UNIT

V. ~~247~~ 245

PUNCHED & CHECKED

D.V.

PROCESSES		APPROVED BY
( ) KO-789-D	(1)	EWK 9-21-76
( )	( )	DCG 9-21-76
( )	( )	MTW 10-2-76
( )	( )	
TYPED BY		
jlc 10-8-76		

04 CODE KO-789-D PKG.

APRIL 28 35526

MAY 1 - 1980

EST. WGT. 1199 LBS.

STD. HRS. 10.8 TIME 7A M

(2)

OK

LP

01 YC-16-B 93 4 33475, 200#
01 YC-16-B 93 4 34374, 400#
01 YC-16-B 93 4 34186, 300#

01 YC-16-B 93 34780 3100
01 YC-16-B 98 72335 40

Homog #2 Leaking
" #4 Second Pass

APR 29 1980

Total Weight ~~5199~~ 5237 # (Req. _____)

NON-BLEEDING

PMENT		NAME: "KROLOR" ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
	1	Run ~~30" (560 G)~~ 6" (440 G) water into V-211- RUN AGITATOR ON HIGH SPEED			
	2	Weigh in drum and pour in	530	32-D	530
208	3	Pump in and stir 5 minutes LOT	80 x 50	YC-16-B	4000
		Record: Start	1 x 40	YC-16-B	40
		Fin 4.30PM			
		~~Adj to 70" (1200 G)~~ 75" (1275 G) 2800-3200			
		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 " and adjust to 60" (2100 G)			
		Inspect homog strainer and clean if necessary			
		DURING HOMOG RUN V-211 AGITATOR ON LOW SPEED			
208		Run 10" (514 G) water into V-245 and start agitator and install temperature chart			
SV 2	10	Pump V-208 thru Homog at 4800-5200 psi into SV- 245			
		Record: Time Start 11:10 Total Minutes 210			
		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			
		CLEAN HOMOG #4	30	3	30
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	3085	32-D	3085
	15	Run ±1000# water into V-384 and pump to V-349			
	16	Adj V-349 to 21" (1000 G) and stir 15 minutes or longer			
	17	Record: °Be 1.108 ~~(14.3 ±0.2)~~ (1.106-1.108) 8/mi			
SV 4	18	When S 10 Homog complete, adjust SV to 66" (3392 G)			
	19	Record: pH 10.6 and adjust to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% Siphon N-7-D into SV and Record: pH 11.2	16	7-D	8
	20	Heat to 190-194°F in 55-65 minutes and Record: HT 187 F and Rec 194 F			
		Note: Strike must be started immediately on completion of heating			
343 & 386	21	While heating SV, run 54" (1485 G) water into V-343			
	22	Meter in from V-386 M30-9.50#/Gal Gal 48.4		27-D	460
	23	Stir 15 minutes or longer			
	24	Record: Be 1.02 ~~(14.1-10.1)~~ (1.021-1.023) 8/mi			

V-245

MENT		PAGE 2 CG 04 CODE KO-789-D (I) EST. WGT. 5199 LBS.	USE LBS.	N CODE.	ACCT LBS.
SV	25	When S 20 heating complete, Record: pH 10.15 (9.6-10.2)			
	26	Set V-343 acid pump at 76 setting (±225 minutes)			
	27	Set V-349 silicate pump at 60 setting (±180 minutes)			
	28	Immediately meter in V-343 and V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start Finish Minutes V-343 4:15 8:05 230 V-349 4:15 8:20 12			

Record:

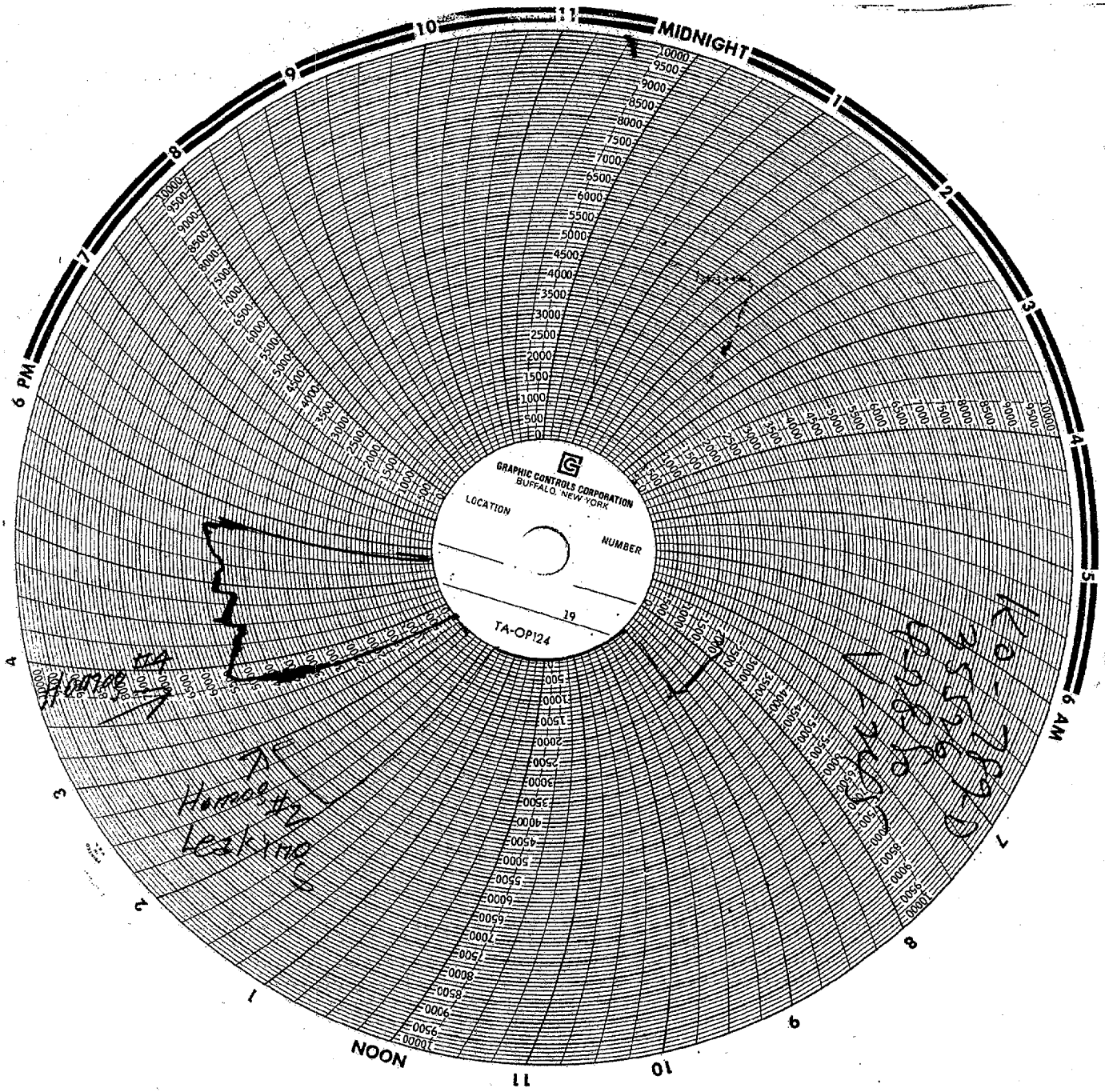
TIME	V-343 INCHES	V-349 INCHES	SV pH	NORMAL pH
4:15	56	21		
at 20 min 4:35	(50) +	(19)	9.9	9.3-10.0
40 min 4:55	(45) +	(16) +	9.8	9.3-10.0
1 hr 5:15	(40) +1	(14) 15 −	9.6	9.3-10.0
2 hrs 6:15	(26) 27 −	(7) 8 −	9.2	9.3-10.0
3 hrs 7:15	(14) 12	(0) 2	9.3 8.0	9.3-10.0
Finish 8:00	(0)			7.5- 8.5

Wt. N-27-D pump Calibrated after Batch (10)

Set N-27 BACK TO 70

		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 9.6 Assume 77%		27-D	
356	30	Run 33" (238 G) water into V-357 and heat to 135-140°F			
	31	Dump in and stir to dissolve	530	15-A	530
02	32	Add 42" (514 G) water to V-302			
8	33	Add and stir 2 minutes Assume 50%	330	7-D	165
V	34	When V-340 MTY, rinse in with minimum water then set pump at zero setting			
	35	When V-340 MTY, rinse in with minimum water then turn off pump motor			
UP905	36	Stir 60 minutes at 190-194°F then turn off steam Record: Start 8:05 A			
	37	Run in V-357 from S 31 and stir 5 minutes			
	38	Record: pH 3.1 (3.4-3.8) and if necessary, adjust (down only) to 3.4-3.8 and Record: pH		15-A	
		Note: Dissolve extra N-15-A in water at 135-140°F in drum, use 130 Gal water to 50# N-15-A. Stir SV 5 minutes after each addition			
	39	Run in N-7-D from S 33 in 10-12 minutes and stir 5 minutes			
	40	Record: pH 6.25 (6.2-6.4) and if necessary, adjust to pH 6.2-6.4 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			
	41	Pour in and stir 15 minutes	50	078-A	5(
	42	Stop agitator			

START	FIN	OPTR
11:00P	7:00A	235 - 37
7:00 Am	10:00 Am	342 + 20



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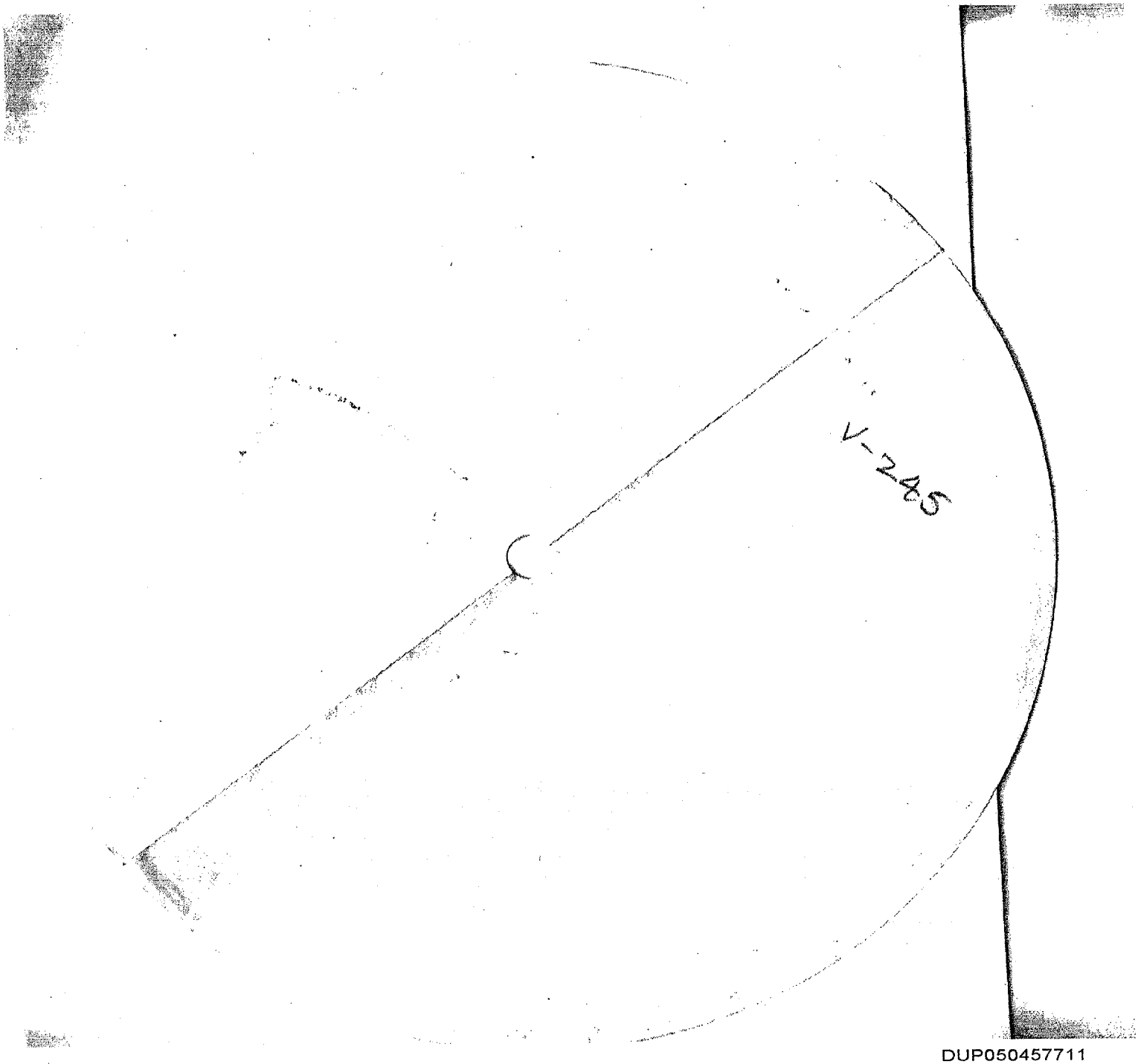

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