

262, 247

C.V.

MAKING INSTRUCTIONS: BATCH UNIT

D.V.

03 CODE KY-907-D PKG.

JUNE 10 36083 PUNCHED &amp; CHECKED

1. WGT. 2737 LBS.

TD. HRS. TIME

4 YC-2-B 93 4 Lot 24786, 5600#

4 YC-2-B 93 4 Lot 24464, 50#

YC-2-B 93 4 Lot , #

| PROCESSES     |     | APPROVED BY  |
|---------------|-----|--------------|
| ( ) KY-907-D  | (F) | EWK 12-12-77 |
| ( ) Alternate | ( ) | DCG 12-14-77 |
| ( )           | ( ) | MTW 12-15-77 |
| ( )           | ( ) | FWP 02-13-79 |
| TYPED BY      |     |              |
| enw021479     |     |              |

Homog #4. 1st Pass

Total Wgt 8387# (Req )

NON-BLEEDING

| ENT | NAME: KROLOR® YELLOW MEDIUM                                                                                 | USE LBS.     | N CODE | ACCT LBS. |
|-----|-------------------------------------------------------------------------------------------------------------|--------------|--------|-----------|
| 203 | Run 50" (827 G) water into V-203. RUN AGITATOR ON HIGH SPEED.                                               | 790          | 32-D   | 790       |
| &   | Weigh in drum & pour in                                                                                     |              |        |           |
| 205 | Dump in & stir 5 min                                                                                        | Lot 113 x 50 | YC-2-B | 5650      |
| 1   | Record: Start 430 AM                                                                                        | 24786        | 5600   |           |
|     | Fin 630 AM                                                                                                  | 24464        | 50     |           |
|     | 75" (1275 G)                                                                                                |              |        |           |
| 4   | Adj to 80" (1360 G)                                                                                         |              |        |           |
| 5   | Pump V-203 thru Homog at 2400-2600 psi into V-263                                                           |              |        |           |
| 6   | When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water                   |              |        |           |
| 7   | Record: V-205 Vol " & adj to 54" (1900 G)                                                                   |              |        |           |
| 8   | Inspect Homog strainer & clean if necessary                                                                 |              |        |           |
|     | DURING HOMOG RUN V-203 AGITATOR ON LOW SPEED.                                                               |              |        |           |
| SV  | 9 Run " (200 G) water into V-262 & install temp chart & start agitator                                      |              |        |           |
| &   |                                                                                                             |              |        |           |
| 205 | 10 Pump V-205 thru Homog at 4800-5200 psi into SV-262                                                       |              |        |           |
| 2   | Record: Time Start 320 P, Total Min 110                                                                     |              |        |           |
|     | NOTE: If Homog pressure falls below 4800 psi 3-way valve will recirculate slurry to V-205                   |              |        |           |
| 11  | When V-205 MTY, run in 5" (240 G) water & pump thru Homog at 4800-5200 psi. Rinse in using Hot Water        |              |        |           |
| 349 | 12 While Homog, run 6" (284 G) water into V-349                                                             |              |        |           |
| &   | 13 Run ± 1000# water into V-384 & heat to 110-120°F                                                         |              |        |           |
| 384 | 14 Weigh into V-384 & pump to V-349                                                                         | ✓ 2150       | 32-D   | 2150      |
| 3   | 15 Run ± 1000# water into V-384 & heat to 110-120°F                                                         |              |        |           |
|     | 16 Weigh into V-384 & pump to V-349                                                                         | ✓ 2150       | 32-D   | 2150      |
|     | 17 Run ± 1000# water into V-384 & pump to V-349                                                             |              |        |           |
|     | 18 Adj V-349 to 25" (1163 G) & stir 15 min or longer                                                        |              |        |           |
|     | 19 Record: 984, 1.02 (16.7 ± 0.2) (1.026 - 1.101)                                                           |              |        |           |
| SV  | 20 When S 11 Homog complete, adj SV to " (2100 G)                                                           |              |        |           |
| 4   | 21 Record: pH 10.8 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% | B            | 7-D    | 4         |
|     | Siphon into SV & Record: pH 11.1                                                                            |              |        |           |
|     | 22 Heat to 190-194°F in 35-45 min & Record: HT 190 of & Rec 190 of                                          |              |        |           |
|     | NOTE: Strike must be started immediately on completion of heating                                           |              |        |           |
|     | 23 While heating SV, run 56" (1520 G) water into V-343                                                      |              |        |           |
|     | 24 Water in from V-386 M 1.035 #/Gal 596 Gal                                                                |              | 27-D   | 647       |
| SV  | 25 Stir 15 min or longer                                                                                    |              |        |           |
| 5   | 26 Record: 1.031 (4.6 ± 0.1) (1.029 - 1.031)                                                                |              |        |           |
|     | 3/mL                                                                                                        |              |        |           |

To  
UAT  
263

V-263

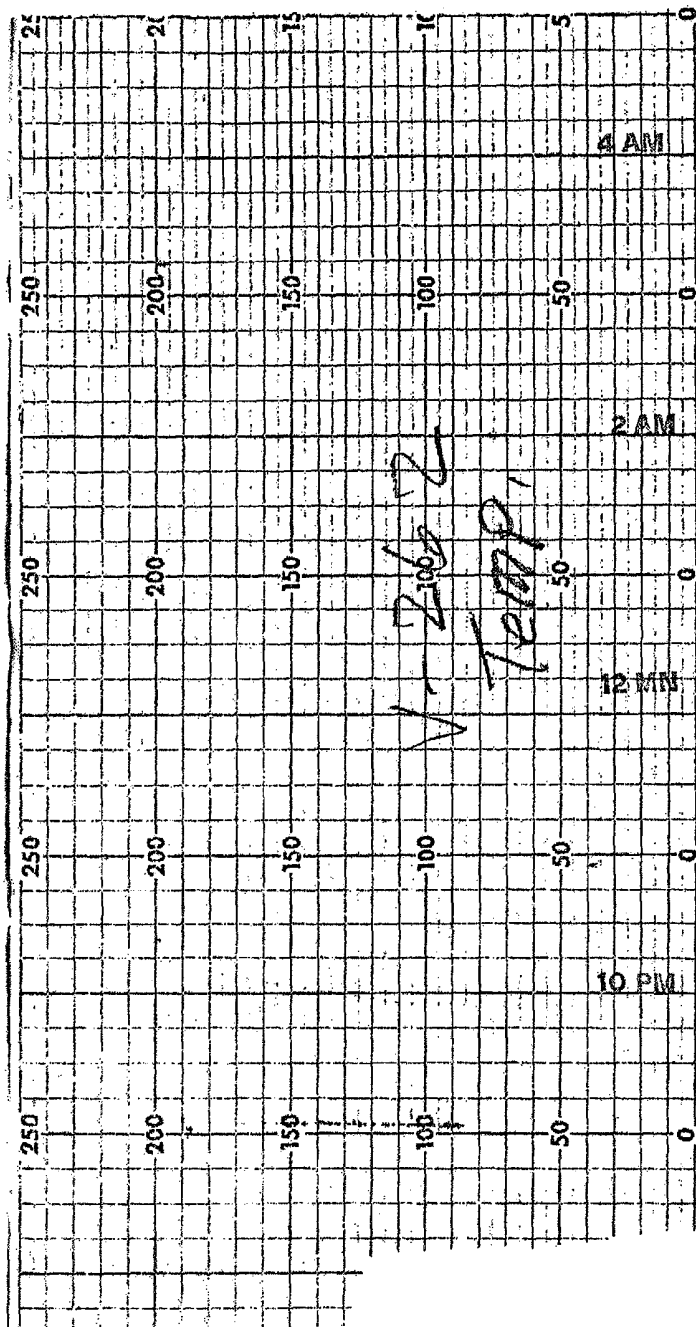
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V-267

| NT | PAGE 2 | CG03                                                                                             | CODE KY-907-D (F) | EST. WGT. | 8387 LBS. | USE LBS.   | N CODE     | ACCT. LBS. |
|----|--------|--------------------------------------------------------------------------------------------------|-------------------|-----------|-----------|------------|------------|------------|
| SV | 27     | When S 22 heating complete, Record: pH 10.0 (9.6-10.2)                                           |                   |           |           |            |            |            |
|    | 28     | Set V-343 acid pump at 69 setting ( $\pm 255$ min)                                               |                   |           |           |            |            |            |
|    | 29     | Set V-349 silicate pump at 60 setting ( $\pm 210$ min)                                           |                   |           |           |            |            |            |
|    | 30     | Immediately meter in V-343 & 349, maintain SV at 190-194°F during strike                         |                   |           |           |            |            |            |
|    | 31     | Record:                                                                                          | Start             | Fin       | Min       |            |            |            |
|    |        | V-343                                                                                            | 9:05 PM           | 11:40 AM  | 2:75      |            |            |            |
|    |        | V-349                                                                                            |                   | 12:40 AM  | 2:15      |            |            |            |
|    |        | Record:                                                                                          | Time              | V-343 in  | V-349 in  | SV pH      | Normal pH  |            |
|    |        | at 20 min                                                                                        | 9:25 PM           | (52)      | (22)      | 9.9        | 9.3-10.0   |            |
|    |        | 40 min                                                                                           | 9:45 PM           | (48)      | (20)      | 9.9        | 9.3-10.0   |            |
|    |        | 1 hr                                                                                             | 10:05 PM          | (43) 47   | (18) 18   | 10.0       | 9.3-10.0   |            |
|    |        | 2 1/2 hrs                                                                                        | 11:20 PM          | (27) 31   | (7) +     | 10.0       | 9.3-10.0   |            |
|    |        | 3 1/2 hrs                                                                                        | 12:35 AM          | (10) 14+  | (0) +     | 10.0       | 9.3-10.0   |            |
|    |        | Finish                                                                                           | 11:40             | (0)       |           | 7.2        | 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 pH to 7.5-8.5 & Record: pH                                      |                   |           |           |            |            |            |
|    |        |                                                                                                  |                   |           |           | Assume 78% |            |            |
|    | 32     | Sift in                                                                                          |                   |           |           | ✓ 300      | 27-D 128-A | 300        |
|    |        | 37"                                                                                              |                   | 385       |           |            |            |            |
|    | 33     | Run 28" (257 G) water into V-343 & heat to 135-140°F                                             |                   |           |           |            |            |            |
|    | 34     | Pump in & stir to dissolve for S 62                                                              |                   |           |           | 400        | 15-A       | 400        |
|    | 35     | Add 24" (294 G) water to V-302                                                                   |                   |           |           |            |            |            |
|    | 36     | Adj & stir 2 min for S 64                                                                        |                   |           |           | Assume 50% | 140 7-D    | 70         |
|    | 37     | During strike pump into PT                                                                       |                   |           |           | 760        | 169-A      | 760        |
|    | 38     | Pump in                                                                                          |                   |           |           | 84         | 155-A      | 84         |
|    | 39     | Pump in                                                                                          |                   |           |           | 84         | 160-A      | 84         |
|    | 40     | Stir 10 min with lightning mixer for S 44                                                        |                   |           |           |            |            |            |
|    | 41     | During strike, run 20" (350 G) water into V-356                                                  |                   |           |           |            |            |            |
|    | 42     | Turn on steam                                                                                    |                   |           |           |            |            |            |
|    | 43     | Adj to 26" (447 G) at 82°C                                                                       |                   |           |           |            |            |            |
|    | 44     | Pump PT mixture from S 40 thru undersurface distributor AFAP                                     |                   |           |           |            |            |            |
|    | 45     | Rinse PT with hot water from hot water mixer & pump in                                           |                   |           |           |            |            |            |
|    | 46     | Shut off pump                                                                                    |                   |           |           |            |            |            |
|    | 47     | Stir 30 min at 82°C for S 56                                                                     |                   |           |           |            |            |            |
|    | 48     | Do not shut off agitator                                                                         |                   |           |           |            |            |            |
|    | 49     | When V-349 MTY, rinse in with minimum water then set pump to zero setting                        |                   |           |           |            |            |            |
|    | 50     | When V-343 MTY, rinse in with minimum water then turn off pump motor                             |                   |           |           |            |            |            |
|    | 51     | Heat to 198-200°F in 5-10 min                                                                    |                   |           |           |            |            |            |
|    | 52     | Close water line & discharge valves at stearate pump                                             |                   |           |           |            |            |            |
|    | 53     | Open V-356 discharge valves to stearate pump inlet                                               |                   |           |           |            |            |            |
|    | 54     | Open water valve at stearate pump & run water thru Homog at 2900-3100 psi to sewer               |                   |           |           |            |            |            |
|    | 55     | While Homog water at 2900-3100 psi, open Homog discharge valve to SV & close valve to sewer      |                   |           |           |            |            |            |
|    | 56     | Immediately open searate pump discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 psi |                   |           |           |            |            |            |
|    |        | Maintain SV at 198-200°F                                                                         |                   |           |           |            |            |            |
|    | 57     | While Homog V-356 to SV, shut off water valve at stearate pump A S A P                           |                   |           |           |            |            |            |

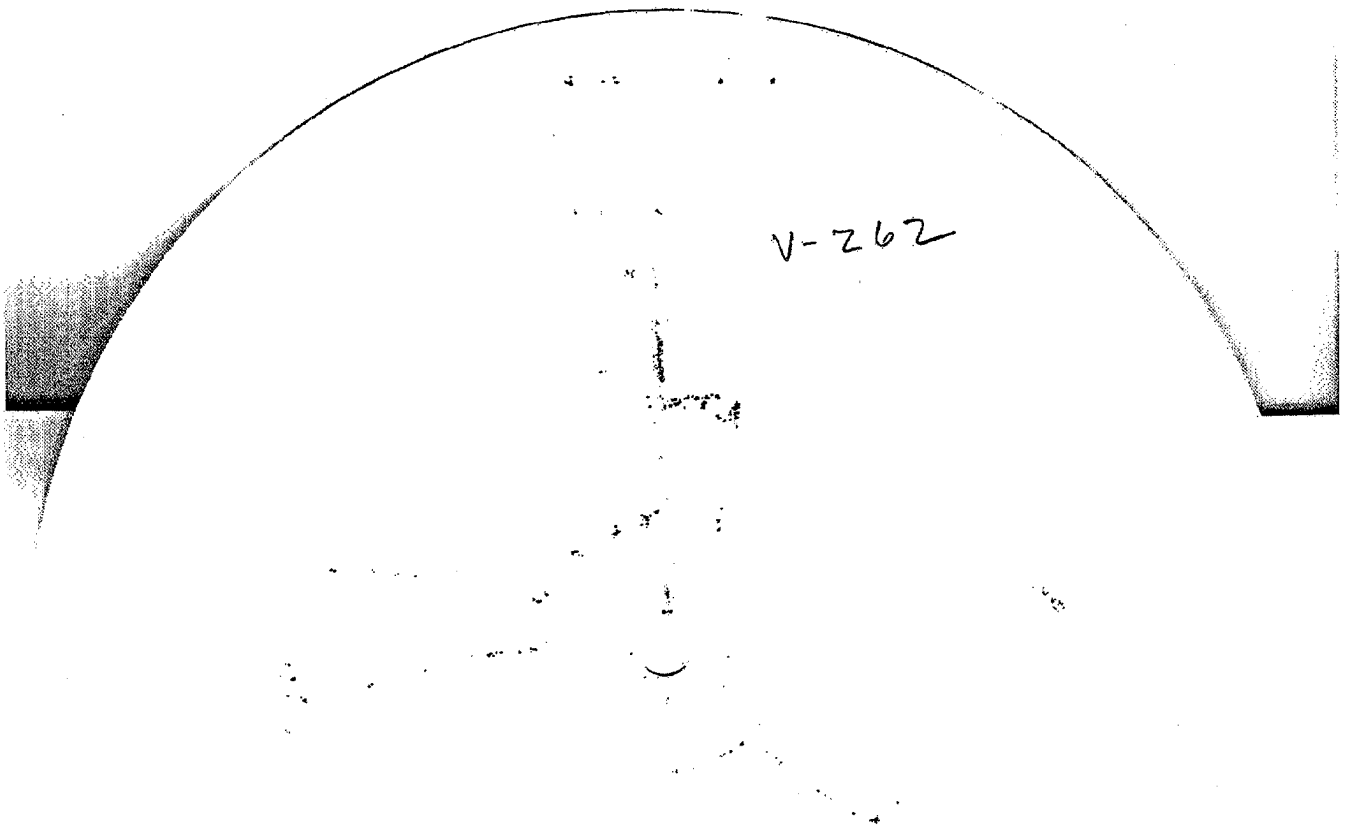
N-262

| PAGE 3 CG 03 CODE KY-907-D (F) EST. WGT. 6053 LBS. |                                                     | USE LBS.   | N CODE  | ACCT. LBS. |
|----------------------------------------------------|-----------------------------------------------------|------------|---------|------------|
| 56                                                 | When Homog complete, rinse in V-356 with hot water  |            |         |            |
|                                                    | From hot water mixer                                |            |         |            |
| 57                                                 | When S58 complete, turn off homog & stearate pump   |            |         |            |
| 58                                                 | Stir 5 min at 198-200°F                             |            |         |            |
| 59                                                 | Shut off steam 335 3/4                              |            |         |            |
| 60                                                 | Run in V-356 from S32 and stir 5 min                |            |         |            |
|                                                    | Record: pH 3.1 (3.3-3.7)                            |            |         |            |
| 61                                                 | If necessary, adj pH to 3.3-3.7 (Downward only) and |            |         |            |
|                                                    | Record: pH                                          |            | 15-A    |            |
| 62                                                 | Run in N-7-D from S32 in 4-6 min and stir 5 min     |            |         |            |
| 63                                                 | Record: pH 3.5 (4.2-4.4) and if necessary, adj to   |            |         |            |
|                                                    | pH 4.2-4.4 & Record: pH 4.2                         | Assume 78% | 27-D    |            |
|                                                    | (Dilute 10 parts water to 1 part N-7-D              | Assume 50% | 30      | 7-D 2.5    |
|                                                    | Siphon N-7-D into SV                                |            |         |            |
| 64                                                 | Do not stop agitator                                |            |         |            |
| START                                              |                                                     | FIN        | OPTR    |            |
| 3:PM                                               |                                                     | 11:PM      | 54-8.59 |            |
| 11:00 P                                            |                                                     | 330/Am     | 235-323 |            |



N32435.01

DUP050461223



**N32435.02**

DUP050461224

