

MAKING INSTRUCTIONS: BATCH UNIT

V. 246, 247

C.V.

D.V.

04 CODE KO-786-D PKG.

APPROX 35143

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 11P M

01 YC-10-B 93 4 33485 500
01 YC-10-B 93 4 34409 500
01 YC-10-B 93 4 34406 1650

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

Total Weight 4962# (Req.)

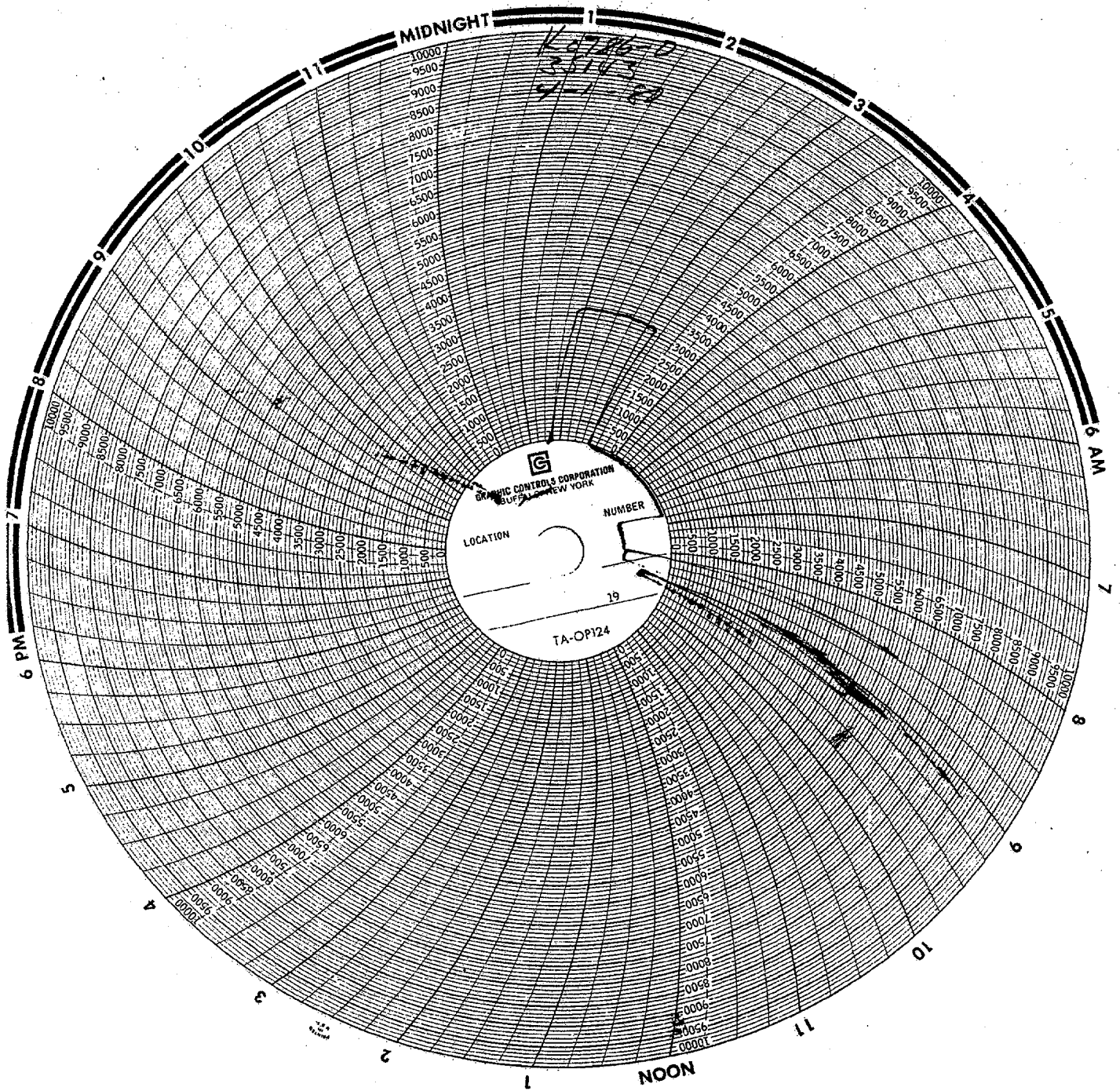
APR 3 1980

NON-BLEEDING

HPMENT	NAME: "KROLOR" ORANGE R	USE	N	ACCT.
		LBS.	CODE	LBS.
211	Run 60" (990 G) water in V-211 and add	30	7-D	15
&	Weigh in drum and pour in V-211	270	32-D	270
208	Dump in and stir 5 minutes	82 x 50	YC-10-B	4100
1	Record: Start 11:45 AM 33485	500		
	Fin 1:30 AM 34409	500		
	75" (275 G) 34406	1650		
	Adjust to 80" (1370 G) 34718	1650		
	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. 449 " and adjust to 50" (1840 G)			
	Inspect homog strainer and clean if necessary			
	DURING HOMOG, RUN AGITATOR ON LOW SPEED			
208	Run 15" (771 G) water into V-247 and start agitator and			
&	Install temperature chart			
SV	Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start 2:05 PM Total Minutes			
	Note: If homog pressure falls below 4800 psi, 3-Way valve will recirculate slurry to V-208			
	When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
9	While Homog, run 6" (284 G) water into V-349			
384	Run 1000# water into V-384 and heat to 110-120°F			
3	Weigh into V-384 and pump to V-349	2400	32-D	2400
	Run 1000# water into V-384 and pump to V-349			
	Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	Record: 1:080 (1000-1000) (1:078-1:081)			
SV	When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	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			
	Heat to 190-194°F in 55-65 minutes & Record: HT F and			
	Rec F			
	Note: Strike must be started immediately on completion of heating			
43	While heating SV, run 51" (1400 G) water into V-343			
&	Meter in from V-386 M 2.10 #Gal 9.307 Gal 38.1	38.1	27-D	355
86	Stir 15 minutes or longer			
5	Record: 1:017 (1000-1000) (1:017-1:019)			

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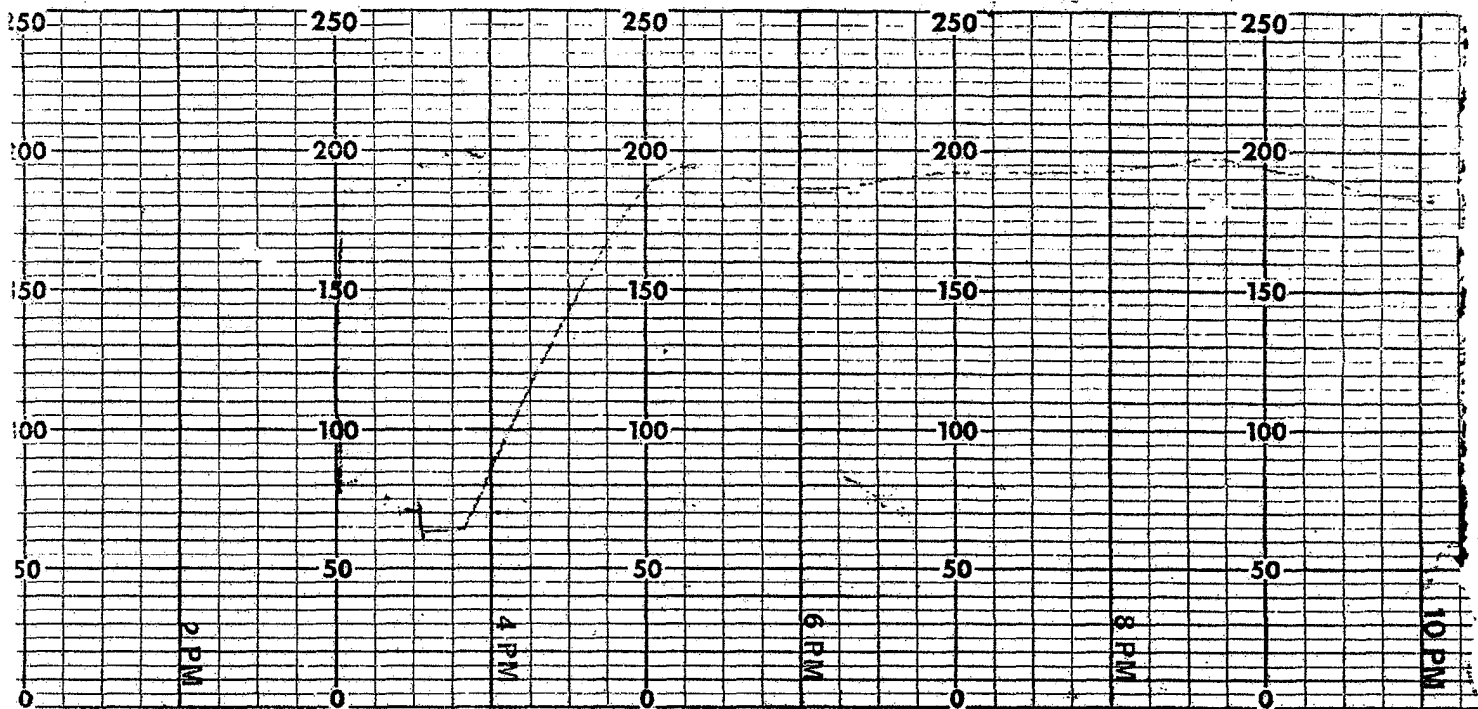
EQUIPMENT	PAGE	CG	CODE	KO-786-D (K)	EST. WGT.	4962	LBS.	USE	N	CODE	ACT.
SV	6										
	25			When S 20 heating complete, Record: pH 10.1 (9.6-10.2)							
	26			Set V-343 acid pump at 72 setting (± 225 minutes)							
	27			Set V-349 silicate pump at 66 setting (± 180 minutes)							
	28			Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike							
	29			Record: Start Finish Minutes							
				V-343 4:55 PM 8:45 PM 200							
				V-349 4:55 PM 8:00 PM 185							
				Record: Time V-343 V-349 SV Normal							
				Inches Inches pH pH							
				at 20 min 5:15 PM (47) 48 (20) 20 9.8 9.3-10.0							
				40 min 5:35 (43) 45 (17) 17 10.0 9.3-10.0							
				1 hr 5:55 (38) 40 (15) 15 10.0 9.3-10.0							
				2 hrs 6:55 (24) 24 (7) 7 10.0 9.3-10.0							
				3 hrs 7:55 (10) 10 (0) 0 10.0 9.3-10.0							
				Finish 8:40 PM (0) 0 9.0 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 7.9 Assume 77%							
								25	27-D	20	
357	7			30 Run 21" (150 G) water into V-357 and heat to 135-140°F							
				31 Pump in and stir to dissolve				300	15-A	300	
302				32 Add 42" (514 G) water to V-302 V-314							
V-314				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 3.4 (3.3-3.7)							
				39 If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH 3.4					15-A		
				40 Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes							
				41 Record: pH 3.7 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH 4.1 Assume 77%					27-D		
				(Dilute 10 parts water to 1 part N-7-D) Assume 50%				20	7-D	10	
				42 Siphon N-7-D into SV							
				42 Stop agitator							
				START FINISH OPTR							
				3:00 PM 10:15 PM 320-D37							



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V-247



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