

PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

246, 24X

245

C.V.

APR 25 1980

D.V.

CG 04 CODE KO-909-D

PKO: 35485

EST. WGT.

1674

LBS.

STD. HRS.

TIME

01 YC-16-B 93 4 Lot 34653, 100 #
 01 YC-16-B 93 4 Lot 33978, 400 #
 01 YC-16-B 93 4 Lot 34779, 550 #

TOTAL WGT 5274# (Req.)

APR 25 1980

NON-BLEEDING

IPMENT	NAME: KROLOD ORANGE Y	USE LBS.	N CODE	ACCT LBS.
211	Run 30" (488 G) water into V-211. RUN AGITATOR ON HIGH SPEED			
208	2 Pour in	480	32-D	480
1	3 Dump in Lot	72 x 50	YC-16-B	3600
	Record: Start:			
	Fin:			
	75" (1225 G)			
	4 Adj to 63" (1065 G) 2800-3200			
	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 45" and adj to 54" (1981 G)			
	8 Inspect homog strainer & clean if necessary			
	9 DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED			
SV	9 Run 10" (514 G) water into V-245. Install Temp chart & start agitator			
2	10 Pump V-208 thru Homog at 4800-5200 psi into SV 245			
	Record: Time Start 1:50 AM Total Min 1:30			
	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	12 While Homog, run 6" (284 G) water into V-349			
384	13 Run 2000# water into V-384 and heat to 110-120°F			
3	14 Weigh into V-384 and pump to V-349	2775	32-D	2775
	15 Run 2000# water into V-384 and pump to V-349			
	16 Adj V-349 to 59" (899 G) and stir 15 min or longer			
	17 Record: Be 1.107 (14.3 ± 0.2) (1.106-1.109)			
SV	18 When S 10" Homog complete, adjust SV to 60" (3084 G)			
4	19 Record: pH 11.1 and adj to 11.1-11.3 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 & Record: pH			
	20 Heat to 190-194°F in 55-65 min and Record: HT 195°F and Rec 195°F			
	NOTE: Strike must be started immediately on completion			

21 Run 10" (514 G) water into V-343
 22 Meter 10°F from V-386 M 30 744 9.50 Galal 43.6
 23 Stir 15 min or longer 1.021 (1.021-1.023)
 24 Record Be 8/mL

27-D 414
 414

V-245

Rel. 10-1-79 Rev. 10-1-79 10-1-79 10-1-79 10-1-79 10-1-79

IPMENT PAGE 2 CG 04 CODE K0-909-D (C) EST. WGT. 5274 LBS. USE LBS. CODE ACCT LBS.

SV 25 When S 20 heating complete, Record: pH 10.2 (9.6-10.2)

6 26 Set V-343 acid pump at 69 setting (± 225 min)

27 Set V-349 silicate pump at 54 setting (± 180 min)

28 Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike

29 Record: Start Finish Minutes

V-343 7:25 AM 11:20 AM 2:45

V-349 7:25 AM 11:20 AM 2:45

Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	7:45 AM	(46) 46	(17) 16	10.0	9.3-10.0
40 min	8:05 AM	(41) 41	(15) 14	10.0	9.3-10.0
1 hr	8:25 AM	(37) 38	(13) 13	10.0	9.3-10.0
2 hrs	9:25 AM	(23) 28	(6) 10	9.9	9.3-10.0
3 hrs	10:25 AM	(10) 13	(0) 1+	9.9	9.3-10.0
Finish	11:10 AM	(0) -	-	6.9	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 & Record: pH Assume 78%

30 Sift in 1 bag 50 27-D 128-A 50

357 31 Run 30" (216 G) water into V-357 & heat to 135-140°F

7 32 Dump in & stir to dissolve for S 61 477 15-A 477

302 33 Add 38" (465 G) water to V-302

8 34 Add & stir 2 min for S 64 Assume 50% 296 7-D 148

PT 35 During strike pump into PT 482 169-A 482

9 36 Pump in 54 155-A 54

37 Pump in 54 160-A 54

38 Stir 10 min with lightning mixer for S 42

356 39 During strike, run 15" (268 G) water into V-356

10 40 Turn on steam

41 Adj to 21" (366 G) at 82-83°C

42 Pump PT mixture from S 38 thru undersurface distributor A F A P

43 Rinse PT with HOT water from hot water mixer & pump in

44 Shut off pump

45 Stir 30 min at 82-83°C for S 55

46 Do not shut off agitator

SV 47 When V-349 MTY, rinse in with minimum water then set pump to zero setting

11 48 When V-343 MTY, rinse in with minimum water then turn off pump motor

49 Stir 60 min at 190-194°F

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

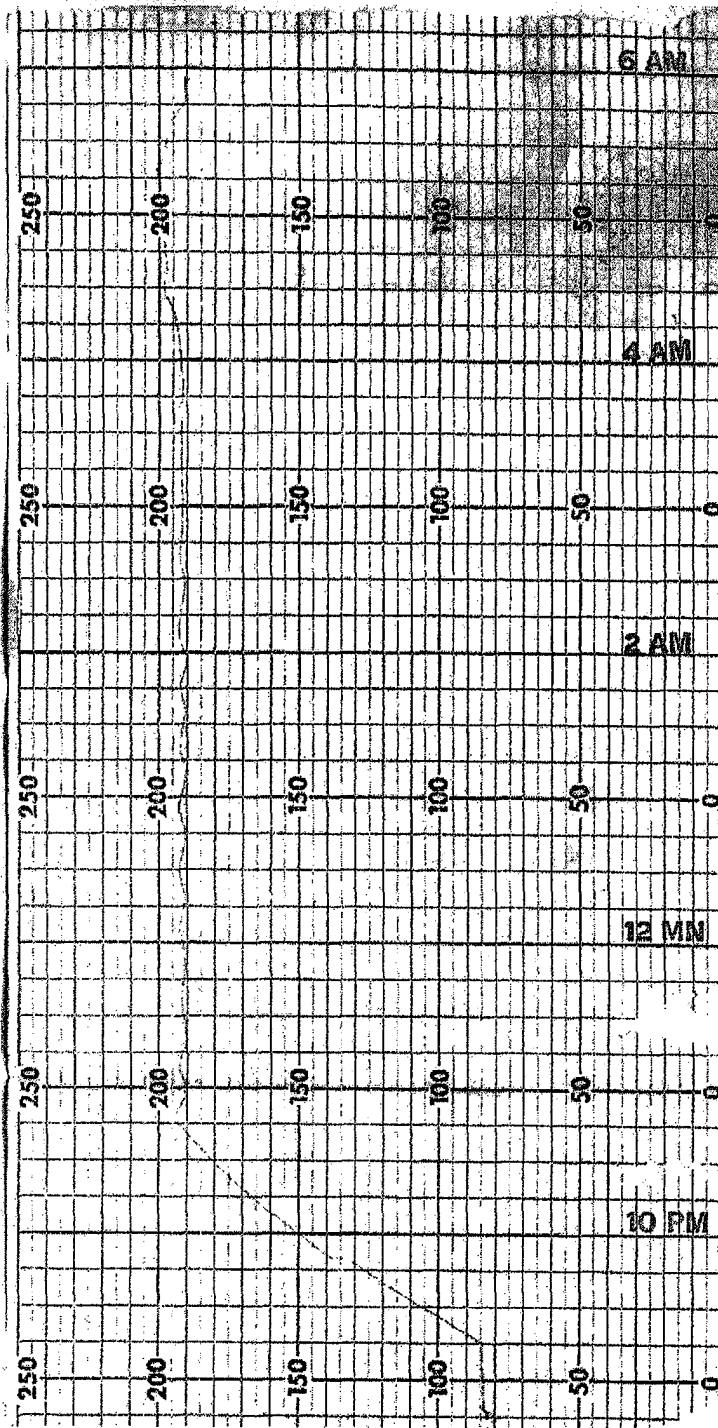
54 While Homog water at 2900-3100 psi, open Homog discharge valve to SV & close valve to sewer

55 Immediately open stearate pump discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 psi. Maintain SV at 198-200°F

56 While Homog V-356 to SV, shut off water valve at stearate pump ASAP

STIR UP AT 123°F

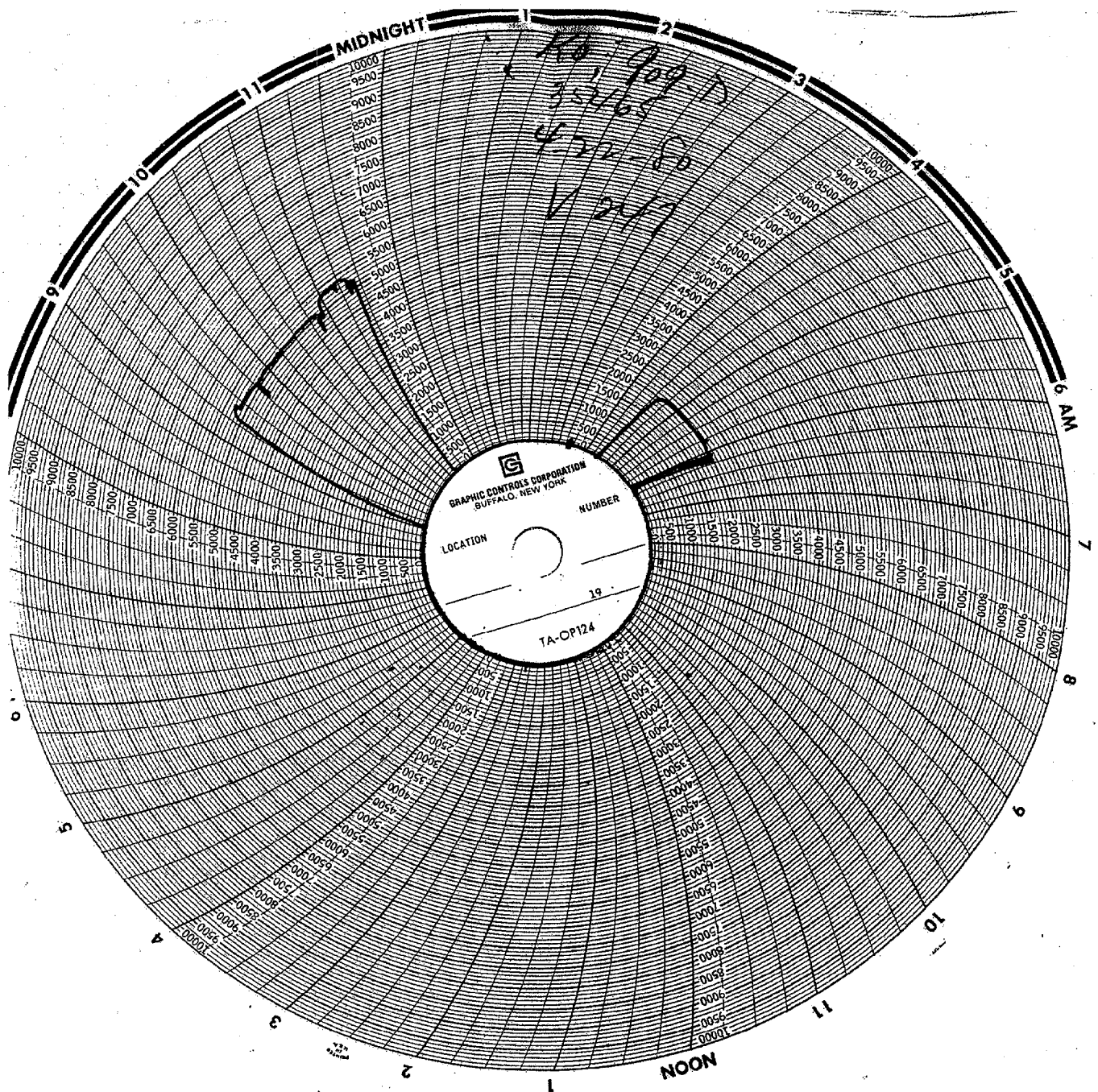
PAGE 3 CG 04 CODE KO-909-D (C) EST. WGT. 5274		LBS.	USE LBS.	N CODE	ACCT LBS.																					
57	When Homog complete, rinse in V-356 with hot water from hot water mixer																									
58	When 557 complete, turn off Homog & stearate pump																									
59	Stir 5 min at 198-200°F																									
60	Shut off steam																									
61	Run in V-357 from S 32 and stir 5 min																									
62	Record: pH 3.1 (3.4-3.8)																									
63	If necessary, adj pH to 3.4-3.8 (Downward only) and Record: pH			15-A																						
64	Run in N-7-D from S 34 in 4-6 min and stir 5 min																									
65	Record: pH 6.3 (6.2-6.4) and if necessary, adj to pH 6.2-6.4 and Record: pH	Assume 78%		27-D																						
	(Dilute 10 parts water to 1 part N-7-D)	Assume 50%		7-D																						
	Siphon N-7-D into SV																									
66	Do Not Stop Agitator																									
<table><tr><th>START</th><th>FIN</th><th>OPTR</th></tr><tr><td>7:00 AM</td><td>3:00 PM</td><td>54-120</td></tr><tr><td>11 PM</td><td>7 AM</td><td>282-381</td></tr><tr><td>4-23-80 7 AM</td><td>3 PM</td><td>120-126</td></tr><tr><td>3:00 PM</td><td>11:00 PM</td><td>235-237</td></tr><tr><td>11:00 PM</td><td>7:00 AM</td><td>381.301</td></tr><tr><td>7:00 AM</td><td>2:30 PM</td><td>126-201</td></tr></table>						START	FIN	OPTR	7:00 AM	3:00 PM	54-120	11 PM	7 AM	282-381	4-23-80 7 AM	3 PM	120-126	3:00 PM	11:00 PM	235-237	11:00 PM	7:00 AM	381.301	7:00 AM	2:30 PM	126-201
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VAT 245 MT AT 1:45 AM																										
DELAYED 45 MINS - POWER HOUSE LOST ① BOILER																										



No. 215A259

N32391.01

DUP050457812



N32391.02

DUP050457813