

APR 8 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. 246 247

C.V.

D.V.

CG 04 CODE KO-786-D

APR 10 35289

PUNCHED & CHECKED

EST. WGT. 862

LBS.

APR 16 1980

STD. HRS. 10.5

TIME

38 M

01 YC-10-B 93 4 34406 300#
 01 YC-10-B 93 4 34719 1700#
 01 YC-10-B 93 4 34415 850#

01 YC-10-B 93 34719 1150#
 01 YC-10-B 98 73241 100#

Total Weight 4962# (Req.)

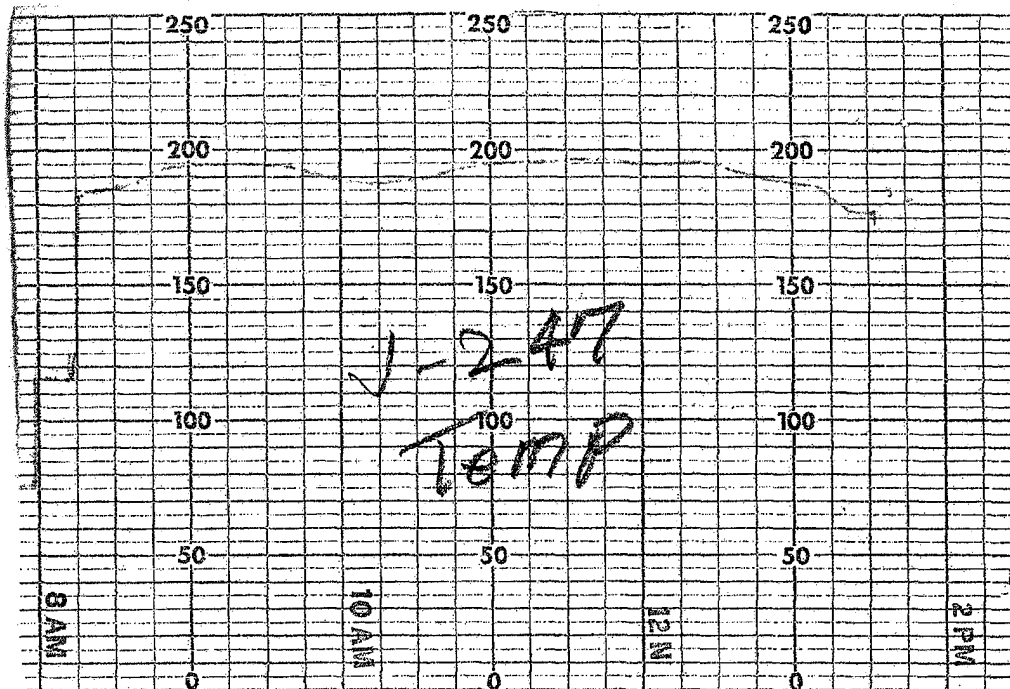
WILL LOOK YELLOW

NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	SET AGITATOR ON HIGH SPEED	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1 Run 60" (990 G) water in V-211 and add	Assume 50%	30	7-D	15
	2 Weigh in drum and pour in V-211		270	32-D	270
	3 Dump in and stir 5 minutes	LOT	82 x 50	YC-10-B	4100
	4 Record: Start 11:45				
	Fin 11:15				
	75" (1275 G)				
	14 Adjust to 80" (1370 G)				
	15 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208				
	16 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water				
	17 Record: V-208 Vol 27" and adjust to 50" (1840 G)				
	18 Inspect homog strainer and clean if necessary				
	DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED.				
208 & SV 2	9 Run 15" (771 G) water into V-208 and start agitator and install temperature chart				
	10 Pump V-208 thru Homog at 4800-5200 psi into SV				
	11 Record: Time Start 10:30 Total Minutes 18				
	Note: If homog pressure falls below 4800 psi, 3-Way valve will recirculate slurry to V-208				
	12 When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi				
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		2400	32-D	2400
	15 Run 1000# water into V-384 and pump to V-349				
	16 Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer				
	17 Record: Sp 1.081 (10.9 ± 0.2) 1.078 - 1.081				
	g/ml				
SV 4	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV				
	19 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				
	20 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				
343 & 386 5	21 While heating SV, run 51" (1400 G) water into V-343				
	22 Meter in from V-386 M 28 #/Gal 38.7 Gal			27-D	355
	23 Stir 15 minutes or longer				
	24 Record: Sp 1.019 (2.8 ± 0.1) 1.017 - 1.019				
	g/ml				

V-247

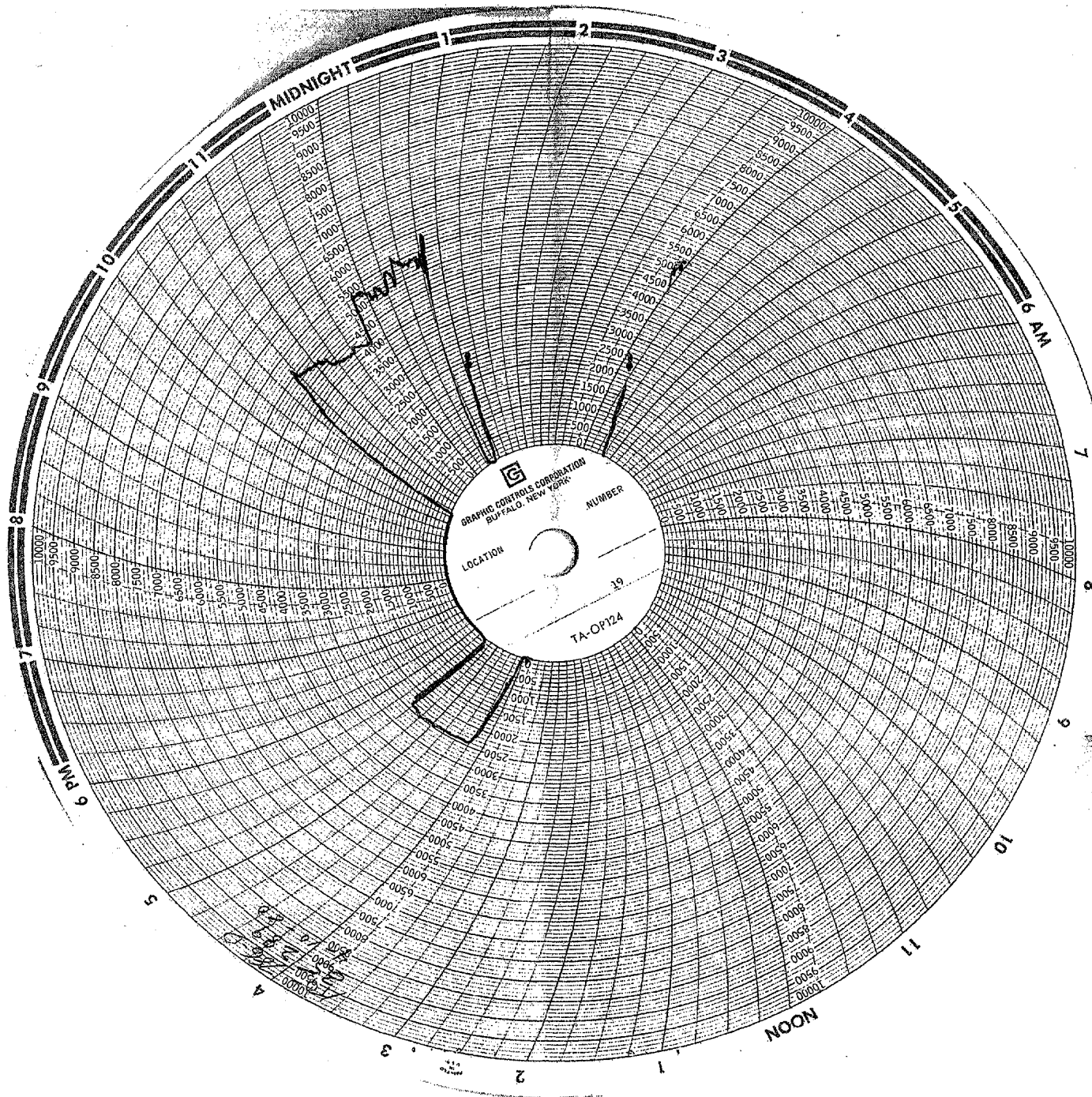
EQUIPMENT	PAGE	2	CG	04	CODE	K0-786-D (4)	EST. WGT.	4962	LBS.	USE	N	ACCT.
										LBS.	CODE	LBS.
SV 6	25	When S 20 heating complete. Record: pH 10.0 (9.6-10.2)										
	26	Set V-343 acid pump at 72 setting (±225 minutes)										
	27	Set V-349 silicate pump at 66 setting (±180 minutes)										
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike										
	29	Record:	Start	Finish	Minutes							
		V-343	4:00	7:55A	235							
		V-349	4:00	7:10A	190							
		Record:	Time	V-343	V-349	SV	Normal					
				Inches	Inches	pH	pH					
		at 20 min	4:20 AM	(47) 47	(20) 20	9.7	9.3-10.0					
		40 min	4:40	(43) 43	(17) 17	9.7	9.3-10.0					
		1 hr	5:00	(38) 38	(15) 15	9.2	9.3-10.0					
		2 hrs	6:00	(24) 24	(7) 7	9.2	9.3-10.0					
		3 hrs	7:00	(10) 12-	(0) -	9.6	9.3-10.0					
		Finish	7:55 AM	(0)		3.5	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 Assume 77%										
											27-D	
357 7	30	Run 21" (150 G) water into V-357 and heat to 135-140°F										
	31	Dump in and stir to dissolve										
								300		15-A		300
302 8	32	Add 42" (514 G) water to V-302										
	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 3.7 (3.3-3.7)										
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH 15-A										
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes										
	41	Record: pH 4.0 (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH Assume 77%										
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%										
		Siphon N-7-D into SV										
	42	Stop agitator										
		START	FINISH	OPTR								
		4:10 P	7:00 AM	126								
		11:00 PM	7:00 AM	237								
		7:00 A	9:10 AM	235-323								



PORATION BUFFALO, NEW YORK

DUP050457921

N32415.01



DUP050457922

N32415.02