

MAR 25 1980 APR - 8 1980

MAKING INSTRUCTIONS: BATCH UNIT

S.V. (246) ~~247~~

C.V.

D.V.

00 04 CODE KO-786-D PKG.

MAR 27 35104

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME 7 A M

01 YC-10-B 93 4 33485.500#
 01 YC-10-B 93 4 34412.1000#
 01 YC-10-B 93 4 34408.1550#

Total Weight 4962# (Req.)

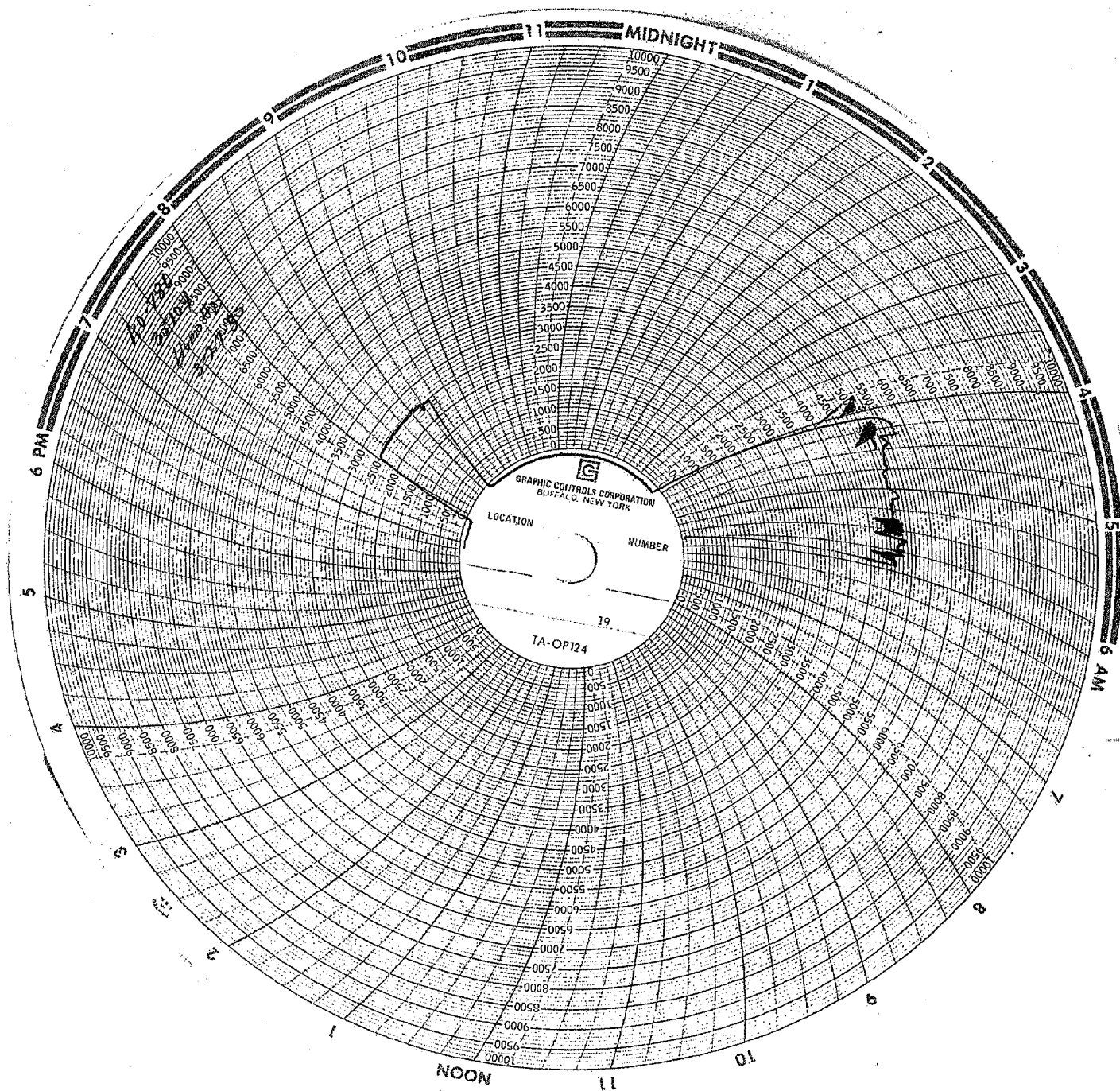
PROCESSES		APPROVED BY	
() KO-786-D	(P)	ENK	9-21-76
()	()	DOG	9-21-76
()	()	MTW	10-1-76
TYPED BY			
JLC 11-16-76			

OIC
KP
01 YC 010B 93 34714 1050#
 01 YC 010B 98 93241 50#
 [MAY LOOK YELLOW] WRT
 NON-BLEEDING

EQUIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	Run 60" (990 G) water in V-211 and add	30	7-D	15
8	Weigh in drum and pour in V-211	270	32-D	170
208	Dump in and stir 5 minutes	83	82 x 50	4100
1	Record: Start 11: A.M. 33485	500		4150
	Fin 12:10 P.M. 34412	1000		
	75" (12786) 34408	1550		
	Adjust to 80" (1370 G) 34714	1050		
	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208 73241	50		
	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	Record: V-208 Vol 54 " and adjust to 50" (1840 G)			
	Inspect homog strainer and clean if necessary			
	During Homog, RUN V-211 AGITATOR ON LOW SPEED			
208 & SV 2	Run 15" (771 G) water into V-208 and start agitator and install temperature chart			
	Pump V-208 thru Homog at 4800-5200 psi into SV 346			
	Record: Time Start 330 Total Minutes 110			
	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			
349 & 384 3	While Homog, run 6" (284 G) water into V-349			
	Run ±1000# water into V-384 and heat to 110-120°F			
	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: 10:00 (10:00-10:20) 1.078-1.081			
SV 4	When S 11 Homog complete, adjust to 66" (3400 G) in SV			
	Record: pH 11.0 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/92 F and Rec 194 F			
	Note: Strike must be started immediately on completion of heating			
343 & 386 5	While heating SV, run 51" (1400 G) water into V-343			
	Meter in from V-386 M 25 #/Gal 7.16 Gal 388		27-D	355
	Stir 15 minutes or longer			
	Record: 10:18 (2:00-2:10) 1.017-1.019			

246

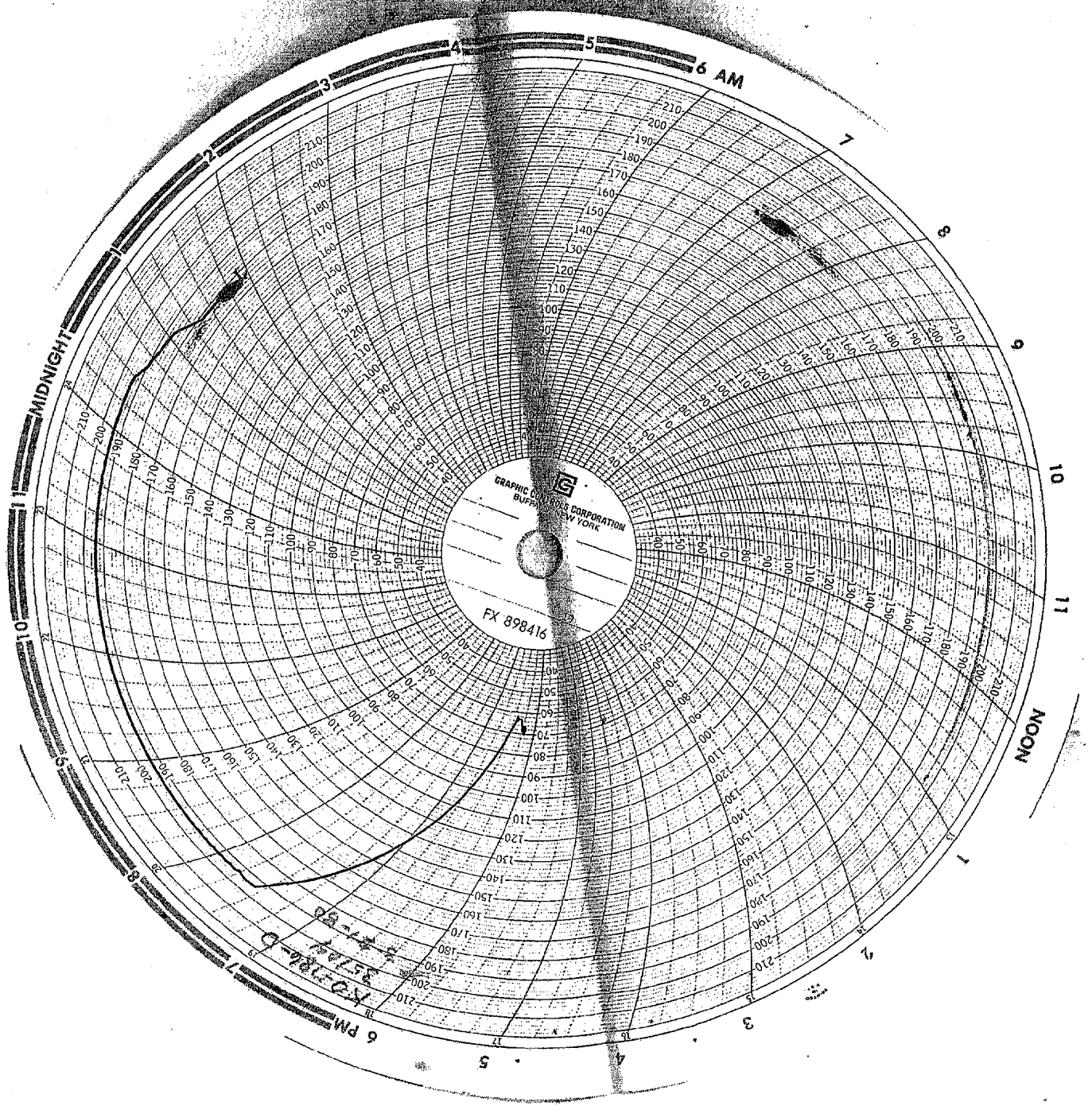
EQUIPMENT	PAGE	2	CG 04	CODE	K0-786-D (B)	EST. WGT.	4962	LBS.	USE LBS.	N CODE	ACCY. LBS.
SV 6	25	When S 20 heating complete. Record: pH <u>9.9</u> (9.6-10.2)									
	26	Set V-343 acid pump at 72 setting (± 25 minutes)									
	27	Set V-349 silicate pump at 66 setting (± 180 minutes)									
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike									
	29	Record:	Start	Finish	Minutes						
		V-343	<u>7:40</u>	<u>12:20 PM</u>	<u>265</u>						
		V-349	<u>7:40</u>	<u>11:05 AM</u>	<u>200</u>						
		Record:	Time	V-343	V-349	SV	Normal				
				Inches	Inches	pH	pH				
		at 20 min	<u>8:05</u>	(47)	(20) 20	<u>9.7</u>	<u>9.3-10.0</u>				
	40 min	<u>8:25</u>	(43) 43	(17) 17	<u>9.7</u>	<u>9.3-10.0</u>					
	1 hr	<u>8:45</u>	(38) 38	(15) 15	<u>9.7</u>	<u>9.3-10.0</u>					
	2 hrs	<u>9:45</u>	(24) 24+	(7) 7+	<u>9.7</u>	<u>9.3-10.0</u>					
	3 hrs	<u>10:45</u>	(10) 10+	(0) 1	<u>9.7</u>	<u>9.3-10.0</u>					
	Finish	<u>11:30</u>	(0)			<u>7.5-8.5</u>					
	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 <u>7.0</u> 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 <u>3.2</u> (3.3-3.7)									
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH <u>3.2</u>									
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes									
	41	Record: pH <u>3.5</u> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH <u>4.2</u> 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							
		<u>7:30 PM</u>	<u>11:00 PM</u>	<u>235-259</u>							
		<u>3:30 AM</u>	<u>7 AM</u>	<u>N38-282</u>							
		<u>7:00 AM</u>	<u>2:00 PM</u>	<u>101</u>							



DUP050457930

N32417.01

240
24



DUP050457932

N32417.02