

246 (247)
 04 CODE KO-789-D PKG.

C.V.

D.V.

~~33974~~ 33974 JAN 23

762 1132 LBS.

SRS. 10.8 TIME 11 PM 7/24 M

01 YC-16-B 93 4 Lot 33752, 900#
 01 YC-16-B 93 4 Lot 32521, 950#
 01 YC-16-B 93 4 Lot 33654, 1250#

3862

Total Weight 5332# (Req 0574)

PROCESSES		APPROVED BY	
() KO-789-D	(I)	EWK 09-21-76	
()	()	DCG 09-21-76	
()	()	MTW 10-02-76	
()	()	FWP 02-05-79	
TYPED BY			
EMW020579			

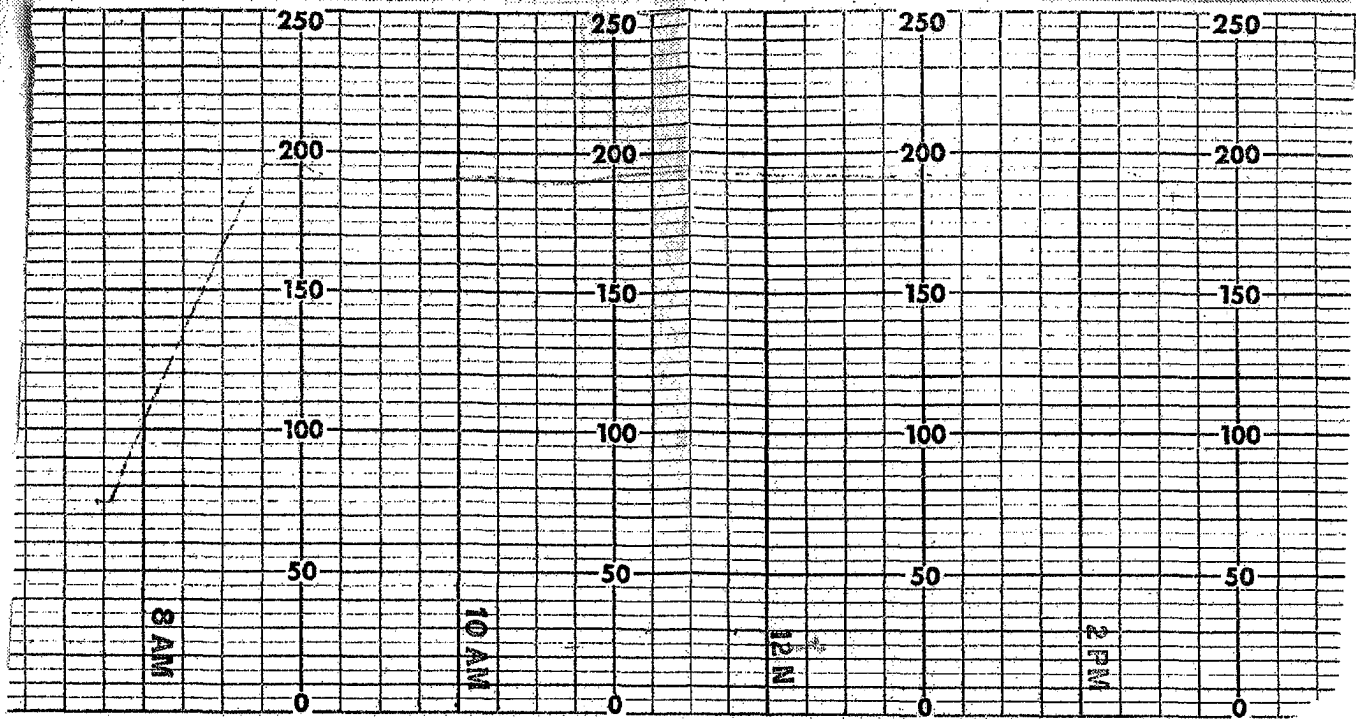
Homog #2

NON-BLEEDING

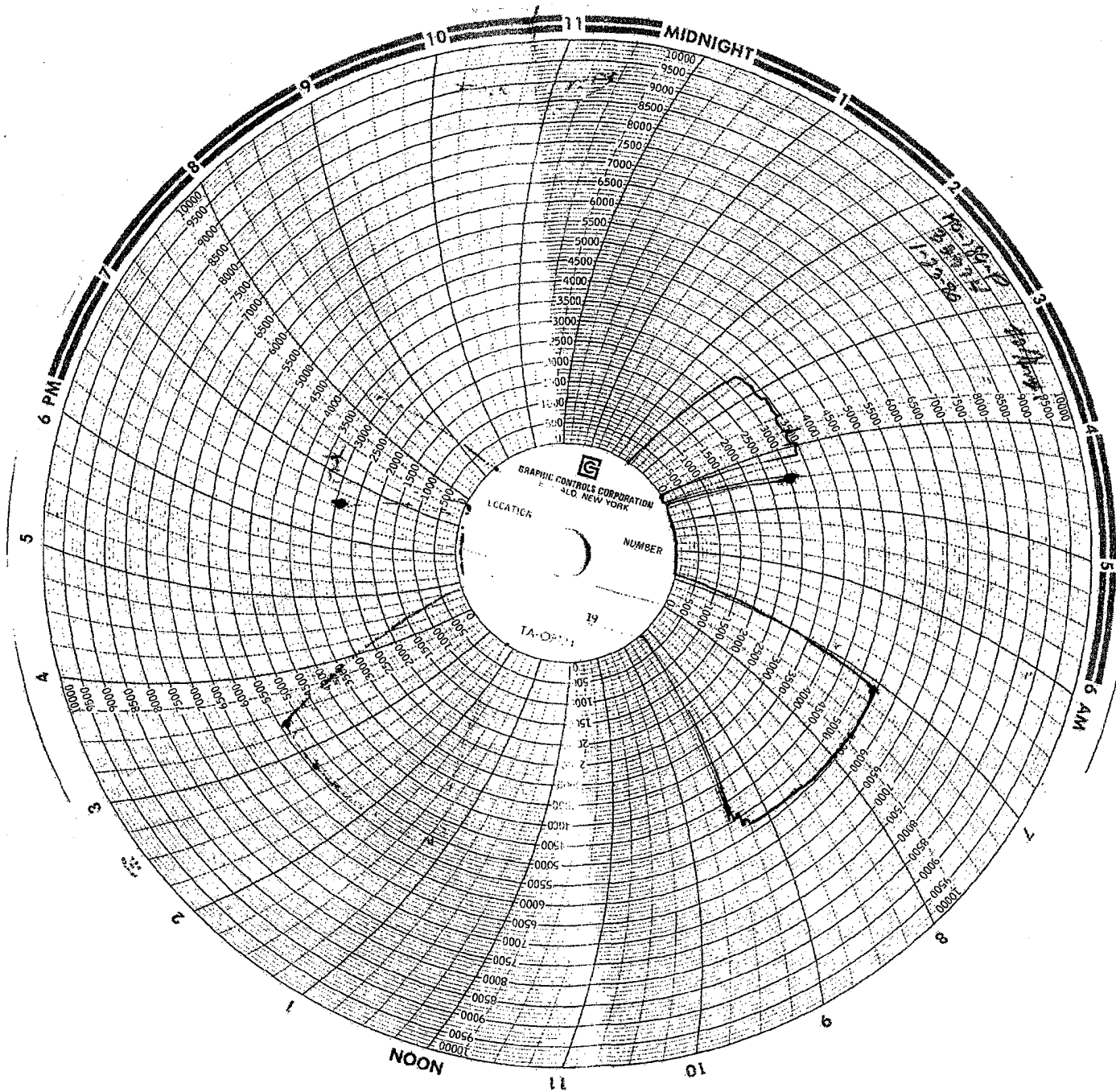
NAME: KROLOR® ORANGE Y		USE LBS.	N CODE	ACCT. LBS.
211	1 Run 60" (990 G) water into V-211			390
&	2 Weigh in drum & pour in	390 530	32-D	530
208	3 Dump in & stir 5 min	Lot 62 84 x 50	YC-16-B	4200
1	Record: Start 12:41 A.M.	53752	900	3100
	Fin 1:15 A.M.	32521	950	
		33654	1250	
	4 Adj to 70" (1200 G) 2800-3200	3100		
	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. Use Hot Water			
	7 Record: V-208 Vol 41" & adj to 54" (1890 G)			
	8 Inspect Homog strainer & clean if necessary			
208	9 Run 10" (514 G) water into V-247 & start agitator & install temperature chart			
&	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
SV	Record: Time Start 7:10 A Total Min 160			
2	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 & 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	2930	32-D	2930
3	15 Run ± 1000# water into V-384 & pump to V-349	1880		1880
	16 Adj V-349 to 30" (1400 G) & stir 15 min or longer 22" (1040 G)			
	17 Record: 98 1.063 ± 0.2 (1.061-1.064)			
SV	18 When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19 Record: pH 10.7 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	22	7-D	11
	Siphon N-7-D into SV & Record: pH 11.1			
20	20 Heat to 190-194°F in 55-65 min & Record: HT 194 OF & Rec 186 OF			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 70" (1920 G) water into V-343			
&	22 Meter in from V-386 M 10, 9.50 #/Gal 30.5		27-D	440
386	23 Stir 15 min or longer			290
51	24 Record: 98 1.013 ± 0.1 (1.013-1.015)			

V-247

LEMENT	PAGE 2	CG 04	CODE K0-789-D (I)	EST. WGT.	5332 LBS.	USE LBS.	N CODE	ACCT LBS.
SV 25	When S 20 heating complete, Record: pH 10.0 (9.6-10.2)							
26	Set V-343 acid pump at 25 setting (± 255 minutes) 65							
27	Set V-349 silicate pump at 25 setting (± 210 minutes) 54							
28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike							
29	Record:	Start	Fin	Min				
	V-343	12:40 PM	5:15 PM	275				
	V-349	12:40 PM	4:25 PM	220				
	Record:	Time	V-343	V-349	SV	Normal		
		12:40	54 in	22 in	pH	pH		
	at 20 min	1:00	(58) 49.50	(27) 20	9.9	9.3-10.0		
	40 min	1:20	(60) 45.40	(24) 18	9.8	9.3-10.0		
	1 hr	1:40	(58) 41.42	(25) 16	9.8	9.3-10.0		
	2 1/4 hrs	2:55	(58) 35.27	(25) 8	9.7	9.3-10.0		
	3 1/2 hrs	4:10	(58) 9.13	(0) 1 1/2	9.4	9.3-10.0		
	Finish	4:55	(0) 2		7.3	7.5- 8.5		
	NOTE: If pH drops below 9.3 in 1st hr, stop pumps & see Supervisor. If final pH is above 8.5, adj to 7.5-8.5 & Record: pH Assume 77%							
							27-D	
30	Run 33" (238 G) water into V-357 & heat to 135-140°F							
31	Dump in & stir to dissolve				370.530		15-A	396
								530
302	32 Add 42" (514 G) water to V-302							
8	33 Add & stir 2 min				Assume 50%	240 330	7-D	166
								100
SV 34	When V-349 MTY, rinse in with minimum water then set pump at zero setting							
9	35 When V-343 MTY, rinse in with minimum water then turn off pump motor							
	36 Stir 30 min at 190-194°F then turn off steam							
	Record: Start 5:15 PM							
	37 Run in V-357 from S 31 & stir 5 min							
	38 Record: pH 3.4 (3.4-3.8) & if necessary, adj (DOWN ONLY) to 3.4-3.8 & Record: pH						15-A	
	NOTE: Dissolve extra N-15-A in water at 135-140°F in drum, use ±30 G water to 50# N-15-A. Stir SV 5 min after each addition							
	39 Run in N-7-D from S 33 in 10-12 min & stir 5 min							
	40 Record: pH 6.3 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH				Assume 77%		27-D	
	(Dilute 10 parts water to 1 part N-7-D)				Assume 50%	30	7-D	15
	Siphon N-7-D into SV							
	41 Pour in & stir 15 min					37.25	978-A	25
	42 Stop agitator							37
	START	FIN	OPTR					
	7:00 PM	3:00 PM	7:55					
	3:00 PM	9:40 PM	409					



CONTROLS CORPORATION BUFFALO, NEW YORK



V-247