S.V. 246 C.V. PUNCHED & CHECKED

CG 04 CODE KO-906-D PKG.

~~[illegible]~~ 34306 MAR. 6

EST. WGT. ~~1377~~ 1327 LBS.

STD. HRS. _____ TIME ~~[illegible]~~ M

MAR 12 1980

PROCESSES		APPROVED BY
( ) KO-906-D	(C)	EWK 1/24/78
( )	( )	DCG 1/26/78
( )	( )	MW 1/26/78
( )	( )	
TYPED BY		
rj 3/2/78		

01	YC-10-B	93	4	34412	850#
01	YC-10-B	93	4	34413	2150#
01	YC-10-B	93	4	34415	700#
01	YC-16-B	98	4	72335	80#

TOTAL WEIGHT ~~5077#~~ 5107 (Req. _____)

11:PM

Homog #2

V-246 'M' T 11:35 PM

NON-BLEEDING

EQUIPMENT		NAME: (990 G) 60" KROLOR® ORANGE R ↓ SET AGITATOR ON HIGH SPEED	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run ~~31" (505 G)~~ water in V-211 and add Assume 50%	26	7-D	13
	2	Weigh in drum and pour in	245	32-D	245
	3	Dump in and stir 5 min Lot	74 x 50	YC-10-B	3700
		Record: Start 4:P.M. 72335	2 x 40	YC-16-B	80
		Finish 5:30 P.M. 34412	850		
		~~75" (1275G) 80 (1360G)~~ 34413	2150		
	4	Adjust to ~~64" (1082 G)~~ 34415	700		
	5	Pump V-211 thru Homog #2 at 1800-2200 psi into V-208	3700		
	6	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7	Record: V-208 Vol 42" & adjust to 45" (1662 G)			
	8	Inspect Homog strainer and clean if necessary			
		DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED			
208 SV 2	9	Run 15" (793 G) water into V-246 & start agitator			
	10	Pump V-208 thru Homog at 4800-5200 psi into SV			
	11	Record: Time Start 11:45P Total Min 135			
		Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	12	When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384 3	13	While Homog, run 5" (237 G) water into V-349			
	14	Run 1000# water into V-384 and heat to 110-120°F			
	15	Weigh into V-384 and pump to V-349	2165	32-D	2165
	16	Run 1000# water into V-384 and pump to V-349			
	17	Adjust V-349 to 20" (946 G) and stir 15 min or longer			
	18	Record: °Be' 1.079 G/mL ~~(10.9 ± 0.2)~~ (1.078-1.081)			
SV 4	19	When S12 Homog complete, adj to 59" (3033 G) in SV			
	20	Record: pH 10.7 & adj 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, stir 5 min & record: pH _____			
	21	Heat to 190-194°F in 55-65 min & Record: HT 187 Rec 194 °F			
		Note: Strike must be started immediately on completion of heating			
343 & 386 5	22	While heating SV, run 46" (1265 G) water into V-343			
	23	Meter in from V-386 M 20 9.19 #/Gal 34.8 Gal		27-D	320
	24	Stir 15 min or longer			
	25	Record: °Be' 1.019 G/mL ~~(2.9 ± 0.1)~~ 1.018-1.019			

13829 REV.

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EQUIPMENT			USE LBS.	N CODE	ACCT. LBS.
SV	26	When S20 heating complete, Record: pH 10.1 (9.6-10.2)			
6	27	Set V-343 acid pump at 65 setting (±225 min)			
	28	Set V-349 Silicate pump at 57 setting (±180 min)			
	29	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	30	Record: Start / Finish / Minutes V-343 4:00 AM / 8:Am / 240 V-349 4:00 AM / 7:50 Am / 185			

Record: Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
4:00	47			
at 20 min 4:20	(43) +	(18)	9.9	9.3-10.0
40 min 4:40	(39) +	(16) +	9.9	9.3-10.0
1 hr 5:00	(35) 36	(13) 14	9.9	9.3-10.0
2 hrs 6:00	(22) 24 -	(7) 8	9.9	9.3-10.0
3 hrs 7:00	(10) 12	(0) 1	9.9	9.3-10.0
Finish 7:45	(0) 0	0	8.3	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 and Record: pH Assume 78%		27-D
	~~31~~	~~Sift in 1 bag~~	~~50~~	~~128-A~~ ~~50~~
357	32	Run ~~19~~ 15" (137 G) water into V-357 & heat to 135-140°F		
7	33	Dump in & stir to dissolve for S61	270	15-A 270
302	34	Run ~~24~~ 15" (294 G) water into V-302		
8	35	Add & stir 2 min for S64 Assume 50%	136	7-D 68
PT	36	During strike pump into PT	464	169-A 464
9	37	Pump in	52	155-A 52
	38	Pump in	52	160-A 52
	39	Stir ~~10~~ 15 min with lightning mixer for S43		
356	40	During strike, run ~~22~~ 15" (268 G) water into V-356		
10	41	Turn on steam		
	42	Adj to ~~30~~ 15" (366 G) at ~~178-182°F~~ 81-82°C		
	43	Pump PT, mixture from S39 thru undersurface Distributor AFAP		
	44	Rinse PT with hot water from hot water mixer & pump in		
	45	Shutoff pump 81-82°C		
	46	Stir 30 min at ~~178-182°F~~ for S55		
	47	Do not shutoff agitator		
SV	48	When V-349 MTY, rinse in with minimum water then set pump to zero setting		
11	49	When V-343 MTY, rinse in with minimum water then turn off pump motor		
	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 2900-3100 psi Maintain SV at 198-200°F		
	56	While Homog V-356 to SV, shutoff water valve at Stearate pump ASAP		

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EQUIPMENT		PAGE 3 CG 04 CODE KO-906-D (C) EST. WGT. 5077 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 11 Con'T'	57	When Homog complete, rinse in V-356 with hot water			
		From hot water mixer			
	58	When 357 complete, turn off Homog & stearate pump			
	59	Stir 5 min at 198-200°F			
	60	Shut off steam			
	61	Run in V-357 from S33 and stir 5 min			
	62	Record: pH 3.7 (3.3-3.7)			
	63	If necessary, adj pH to 3.3-3.7 (Downward only) and			
		Record: pH ✓	✓	15-A	
	64	Run in N-7-D from S35 in 4-6 min and stir 5 min			
	65	Record: pH 4.0 (4.0-4.2) and if necessary, adj to			
		pH 4.0-4.2 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			

START	FIN	OPTR
11:00P	7:00AM	235-323
7AM		223-282

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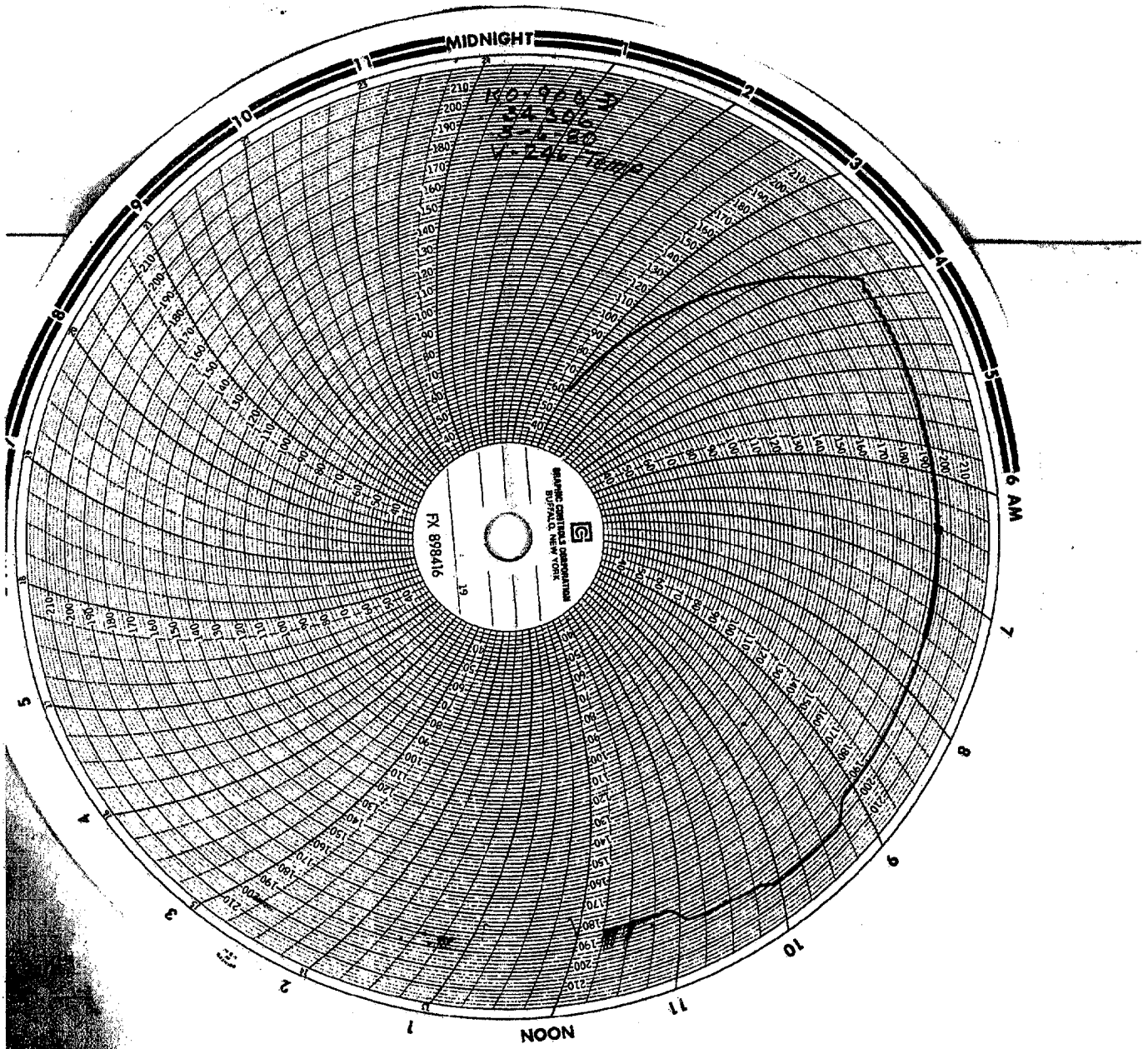

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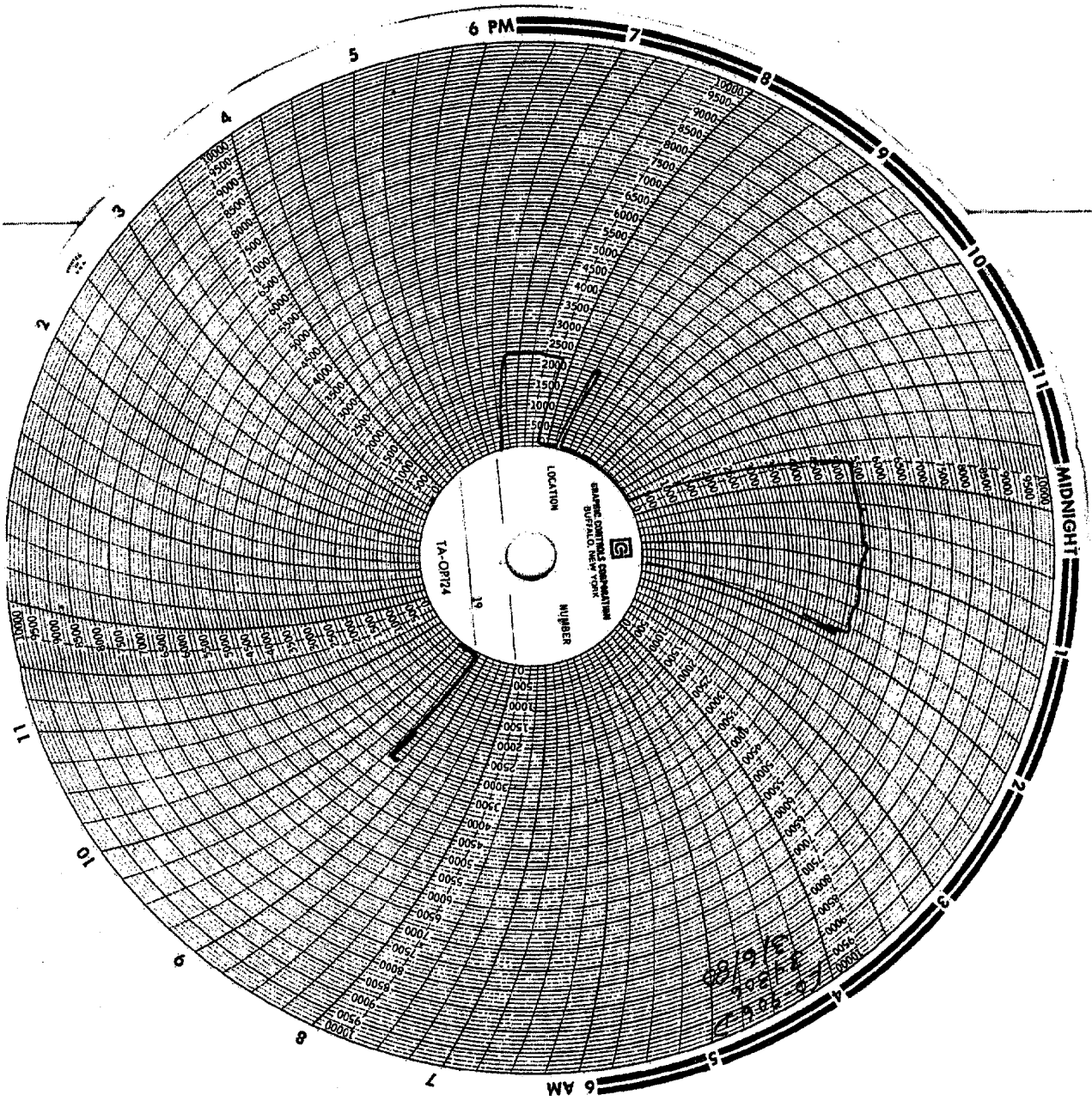

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