

S.V. 247

C.V.

D.V.

CG 04 CODE KO-906-D PKG.

JAF-4 33623

EST. WGT. 1377 LBS.

STD. HRS. TIME 11P M

01 YC-10-B	93	4	33486	500#
01 YC-10-B	93	4	33360	2150#
01 YC-10-B	93	4	33487	1050#

TOTAL WEIGHT 5077# (Req. _____)

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

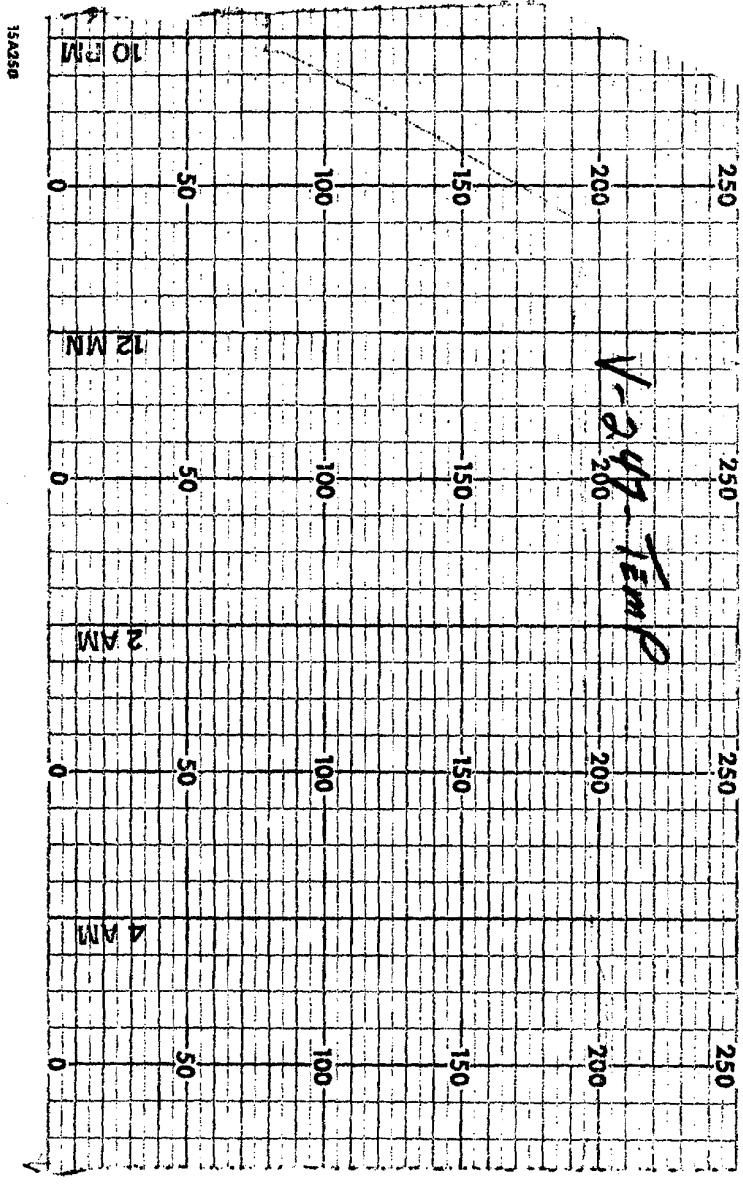
Homog #2 - 1st Pass
 " #2 - 2nd Pass
 " #4 - 2nd Pass
 NON-BLEEDING

EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
211	60" 9903 KROLOR® ORANGE R			
208	1 Run 31" (505 G) water in V-211 and add	Assume 50%	26	7-D 13
1	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 2:30 AM	33486		
	Finish 3:15 AM	33360		
	30" 13608	33487		
25 (10756)	4 Adjust to 64" (1082 G)			
	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 41 " & adjust to 45" (1662 G)			
	8 Inspect Homog strainer and clean if necessary			
208 SV	9 Run 15" (793 G) water into V-208 & start agitator			
2	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
	11 Record: Time Start Total Min			
	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	13 While Homog, run 5" (237 G) water into V-349			
384	14 Run 1000# water into V-384 and heat to 110-120°F			
3	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 1078 (10.9 ± 0.2) (1078-1.081) 9/mk			
SV	19 When S12 Homog complete, adj to 59" (3033 G) in SV			
4	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 192 Rec 192 OF			
	Note: Strike must be started immediately on completion of heating			
343	22 While heating SV, run 46" (1265 G) water into V-343			
386	23 Meter in from V-386 M 1- 9.70#/Gal, 33.0 Gal		27-D	320
5	24 Stir 15 min or longer			
	25 Record: °Be 1017 (2.9 ± 0.1)			

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EQUIPMENT		PAGE 2	CG 04	CODE K0-906-D (C)	EST. WGT. 5077	LBS.	USE LBS.	N CODE	ACCT LBS.
SV 6	26	When S20 heating complete, Record: pH 9.8 (9.6-10.2)							
	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 12: Pm 3: 45 Am 225							
		V-349 12: Pm 3: Am 180							
		Record:	Time	V-343	V-349	SV pH	Normal pH		
				Inches	Inches				
		at 20 min	12:20A	(43) 43	(18) 18	9.6	9.3-10.0		
		40 min	12:40A	(39) 39	(16) 16	9.6	9.3-10.0		
		1 hr	1: Am	(35) 35	(13) 13	9.6	9.3-10.0		
		2 hrs	2: Am	(22) 22	(7) 7	9.6	9.3-10.0		
		3 hrs	3: Am	(10) 10	(0) 0	9.5	9.3-10.0		
		Finish	3: 45 Am	(0) 0	0 0	8.1	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" (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" (294 G) water into V-302							
8	35	Add & stir 2 min for S64					Assume 50%	136	7-D 68
PT 9	36	During strike pump into PT					464	169-A	464
	37	Pump in					52	155-A	52
	38	Pump in					52	160-A	52
	39	Stir 10 min with lightning mixer for S43							
356 10	40	During strike, run 15" (268 G) water into V-356							
	41	Turn on steam							
	42	Add to 30" (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 11	48	When V-349 MTY, rinse in with minimum water then set pump to zero setting							
	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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SV	57				When Homog complete, rinse in V-356 with hot water						
11					From hot water mixer						
Con'T'	58				When 857 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 <u>3.3</u> (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 <u>4.2</u> (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			
					<u>11:00 A</u>	<u>3:00 P</u>		<u>120-126</u>			
					<u>3:00 P</u>	<u>11:00 P</u>		<u>235 - 323</u>			
					<u>11: Pm</u>			<u>223 - 282</u>			



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