

246 247

PUNCHED & CHECKED

D.V.

CO 04 CODE KO-909-D

PKO

MAY -1

35595 MAY - 7 1980

EST. WGT. 1596 1674 LBS.

STD. HRS.

TIME

M

01 YC-16-B 93 4 Lot 34574 600#

01 YC-16-B 93 4 Lot 34654 1900#

01 YC-16-B 93 4 Lot 34751 1200#

PROCESSES		APPROVED	
() KO-909-D	(C)	1-28-77	2-27-77
()	()	DCG 1-30-77	
()	()	MMW 2-27-77	
()	()		
TYPED BY			
NSA 3-13-78			

Homog #2

5296 TOTAL WGT 5274# (Req.)

NON-BLEEDING

IPMENT	NAME	KROLOD ORANGE Y	USE LBS.	N CODE	ACC LBS
211	1	Run 36" (488 G) water into V-211. RUN AGITATOR ON HIGH SPEED.			
208	2	Pour in	480	32-D	480
1	3	Dump in Lot 74 28 x 50 YC-16-B 3600			
		Record: Start: 34574 600#			3700
		Fin: 34654 1500#			
		.75" (1275 G) 34751 1200#			
	4	Adj to 69" (1065 G) 2800-3200			
	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 42 and adj to 54" (1981 G)			
	8	Inspect homog strainer & clean if necessary			
	9	DURING HOMOG RUN AGITATOR ON LOW SPEED			
SV	10	Run 10" (514 G) water into V-208. Install Temp chart & start agitator			
2	10	Pump V-208 thru Homog at 4800-5200 psi into SV			
		Record: Time Start 7:00A Total Min 180			
		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 and pump thru Homog at 4800-5200 psi			
349	12	While Homog, run 6" (284 G) water into V-349			
8	13	Run 1000# water into V-384 and heat to 110-120°F	2500		2500
384	14	Weigh into V-384 and pump to V-349	2775	32-D	2775
3	15	Run 1000# water into V-384 and pump to V-349			
	16	Adj V-349 to 19" (899 G) and stir 15 min or longer			
	17	Record: Be 1.0944 (3.4 ± 0.2) (1.091-1.094)			
SV	18	When S 10 Homog complete, adjust SV to 60" (3084 G)			
4	19	Record: pH 10.8 and adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	10	7-11	5
		Siphon N-7-D into SV & Record: pH 11.1			
	20	Heat to 190-194°F in 55-65 min and Record: HT 187°F and Rec 187°F			
		NOTE: Strike must be started immediately on completion of heating			
43	21	While heating SV, run 49" (1348 G) water into V-343	33.6	27-D	373
1	22	Water in from V-386 M 31-11.1 #/Gal Gal			414
36	23	Stir 15 min or longer			
1	24	Record: Be 1.018 (3.4 ± 0.1) (1.018-1.020)			

N32370

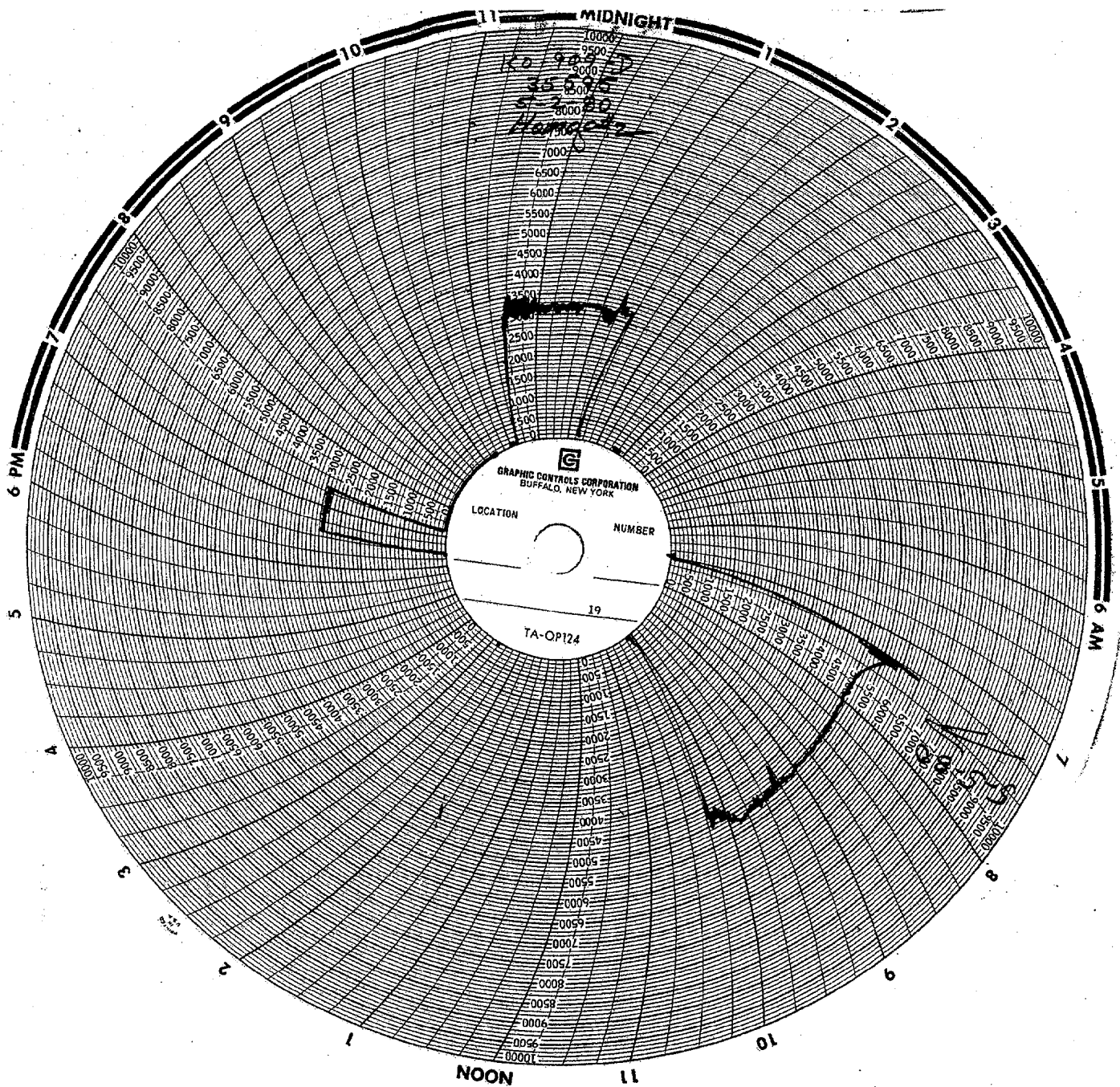
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INSTRUMENT	PAGE 2	CG 04 CODE K0-909-0000	EST. WGT. 5274 LBS.	USE LBS.	CODE	A																																								
SV 25	When S 20 heating complete, Record: pH 10.1 (9.6-10.2)																																													
6 26	Set V-343 acid pump at 69 setting (± 225 min)																																													
27	Set V-349 silicate pump at 54 setting (± 180 min)																																													
28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike																																													
29	<table border="1"> <thead> <tr> <th>Record</th> <th>Start</th> <th>Finish</th> <th>Minutes</th> </tr> </thead> <tbody> <tr> <td>V-343</td> <td>11:45</td> <td>3:40 PM</td> <td>235</td> </tr> <tr> <td>V-349</td> <td>11:45 AM</td> <td>2:55 PM</td> <td>190</td> </tr> </tbody> </table>						Record	Start	Finish	Minutes	V-343	11:45	3:40 PM	235	V-349	11:45 AM	2:55 PM	190																												
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Finish	3:30 (0)	-	9.2	7.5-8.5																																										
	NOTE: If pH not as specified, notify Supervisor & note in log																																													
	2) final pH is above 8.5, add to 7.5-8.5 &																																													
	Record: pH 6.5 Assume 78% 20																																													
30	Sift in 1 bag 356 50 27-0 128-A 50																																													
31	Run 30" (216 G) water into V-302 & heat to 135-140°F																																													
32	Dump in & stir to dissolve for 61 477 15-A 477																																													
33	Add 38" (465 G) water to V-302																																													
34	Add & stir 2 min for S 64 Assume 50% 296 7-0 148																																													
PT 35	During strike pump into PT 482 169-A 482																																													
36	Pump in 54 155-A 54																																													
37	Pump in 54 160-A 54																																													
38	Stir 10 min with lightning mixer for S 42																																													
356 39	During strike, run 15" (268 G) water into V-356																																													
40	Turn on steam																																													
41	Add to 1" (366 G) at 82-83°C																																													
42	Pump mixture from S 38 thru undersurface distributor A F A P																																													
43	Rinse with HOT water from hot water mixer & pump in																																													
44	Shut off pump																																													
45	Stir 30 min at 82-83°C for S 55																																													
46	Do not shut off agitator																																													
SV 47	When V-343 MTY, rinse in with minimum water then set pump to zero setting																																													
48	When V-343 MTY, rinse in with minimum water then turn off pump motor																																													
49	Stir 30 min at 190-194°F																																													
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 2800-3100 psi. Maintain SV at 198-200°F																																													
56	While Homog V-356 to SV, shut off water valve at stearate pump A F A P																																													

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MENT	PAGE 3 CG 04 CODE K0-909-D (C) EST. WGT. 5274 LBS.	USE LBS.	N CODL	AC
57	When Homog complete, rinse in V-356 with hot water from hot water mixer			
58	When S57 complete, turn off Homog & stearate pump			
59	Stir 5 min at 198-200°F			
60	Shut off steam			
61	Run in V-357 from S 32 and stir 5 min			
62	Record: pH <u>3.2</u> (3.4-3.8)			
63	If necessary, adj pH to 3.4-3.8 (Downward only) and Record: pH <u>3.2</u>		15-A	
64	Run in N-7-D from S 34 in 4-6 min and stir 5 min			
65	Record: pH <u>7.5</u> (6.2-6.4) and if necessary, adj to pH 6.2-6.4 and Record: pH <u>6.2</u> Assume 78% Assume 50%	20	27-B	
	(Dilute 10 parts water to 1 part N-7-D)		7-D	
	Siphon N-7-D into SV			
66	Do Not Stop Agitator			
	START FIN OPTR			
	<u>11:00 P</u> <u>7:00 AM</u> <u>235</u>			
5-5-80	<u>7:00 AM</u> <u>3:00 PM</u> <u>235</u>			
	<u>3:00 P</u> <u>9:15</u> <u>201</u>			

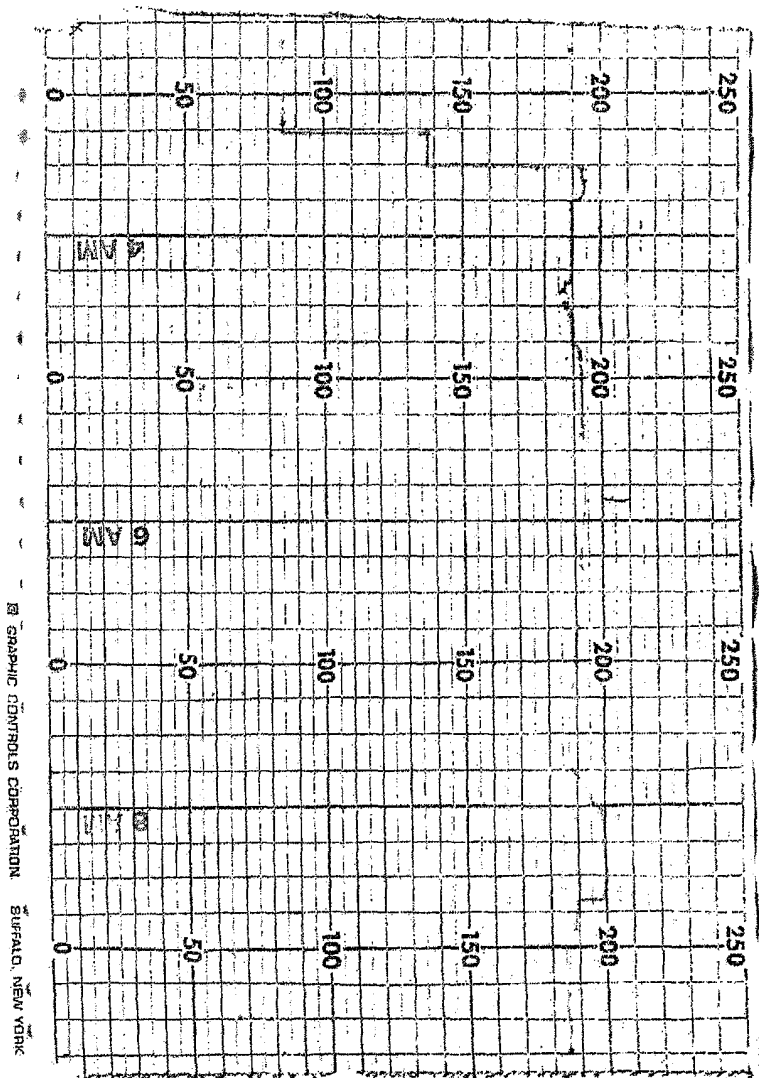


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V-247

DUP050457743



GRAPHIC CONTROLS CORPORATION, BUFFALO, NEW YORK

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