

246, 247, 245

C.V.

D.V.

04 CODE K0-789-D PKG.

JAN 20 33930

76.2 + 132 LBS.

| PROCESSES    |     | APPROVED BY  |  |
|--------------|-----|--------------|--|
| ( ) K0-789-D | (I) | EWK 09-21-76 |  |
| ( )          | ( ) | DCG 09-21-76 |  |
| ( )          | ( ) | MTW 10-02-76 |  |
| ( )          | ( ) | FWP 02-05-79 |  |
| TYPED BY     |     |              |  |
| emw020579    |     |              |  |

10.8 TIME

01 YC-16-B 93 4 Lot 33656 250#  
 01 YC-16-B 93 4 Lot 32510 100#  
 01 YC-16-B 93 4 Lot 30094 700#

01 YC-16-B 93 33478 2050  
 Homog #2

Total Weight 5332# (Req )

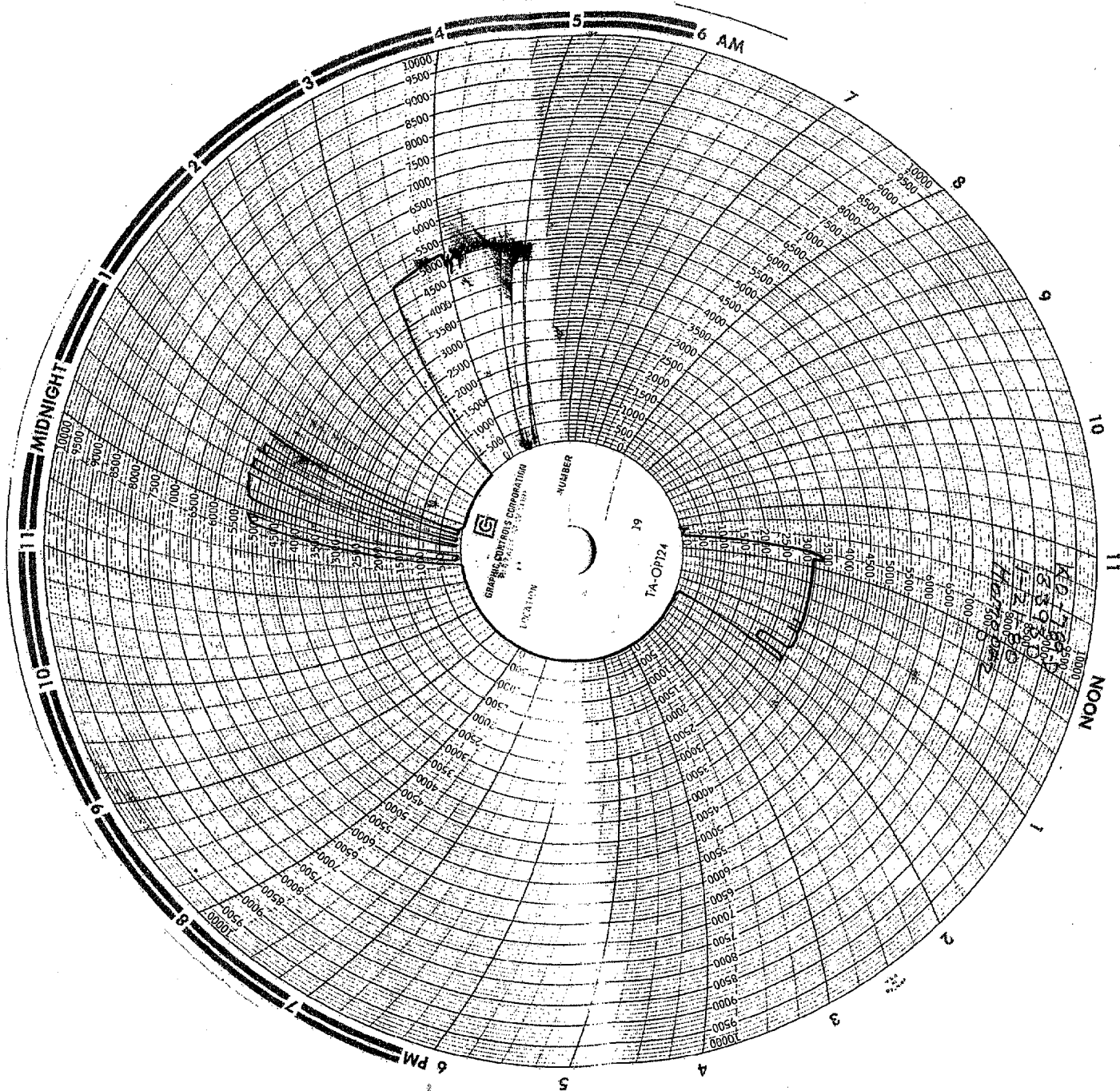
NON-BLEEDING

| NAME: KROLOR® ORANGE Y |                                                                                                             | USE LBS. | N CODE  | ACCT. LBS. |
|------------------------|-------------------------------------------------------------------------------------------------------------|----------|---------|------------|
| 211                    | 1 Run 60" (990 G) water into V-211                                                                          |          |         | 990        |
| 8                      | 2 Weigh in drum & pour in                                                                                   |          |         |            |
| 208                    | 3 Dump in & stir 5 min                                                                                      | 390 530  | 32-D    | 530        |
| 1                      | Record: Start 9:20                                                                                          | 33656    | YC-16-B | 4200       |
|                        | Fin 10:30                                                                                                   | 332510   |         | 3100       |
|                        | 4 Adj to 70" (1200 G) 2800-3200                                                                             | 33094    |         |            |
|                        | 5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208                                                      | 33478    |         |            |
|                        | 6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water                 |          |         |            |
|                        | 7 Record: V-208 Vol 54" & adj to 54" (1890 G)                                                               |          |         |            |
|                        | 8 Inspect Homog strainer & clean if necessary                                                               |          |         |            |
| 208                    | 9 Run 10" (514 G) water into V-245 & start agitator & install temperature chart                             |          |         |            |
| SV                     | 10 Pump V-208 thru Homog at 4800-5200 psi into SV-245                                                       |          |         |            |
| 2                      | Record: Time Start 11:37 AM Total Min 150                                                                   |          |         |            |
|                        | 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                                                             |          |         |            |
| 8                      | 13 Run ± 1000# water into V-384 & heat to 110-120°F                                                         | 1880     |         | 1880       |
| 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                                                             |          |         |            |
|                        | 16 Adj V-349 to 30" (1400 G) & stir 15 min or longer 22" (1040 G)                                           |          |         |            |
|                        | 17 Record: 0.061 (10.0 ± 0.2) (1.061-1.064)                                                                 |          |         |            |
| SV                     | 18 When S 10 Homog complete, adj SV to 45" (2300 G)                                                         |          |         |            |
| 4                      | 19 Record: pH 11.3 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50% | 16       | 7-D     | 8          |
|                        | Siphon N-7-D into SV & Record: pH 11.1                                                                      |          |         |            |
|                        | 20 Heat to 190-194°F in 55-65 min & Record: HT 192°F & Rec 193°F                                            |          |         |            |
|                        | NOTE: Strike must be started immediately on completion of heating                                           |          |         |            |
| 343                    | 21 While heating SV, run 70" (1920 G) water into V-343                                                      |          |         |            |
| 8                      | 22 Meter in from V-386 M 10, 9.50 #/Gal 30.5 Gal                                                            |          | 27-D    | 440        |
| 386                    | 23 Stir 15 min or longer                                                                                    |          |         | 290        |
| 5                      | 24 Record: 0.015 (2.5 ± 0.1) (1.013-1.015)                                                                  |          |         |            |

V.M.

V-245 240

| MPMENT | 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 9.2 (9.6-10.2)                                                                                |          |                   |            |           |            |         |           |
| 6 26   | Set V-343 acid pump at 86 setting (± 255 minutes) 65                                                                                 |          |                   |            |           |            |         |           |
| 27     | Set V-349 silicate pump at 22 setting (± 210 minutes) 54                                                                             |          |                   |            |           |            |         |           |
| 28     | Immediately meter in V-343 & V-349. Maintain SV at 190-1940F during strike                                                           |          |                   |            |           |            |         |           |
| 29     | Record:                                                                                                                              | Start    | Fin               | Min        |           |            |         |           |
|        | V-343                                                                                                                                | 6:05 AM  | 10:35A            | 270.       |           |            |         |           |
|        | V-349                                                                                                                                | 6:05 AM  | 9:40A             | 215        |           |            |         |           |
|        | Record:                                                                                                                              | Time     | V-343             | V-349      | SV        | Normal     |         |           |
|        |                                                                                                                                      |          | in                | in         | pH        | pH         |         |           |
|        | at 20 min                                                                                                                            | 6:15 AM  | (56) 49.40        | (28) 20.19 | 9.5       | 9.3-10.0   |         |           |
|        | 40 min                                                                                                                               | 6:45     | (60) 45.13        | (24) 18.17 | 9.3       | 9.3-10.0   |         |           |
|        | 1 hr                                                                                                                                 | 7:05     | (58) 41.1         | (28) 16    | 9.4       | 9.3-10.0   |         |           |
|        | 2 1/2 hrs                                                                                                                            | 8:20     | (34) 25.27        | (32) 8     | 9.4       | 9.3-10.0   |         |           |
|        | 3 1/2 hrs                                                                                                                            | 9:35     | (28) 21.1         | (0) 7      | 9.5       | 9.3-10.0   |         |           |
|        | Finish                                                                                                                               | 10:35    | (0)               | (0)        | 5.6       | 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      |
| 357 30 | Run 33" (238 G) water into V-357 & heat to 135-1400F                                                                                 |          |                   |            |           |            |         | 396       |
| 7 31   | Dump in & stir to dissolve                                                                                                           |          |                   |            |           | 396 530    | 15-A    | 530       |
| 302 32 | Add 42" (514 G) water to V-302                                                                                                       |          |                   |            |           |            |         |           |
| 8 33   | Add & stir 2 min                                                                                                                     |          |                   |            |           | Assume 50% | 246 330 | 7-D 165   |
| 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 190-1940F then turn off steam                                                                                         |          |                   |            |           |            |         |           |
|        | Record: Start 10:40                                                                                                                  |          |                   |            |           |            |         |           |
| 37     | Run in V-357 from S 31 & stir 5 min                                                                                                  |          |                   |            |           |            |         |           |
| 38     | Record: pH 3.1 (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 135-1400F 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 5.3 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.4                                                          |          |                   |            |           | Assume 77% | 27-D    |           |
|        | (Dilute 10 parts water to 1 part N-7-D)                                                                                              |          |                   |            |           | Assume 50% | 40      | 7-D 20    |
|        | Siphon N-7-D into SV                                                                                                                 |          |                   |            |           |            |         | 37        |
| 41     | Pour in & stir 15 min                                                                                                                |          |                   |            |           |            | 3426    | 978-A 25  |
| 42     | Stop agitator                                                                                                                        |          |                   |            |           |            |         |           |
|        | START                                                                                                                                | FIN      | OPTR              |            |           |            |         |           |
|        | 10:30 A                                                                                                                              | 3:00 PM  | 235-342           |            |           |            |         |           |
|        | 11:00 PM                                                                                                                             | 1:00 PM  | 520-102           |            |           |            |         |           |
|        | 2:00 A                                                                                                                               | 12:10 PM | 235               |            |           |            |         |           |



V-245

