S.V. ~~246~~, (247) C.V. D.V.

CG 04 CODE KO-906-D PKG. _____

→ 1/3 34106 11P

EST. WGT. 1377 LBS.

STD. HRS. _____ TIME _____ M

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		

OK / KP

Homog #2

01 YC-10-B 93 4 33486 , 400 #
01 YC-10-B 93 4 33368 , 2200 #
01 YC-10-B 93 4 33487 , 1100 #

TOTAL WEIGHT 5077# (Req. 595)

NON-BLEEDING

QUIPMENT		NAME: KROLOR® ORANGE R	USE LBS.	N CODE	ACCT. LBS.
	60" (996)				
211 &	1	Run ~~31" (505 G)~~ water in V-211 and add Assume 50%	26	7-D	13
208	2	Weigh in drum and pour in	245	32-D	245
1	3	Dump in and stir 5 min Lot	74 x 50	YC-10-B	3700
		Record: Start 3.30			
		Finish 5.30			
		75" (1275G)			
	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 50 " & adjust to 45" (1662 G)			
	8	Inspect Homog strainer and clean if necessary			
208 &	9	Run 15" (793 G) water into V-247 & start agitator			
SV	10	Pump V-208 thru Homog at 4800-5200 psi into SV			
2	11	Record: Time Start 3AM Total Min 140			
		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: [redacted] 1080 ~~(10.9 ± 0.2)~~ (1.078 - 1.081) g/mL			
SV	19	When S12 Homog complete, adj to 59" (3033 G) in SV			
4	20	Record: pH 11.0 & 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 ____, Rec ____ °F			
		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 14 , 9.38 #/Gal, 34.1 Gal		27-D	320
5	24	Stir 15 min or longer			
	25	Record: [redacted] 1018 ~~(2.9 ±0.1)~~ (1.018 - 1.019) g/mL			

13829 REV.

N 263

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EQUIPMENT			USE LBS.	N CODE	ACCT LBS.
SV 6	26	When S20 heating complete, Record: pH 10.1 (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 7 55 am / 12:40 pm / 300 V-349 9 am / 12:02 pm / 245			

Record: Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
at 20 min 8:15	(43) 43	(18) 18	9.8	9.3-10.0
40 min 8:35	(39) 39	(16) 16	9.8	9.3-10.0
1 hr 8:55	(35) 35	(13) 13	9.8	9.3-10.0
2 hrs 9:55	(22) 23	(7) 7+	9.8	9.3-10.0
3 hrs 10:55	(10) 23+	(0) 1+	9.8	9.3-10.0
Finish 11:40	(0)		7.5	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			
	31	Sift in 1 bag — Assume 78%	50	27-D 128-A	50
357 7	32	Run 19" (137 G) water into V-357 & heat to 135-140°F			
	33	Dump in & stir to dissolve for S61	270	15-A	270
302 8	34	Run 24" (294 G) water into V-302 2-D			
	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	Adj to 30" (366 G) at ~~178-182°F~~ 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			
	46	Stir 30 min at ~~178-182°F~~ for S55 82°C			
	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			

EQUIPMENT		PAGE 3 CG 04 CODE KO-906-D (C) EST. WGT. 5077 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	~~57~~	When Homog complete, rinse in V-356 with hot water			
11		From hot water mixer			
Con'T'	~~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 S33 and stir 5 min			
	~~62~~	Record: pH 3.1 (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 4.2 (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
3:00P	11:00P	235-323
7:00 am	3:00 pm	101-126
300/Pm	330/Pm	323

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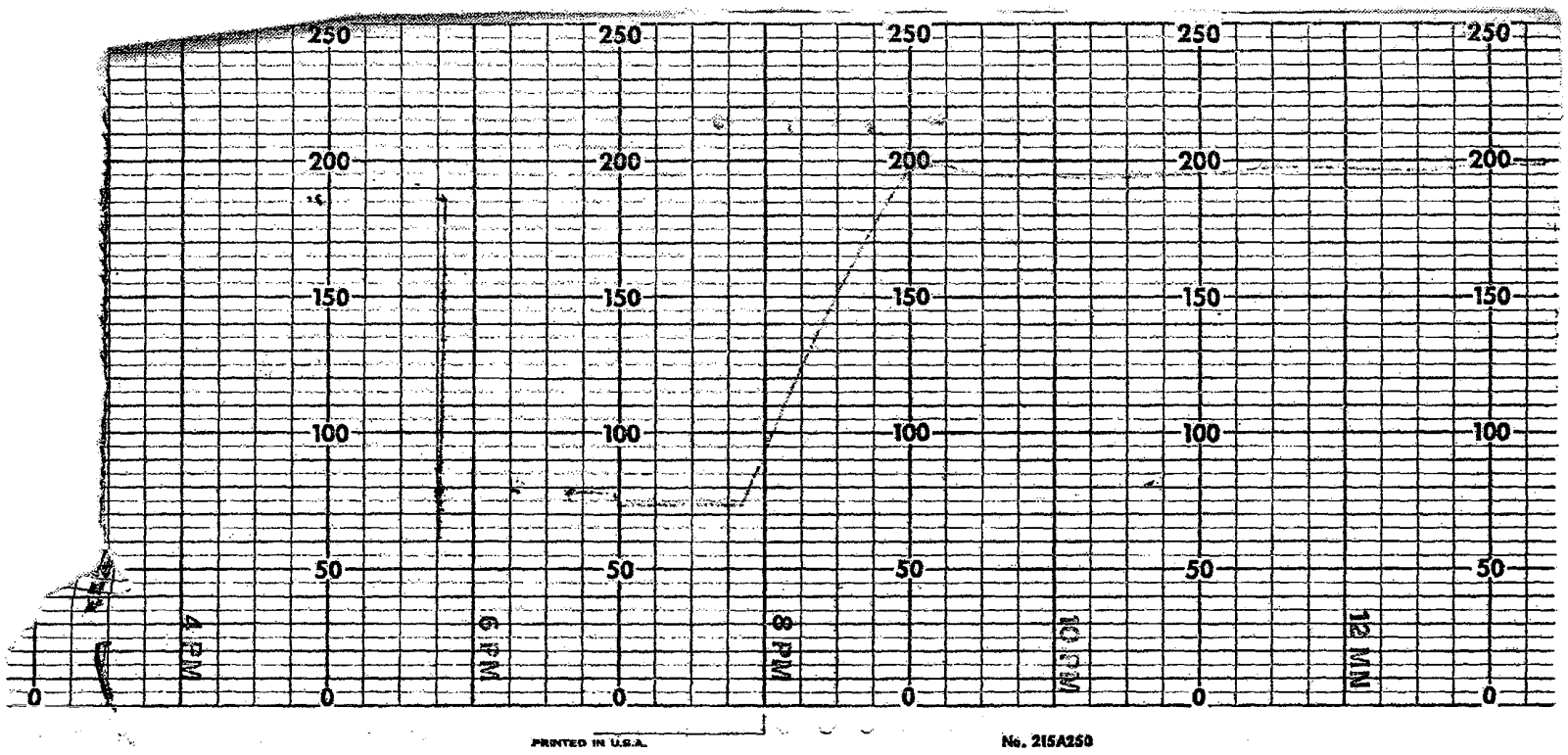

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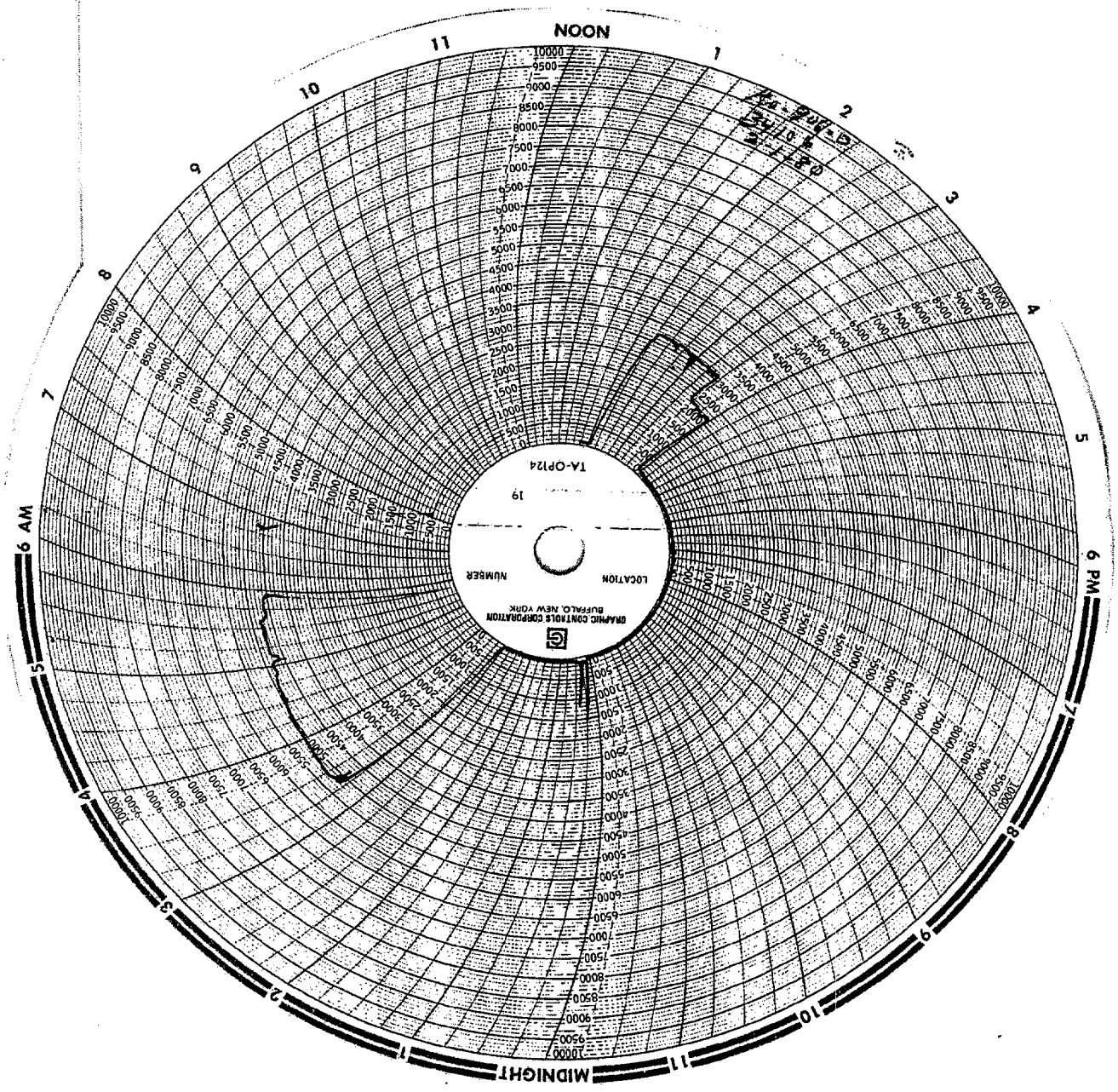

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