

V. 246, 247

C.V.

D.V.

OG 04 CODE K0-786-D PKG.

JAN-6 33652

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

01 YC-10-B 93 4 33480 1300#
 01 YC-10-B 93 4 33368 1200#
 01 YC-10-B 93 4 33486 1600#

PROCESSES		APPROVED BY
() K0-786-D	(P)	EWK 9-21-76
()	()	DCG 9-21-76
()	()	MTW 10-1-76
()	()	
TYPED BY		
JIC 11-16-76		

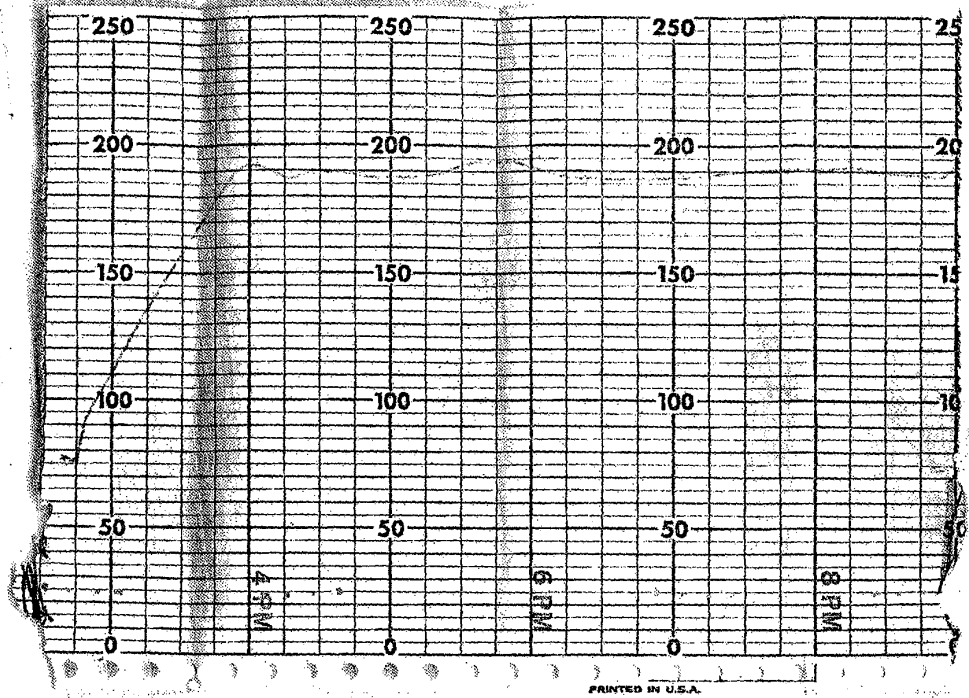
Total Weight 4962# (Req. 525)

NON-BLEEDING

SHIPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211	Run 60" (990 G) water in V-211 and add	Assume 50%	30	7-D 15
8	Weigh in drum and pour in V-211	270	32-D	270
208	Dump in and stir 5 minutes	82 x 50	YC-10-B	4100
1	Record: Start 1.30 AM 33480	1.30		
	Fin 3.30 AM 33368	1.20		
	75" (12756) 33486	1.60		
	4 Adjust to 80" (1370 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 47" and adjust to 50" (1840 G)			
	8 Inspect homog strainer and clean if necessary			
108	9 Run 15" (771 G) water into V-247 and start agitator and install temperature chart			
8	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
SV	Record: Time Start 11:54 AM Total Minutes 130			
2	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			
384	14 Weigh into V-384 and pump to V-349	2400	32-D	2400
3	15 Run 1000# water into V-384 and pump to V-349			
	16 Adjust V-349 to (22") (1040 G) & stir 15 minutes or longer			
	17 Record: 1.050 (10.9 ± 0.2) (1.078-1.081)			
SV	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
4	19 Record: pH 10.4 and adjust 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 and Record: pH			
	20 Heat to 190-194°F in 55-65 minutes & Record: HT 192 F and Rec 199 F			
	Note: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 51" (1400 G) water into V-343			
8	22 Meter in from V-386 M 2 #/Gal 9.70 Gal 36.6		27-D	355
386	23 Stir 15 minutes or longer			
5	24 Record: 1.019 (2.8 ± 0.1) 1.017-1.019			

V-247

EQUIPMENT	PAGE 2 CG 04 CODE K0-786-D (B) EST. WGT. 4962 LBS.	USE LBS.	N CODE	ACT. LBS.
SV 6	25 When S 20 heating complete. Record: pH <u>9.6</u> (9.6-10.2) 26 Set V-343 acid pump at (72) setting (± 25 minutes) 27 Set V-349 silicate pump at (66) setting (± 180 minutes) 28 Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike 29 Record: Start Finish Minutes V-343 <u>11:40</u> <u>8:30 A.M.</u> <u>230</u> V-349 <u>7: AM</u> <u>7:50 A.M.</u> <u>190</u> Record: Time V-343 V-349 SV Normal Inches Inches pH pH at 20 min <u>5:00</u> (47) <u>77</u> (20) <u>2.0</u> <u>9.5</u> 9.3-10.0 40 min <u>5:20</u> (43) <u>43</u> (17) <u>1.2</u> <u>9.7</u> 9.3-10.0 1 hr <u>5:40</u> (38) <u>38</u> (15) <u>1.5</u> <u>9.7</u> 9.3-10.0 2 hrs <u>6:40</u> (24) <u>26</u> (7) <u>7</u> <u>9.7</u> 9.3-10.0 3 hrs <u>7:40</u> (10) <u>13</u> (0) <u>±1</u> <u>9.7</u> 9.3-10.0 Finish <u>8:25</u> (0) <u>—</u> (0) <u>—</u> <u>8.5</u> 7.5-8.5 Note: if pH drops below 9.3 in 1st hour, stop pumps and see supervisor. If final pH is above 8.5, adjust to (7.5-8.5) and Record: pH Assume 77%			
357 7	30 Run 21" (150 G) water into V-357 and heat to 135-140°F 31 Dump in and stir to dissolve	300	15-A	300
302 8	32 Add 42" (514 G) water to V-302 33 Add and stir 2 minutes Assume 50%	150	7-D	75
SV 9	34 When V-349 MTY, rinse in with minimum water then set pump to zero setting 35 When V-343 MTY, rinse in with minimum water, then turn off pump motor 36 TURN OFF STEAM 37 Run in V-357 from S 31 and stir 5 minutes 38 Record: pH <u>3.4</u> (3.3-3.7) 39 If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH 40 Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes 41 Record: pH <u>5.7</u> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH <u>4.2</u> Assume 77% (Dilute 10 parts water to 1 part N-7-D) Assume 50% Siphon N-7-D into SV 42 Stop agitator START FINISH OPTR <u>7:00 AM</u> <u>3:00 PM</u> <u>322-201</u> <u>11:00 PM</u> <u>7:00 AM</u> <u>438-409</u> <u>7:00 PM</u> <u>10:30 AM</u> <u>401427</u>	10	27-D 7-D	8



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