

246. (247) (245) C.V.

D.V.

04 CODE KO-789-D PKG.

JAN 15 33828

WGT 509 1132 TBS.

PROCESSES		APPROVED BY
() KO-789-D	(1)	EWK 09-21-76
()	()	DCG 09-21-76
()	()	MTW 10-02-76
()	()	FWP 02-05-79
TYPED BY		
emw020579		

SAS 10.8 TIME 7 A M

01 YC-16-B 93 4 Lot 32510, 400 #

01 YC-16-B 93 4 Lot 33473, 1700 #

01 YC-16-B 93 4 Lot , #

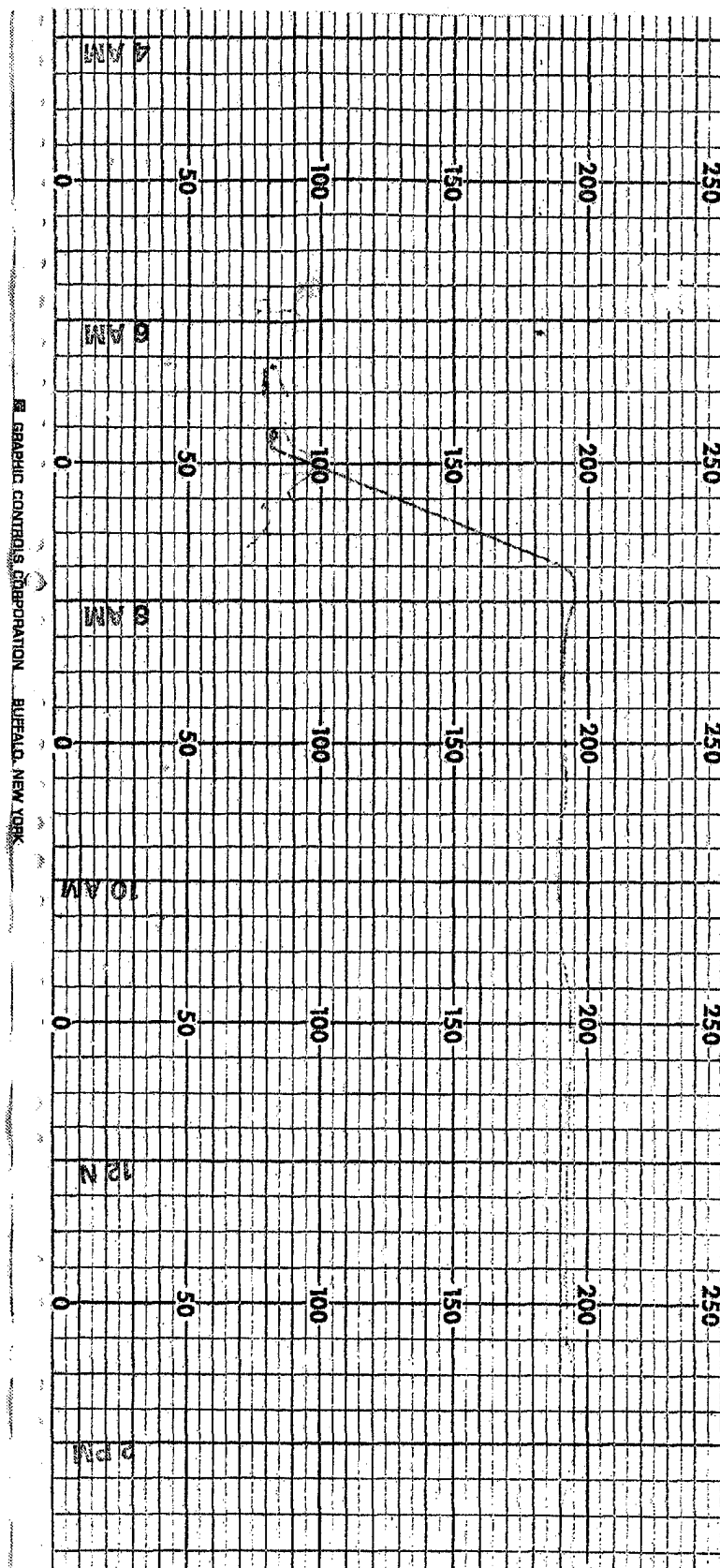
Total Weight 5332# (Req 0548)

NON-BLEEDING

NAME: KROLOR® ORANGE Y		USE LBS.	N CODE	ACCT. LBS.
211	1 Run 60" (990 G) water into V-211			265
&	2 Weigh in drum & pour in	265 530	32-D	530
208	3 Dump in & stir 5 min	Lot 42 24 x 50	YC-16-B	4200
1	Record: Start 5:45	32510		3100
	Fin 7:10	33473		
4	Adj to 70" (1200 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. Use Hgt Water			
7	Record: V-208 Vol 39" & adj to 54" (1890 G)			
8	Inspect Homog strainer & clean if necessary			
208	9 Run 10" (514 G) water into V-247 & start agitator & install temperature chart			
SW	10 Pump V-208 thru Homog at 4800-5200 psi into SV-247			
2	Record: Time Start 8: Am, Total Min / 30			
	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			
&	13 Run ± 1000# water into V-384 & heat to 110-120°F	1272		1272
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" (1041 G)			
✓	17 Record: 0.6 1.041 (10.0 ± 0.2) (1.040-1.044)			
SW	18 When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19 Record: pH 10.6 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	12	7-D	6
✓	20 Siphon N-7-D into SV & Record: pH 11.3			
	Heat to 190-194°F in 55-65 min & Record: HT 192°F & Rec 192°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 4, 755/Gal 204		27-D	410
386	23 Stir 15 min or longer			125
5	24 Record: 0.6 1.008 (2.5 ± 0.1) (1.008-1.009)			

V-247

MPMENT	PAGE 2 CG 04 CODE K0-789-D (I) EST. WGT.	5332 LBS.	USE LBS.	N CODE	ACCT. LBS.	
SV 6	25 When S 20 heating complete, Record: pH <u>10.0</u> (9.6-10.2)					
	26 Set V-343 acid pump at 25 setting (± 255 minutes) <u>65</u>					
	27 Set V-349 silicate pump at 22 setting (± 210 minutes) <u>53</u>					
	28 Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike					
	29 Record:	Start	Fin	Min		
	V-343	<u>245</u>	<u>8:00 PM</u>	<u>315</u>		
	V-349	<u>245</u>	<u>6:45 PM</u>	<u>240</u>		
	Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
	at 20 min	<u>305</u>	(86) <u>49-50</u>	(28) <u>2021</u>	<u>10.0</u>	9.3-10.0
	40 min	<u>325</u>	(80) <u>45-46</u>	(24) <u>18-19</u>	<u>10.0</u>	9.3-10.0
	1 hr	<u>345</u>	(86) <u>41-42</u>	(28) <u>16-16</u>	<u>10.0</u>	9.3-10.0
	2 1/2 hrs	<u>500</u>	(24) <u>25-26</u>	(18) <u>8-8</u>	<u>9.9</u>	9.3-10.0
	3 1/2 hrs	<u>615</u>	(18) <u>9-10</u>	(0) <u>+1</u>	<u>9.9</u>	9.3-10.0
	Finish	<u>700</u>	(0)		<u>7.3</u>	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 135-140°F					
7	31 Dump in & stir to dissolve				265 530 15-A 530	
314	32 Add 42" (514 G) water to V- 357 <u>314</u>					
8	33 Add & stir 2 min				Assume 50% 164 330 7-D 165	
SV 9	34 When V-349 MTY, rinse in with minimum water then set pump at zero setting					
	35 When V-343 MTY, rinse in with minimum water then turn off pump motor					
	36 Stir 30 min at 190-194°F then turn off steam					
	Record: Start <u>8:00 PM</u>					
	37 Run in V-357 from S 31 & stir 5 min					
	38 Record: pH <u>2.7</u> (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 135-140°F 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 <u>4.2</u> (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH <u>6.4</u>				Assume 77% 27-D	
	(Dilute 10 parts water to 1 part N-7-D)				Assume 50% 10 7-D 5	
	Siphon N-7-D into SV					
	41 Pour in & stir 15 min				12 25 978-A 1225	
	42 Stop agitator					
	START <u>7:10 P</u>	FIN <u>11:00</u>	OPTR <u>120-101</u>			
	<u>7 AM</u>	<u>3 PM</u>	<u>223-282</u>			
	<u>3: P.M.</u>	<u>10:30 P.M.</u>	<u>101-126</u>			



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK

