~~246~~ ~~247~~ 245 C.V. D.V.

04 CODE KO-789-D PKG.

JAN 18 33882

WGT 509 ~~1132~~ LBS.

HRS. 10.8 TIME 11P M 32520

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

OK

01 YC-16-B 93 4 Lot 32520, 200#

01 YC-16-B 93 4 Lot 33609, 1000#

01 YC-16-B 93 4 Lot 33655, 900#

Total Weight ~~5332#~~ 2609 (Req _____)

NON-BLEEDING

ENT		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	1	Run 60" (990 G) water into V-211			
&	2	Weigh in drum & pour in	265 ~~530~~	32-D	~~530~~ 265
208	3	Dump in & stir 5 min Lot 42	~~84~~ x 50	YC-16-B	~~4200~~ 2100
1		Record: Start 12 A.M. 32520	200		
		Fin 1 A.M. 33609	1000		
		33655	900		
	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 Hot Water			
	7	Record: V-208 Vol 42" & 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			
&	10	Pump V-208 thru Homog at 4800-5200 psi into SV-245			
SV 2		Record: Time Start 10:20 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			
&	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" (1040 G)			
	17	Record: °Be' 1.044 ~~(10.0 ± 0.2)~~ (1.040-1.044) g/ml			
SV	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%	20	7-D	10
		Siphon N-7-D into SV & Record: pH 11.2			
	20	Heat to 190-194°F in 55-65 min & Recrod: HT ____ °F & Rec ____ °F			
		NOTE: Strike must be started immediately on completion of heating			
343	21	While heating SV, run ~~70" (1920 G)~~ 52" (1430 G) water into V-343			
&	22	Meter in from V-386 M 7, 9.55 #/Gal 20.4 Gal		27-D	~~440~~ 195
386	23	Stir 15 min or longer 70.73			
5	24	Record: °Be' 1.009 ~~(2.5 ± 0.1)~~ (1.008 - 1.009) g/ml 276			

V-245

PMENT		PAGE 2 CG 04 CODE KO-789-D (I) EST. WGT. 5332 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete, Record: pH 10.0 (9.6-10.2)			
	26	Set V-343 acid pump at 26 setting (± 255 minutes) 65			
	27	Set V-349 silicate pump at 72 setting (± 210 minutes) 53			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start Fin Min			
		V-343 2:30 AM 6:05 AM 215			
		V-349			

Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	2:50 A	(66) 49 50	(27) 20 20	9.9	9.3-10.0
40 min	3:10 A	(60) 45 46	(24) 18 19	9.8	9.3-10.0
1 hr	3:30 A	(55) 41 42	(21) 16 16	9.8	9.3-10.0
2¼ hrs	4:45 A	(34) 25 26	(11) 8 8	9.8	9.3-10.0
3½ hrs	6:00 A	(18) 9 10	(0) —	9.8	9.3-10.0
Finish	6:45 A	(0) 0	—	7.8	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 7	30	Run 33" (238 G) water into V-357 & heat to 135-140°F			265
	31	Dump in & stir to dissolve	265 ~~530~~	15-A	~~530~~
302 8	32	Add 42" (514 G) water to V-302			92
	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 6:50 A.M			
	37	Run in V-357 from S 31 & stir 5 min			
	38	Record: pH 3.2 (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 4.5 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.3 Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	36	7-D	18
		Siphon N-7-D into SV			
	41	Pour in & stir 15 min	12 ~~25~~	978-A	12 ~~25~~
	42	Stop agitator			

START	FIN	OPTR
3:00 P	11:00 P	27-120
11:00 P.M	7:00 A.M	37-320
7:00 AM.	8:50 AM	235

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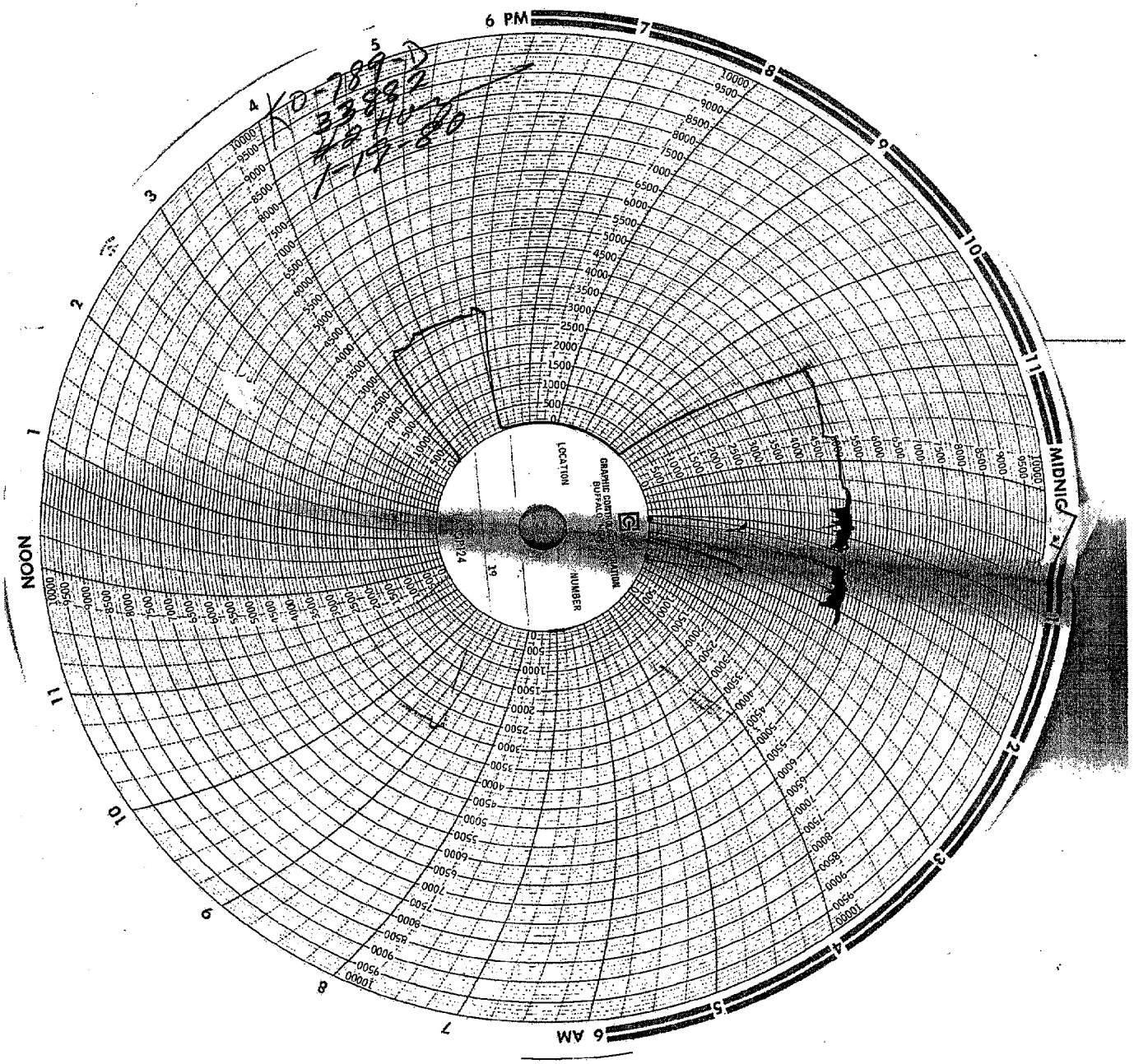

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