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

04 CODE KO-789-D JAN 22 PKG. 33955

WGT 762 ~~1132~~ LBS.

10.8 TIME 7:A M

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 33608, 700#

01 YC-16-B 93 4 Lot 33751, 200#

01 YC-16-B 93 4 Lot 33754, 2150#

3862 33754 50

(2) (V.m.)

Total Weight ~~5332~~# (Req 0571)

NON-BLEEDING

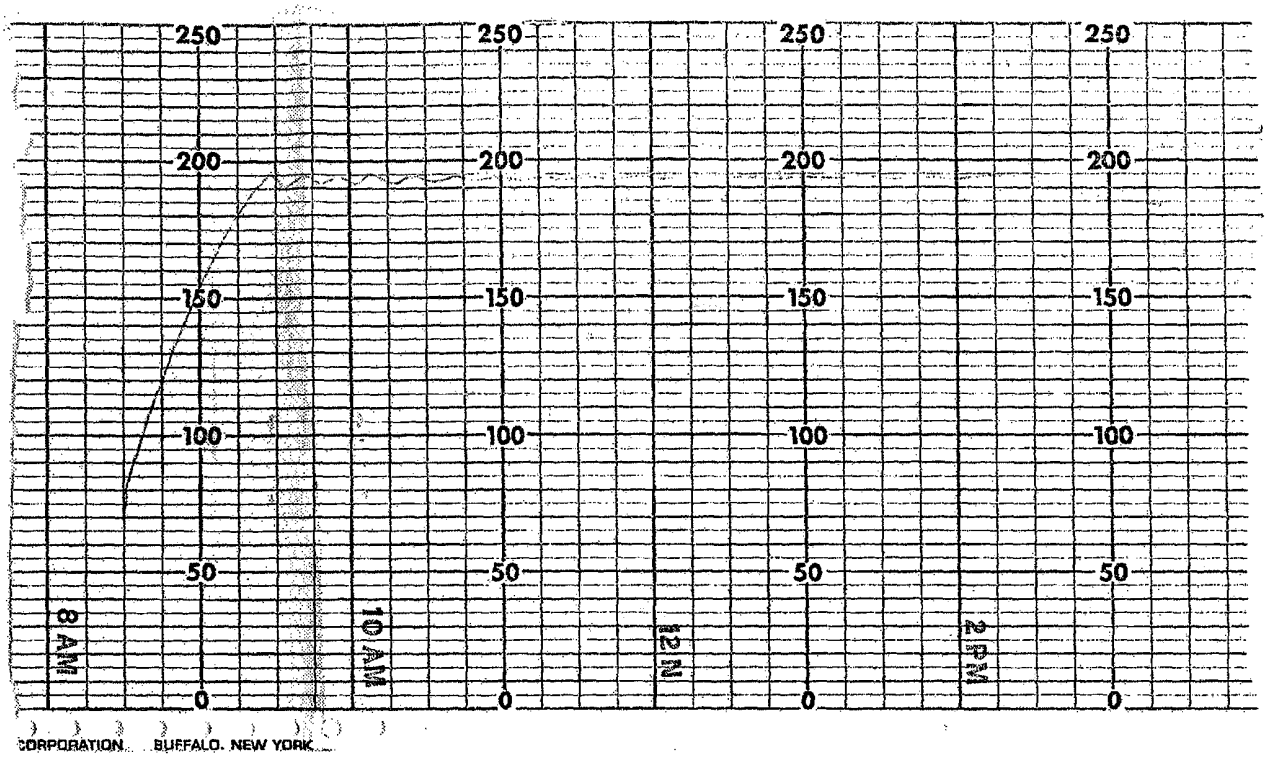
PART		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run 60" (990 G) water into V-211			390
	2	Weigh in drum & pour in	390 ~~530~~	32-D	~~530~~
	3	Dump in & stir 5 min Lot 62	~~84~~ x 50	YC-16-B	~~4200~~
		Record: Start 1.00 PM 33608	700		3100
		Fin 2.50 PM 33751	200		
		33754	2150		
	4	Adj to 70" 1200 G) 2800-3200 33754	50		
	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 54 " & adj to 54" (1890 G)			
	8	Inspect Homog strainer & clean if necessary			
208 & SV 2	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			
		Record: Time Start 1.20 AM Total Min 100			
		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 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ± 1000# water into V-384 & heat to 110-120°F			
	14	Weigh into V-384 & pump to V-349	~~2930~~	32-D	~~2930~~
	15	Run ± 1000# water into V-384 & pump to V-349	1880		1880
	16	Adj V-349 to ~~30" (1400 G)~~ & stir 15 min or longer 22" (1040 G)			
	17	Record: °Be 1.064 ~~(10.0 ± 0.2)~~ (1.061-1.064) g/mL			
SV 4	18	When S 10 Homog complete, adj SV to 45" (2300 G)			
	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%	22	7-D	11
		Siphon N-7-D into SV & Record: pH 11.2			
	20	Heat to 190-194°F in 55-65 min & Recrod: HT 194 °F & Rec 187 °F			
		NOTE: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run ~~70" (1920 G)~~ 52" (1430 G) water into V-343			
	22	Meter in from V-386 M 10, 9.50 #/Gal 30.5 Gal		27-D	~~440~~ 290
	23	Stir 15 min or longer			
	24	Record: °Be 1.014 ~~(2.5 ± 0.1)~~ (1.013-1.015) g/mL			

V-245

PMENT		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 10.2 (9.6-10.2)			
6	26	Set V-343 acid pump at 86 setting (± 255 minutes) 65			
	27	Set V-349 silicate pump at 72 setting (± 210 minutes) 54			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start Fin Min V-343 7:30 12:05PM 275. V-349 7 AM 11:10A 220			
		Record: Time V-343 in V-349 in SV pH Normal pH 7:30 — — — — at 20 min 7:50 (68) 49 + (27) 20 10.0 9.3-10.0 40 min 8:10 (68) 4546 (24) 18 9.9 9.3-10.0 1 hr 8:30 (55) 4142 (21) 16 9.85 9.3-10.0 2¼ hrs 9:45 (34) 2528 (11) 8 9.8 9.3-10.0 3½ hrs 11:00 (13) 913 (0) ± 1 9.7 9.3-10.0 Finish 11:45 (0) — — 7.0 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			390
7	31	Dump in & stir to dissolve	390 530	15-A	530
302	32	Add 42" (514 G) water to V-302			120
8	33	Add & stir 2 min Assume 50%	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 190-194°F then turn off steam Record: Start 12:05PM.			
	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 6.2 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV			37
	41	Pour in & stir 15 min	37 25	978-A	25
	42	Stop agitator			

START	FIN	OPTR
11:00 PM	7:00 AM OR	144-145
7:00 A	1:30 PM.	235 - 54

DUP050095299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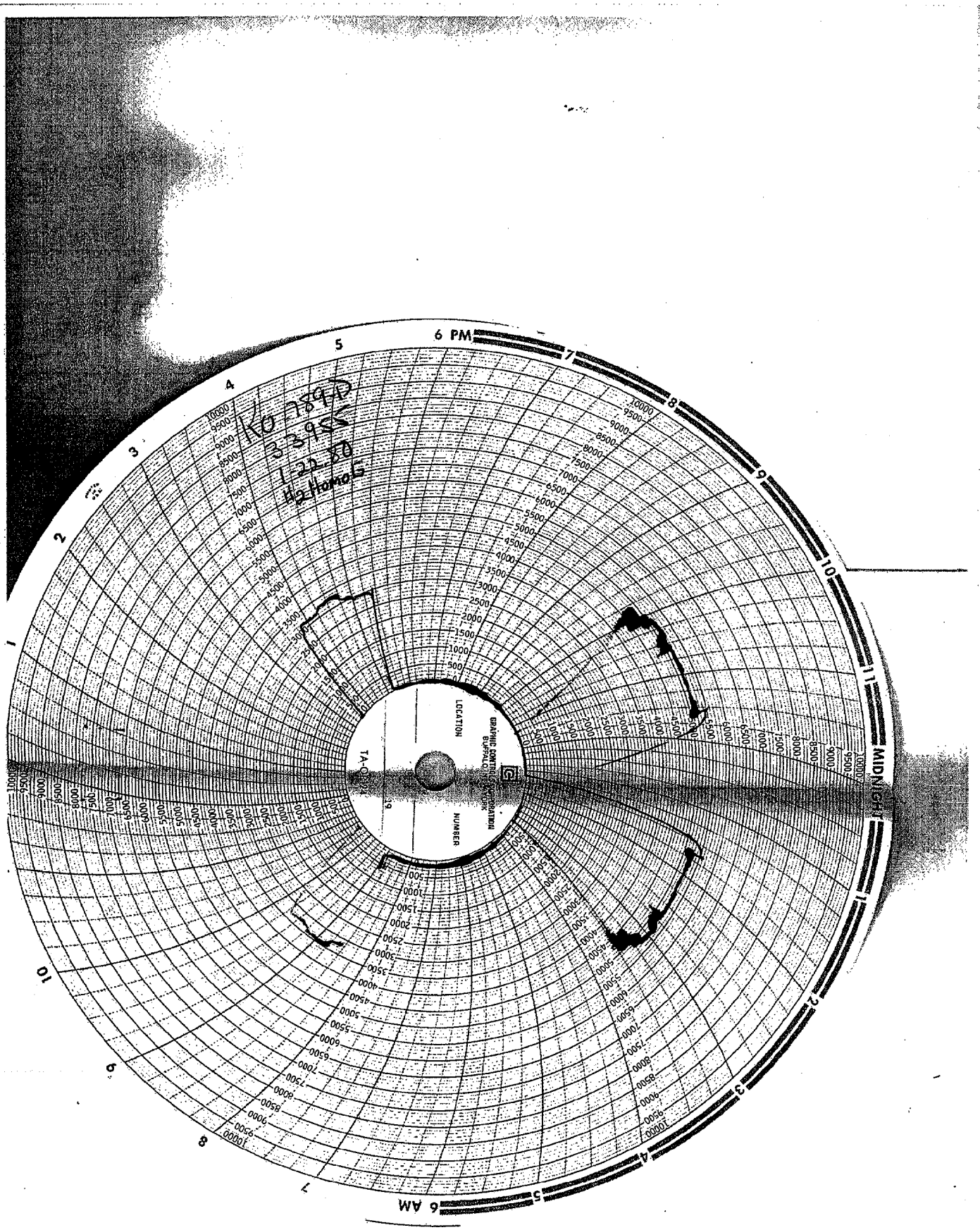
CORPORATION BUFFALO, NEW YORK



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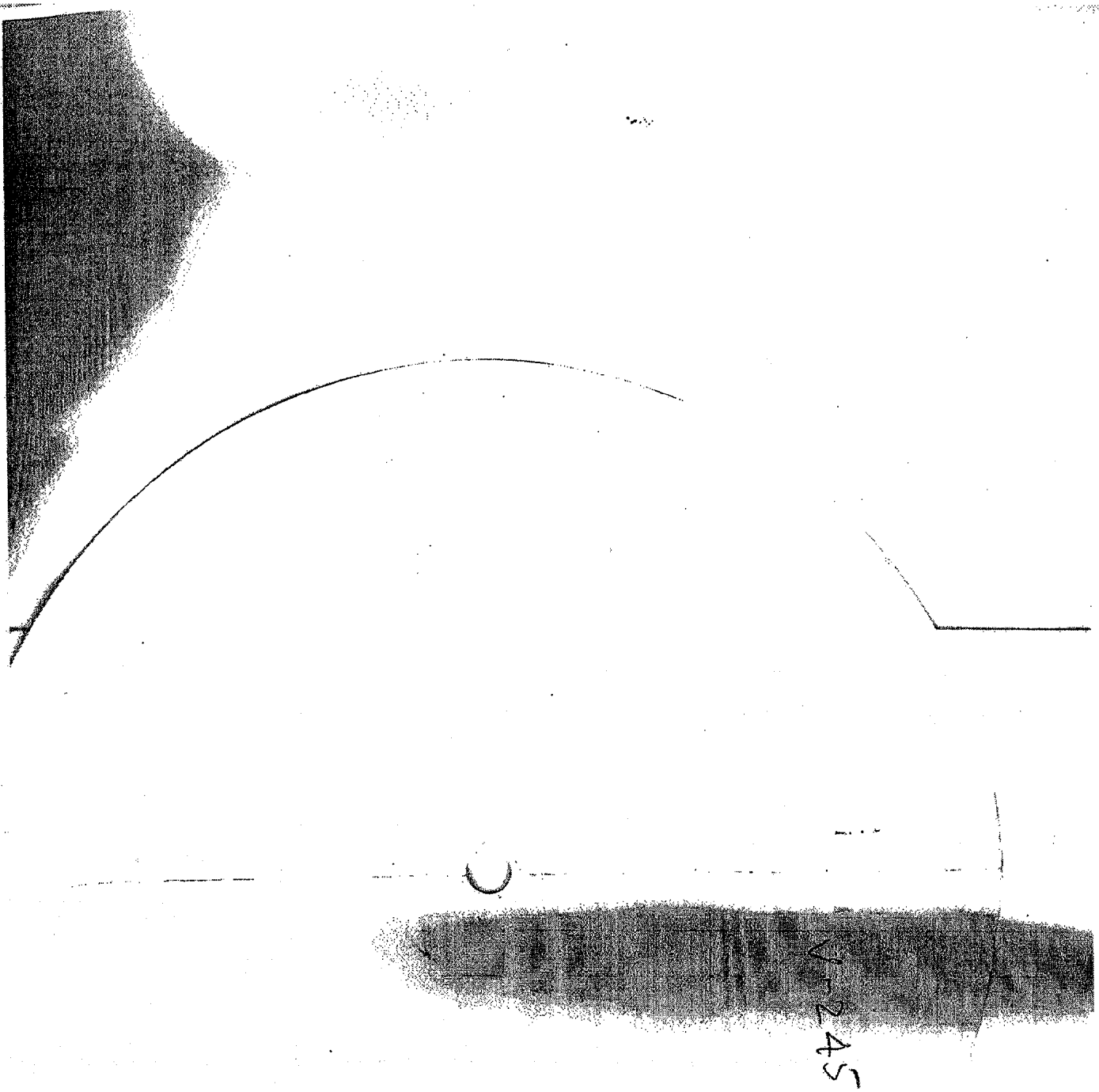

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