

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

D.V.

CO 04 CODE K0-909-D PKG.

JAN 13 33795

EST. WGT. 812 2074 LBS.

STD. HRS. TIME 7 AM

01 YC-16-B 93 4 Lot 28821 50 #
 01 YC-16-B 93 4 Lot 28821 3250 950 #
 01 YC-16-B 93 4 Lot 33475 800 #

TOTAL WGT 527 (Req.)

PROCESSES		APPROVED BY	
() K0-909-D	(C)	EWK 1-27-78	
()	()	DCG 1-30-78	
()	()	MTW 2-27-78	
()	()		
TYPED BY			
NSA 3-13-78			

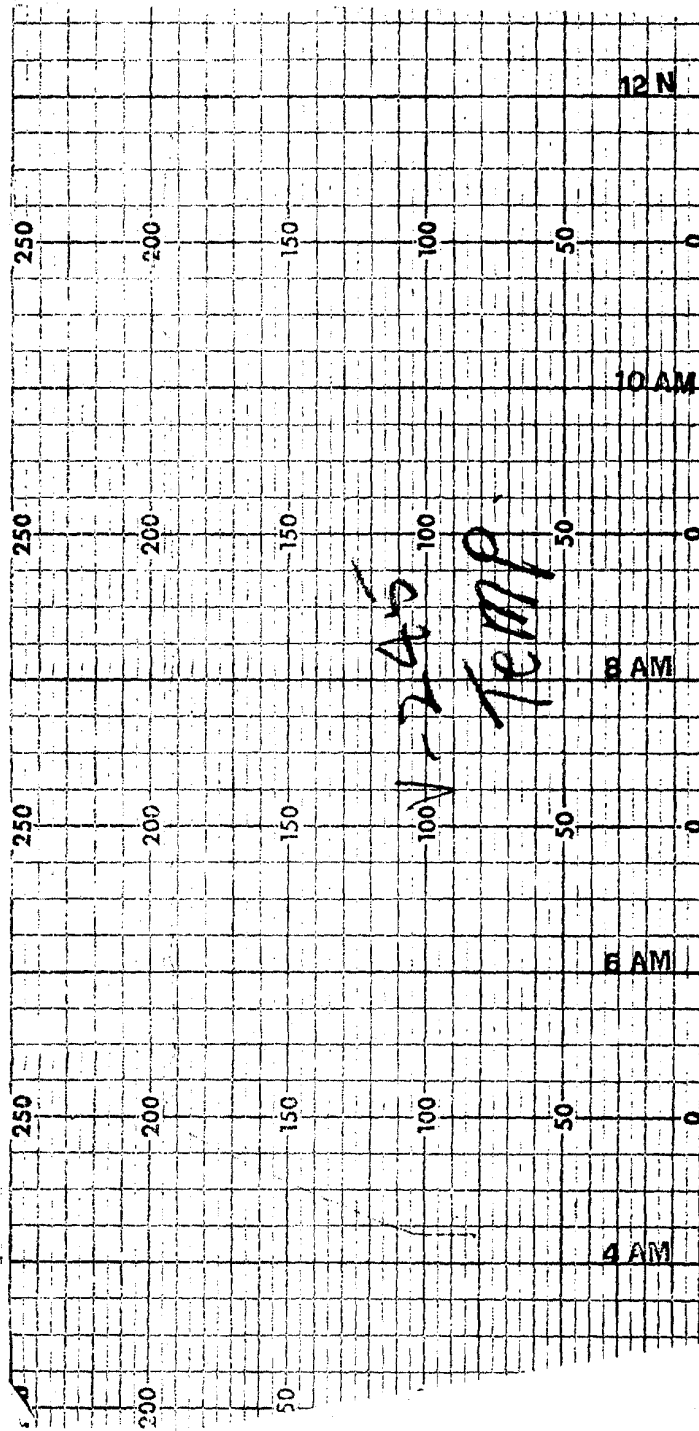
EQUIPMENT		NAME: KROMOR ORANGE Y		USE LBS.	N CODE	ACCT. LBS.
211	1	Run 30" (514 G) water into V-211				
8	2	Pour in		480 240	32-D	480 240
208	3	Dump in	Lot 36	30 x 50	VC-16-B	2500
1		Record: Start: 8:00				1800
		Fin: 8:30				
		75" (1275 G)				
		Adj to 63" (1065 G) 2800-3200				
		Pump V-211 thru Homog #2 at 1800-2200 psi into V-208				
		When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water				
		Record: V-208 Vol 48" and adj to 54" (1981 G)				
		Inspect homog strainer & clean if necessary				
208	4	Run 10" (514 G) water into V-245. Install Temp chart				
8	5	start agitator				
SV	10	Pump V-208 thru Homog at 4800-5200 psi into SV				
2		Record: Time Start 12:35 PM Total Min 130				
		NOTE: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208				
		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		1388		1388
384	14	Weigh into V-384 and pump to V-349		2775	32-D	2775
3	15	Run 1000# water into V-384 and pump to V-349				
	16	Adj V-349 to 19" (899 G) and stir 15 min or longer				
	17	Record: pH 1.05 (1.34 ± 0.2) 1.057- (1.061)				
		g/ml				
	18	When S-10 Homog complete, adjust SV to 60" (3084 G)				
	19	Record: pH 10.5 and adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		26	7-D	13
		Siphon N-7-D into SV & Record: pH 11.3				
	20	Heat to 190-194°F in 55-65 min and Record: HT °F and Rec 192 °F				
		NOTE: Strike must be started immediately on completion of heating				
343	21	While heating SV, run 49" (1348 G) water into V-343				
8	22	Water in from V-386 M 2.64 #/Gal 21.5 Gal			27-D	414
386	23	Stir 15 min or longer				207
5	24	Record: pH 1.011 (3.4 ± 0.1) 1.009- (1.011)				
		g/ml				

V-245

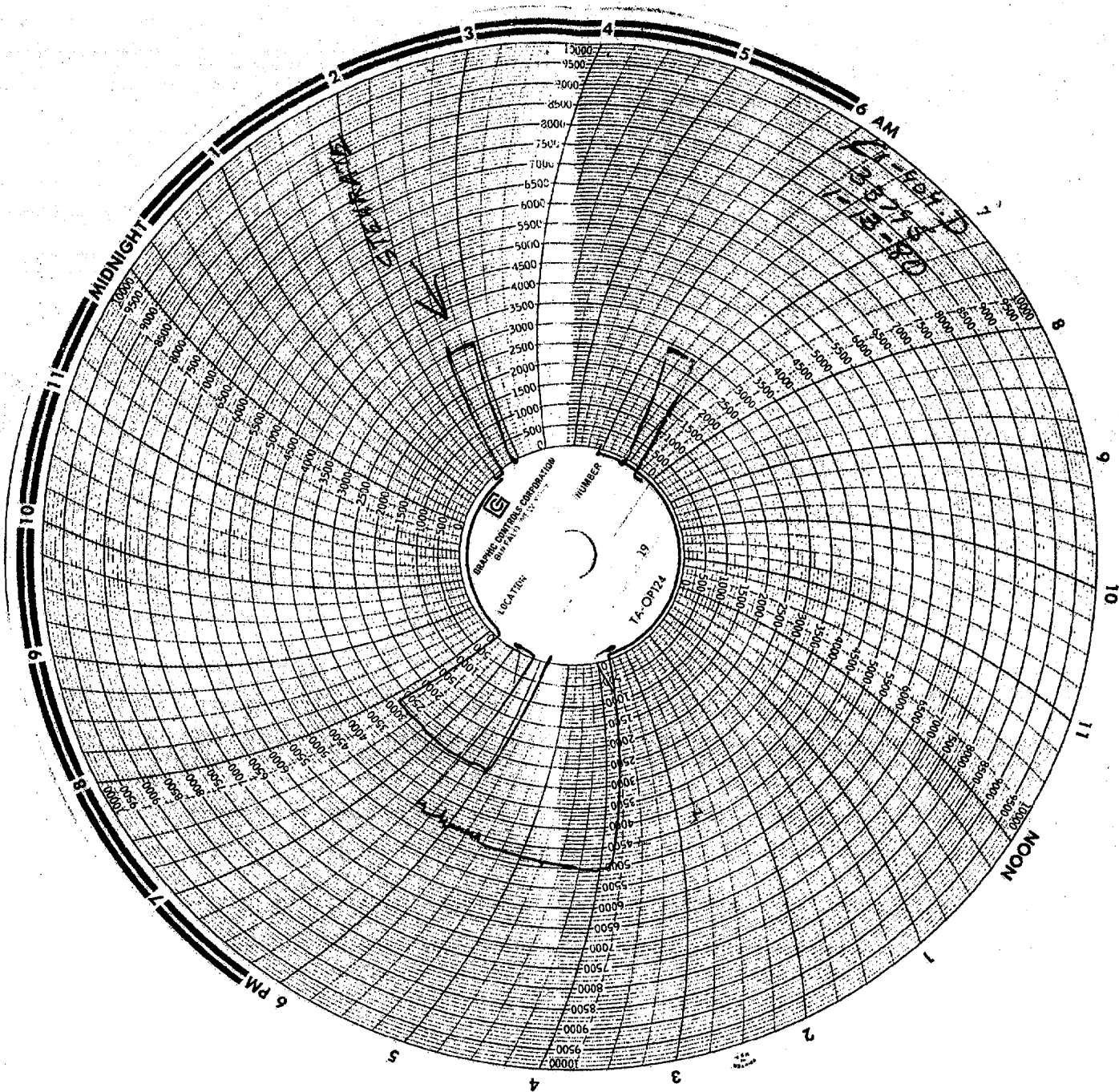
EQUIPMENT	PAGE 2 CG 04 CODE KO-909-D (C)	EST. WGT. 5274 LBS.	USE LBS.	N CODE.	ACCT. LBS.
SV 6	25 When S 20 heating complete, Record: pH/0.2 (9.6-10.2) 26 Set V-343 acid pump at (69) setting (± 225 min) 27 Set V-349 silicate pump at (54) setting (± 180 min) 28 Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike 29 Record: Start Finish Min V-343 0.55 12:55 A 248 V-349 0 PM 12:05 AM 198				
	Record: Time V-343 V-349 SV pH Normal pH Inches Inches at 20 min 9:15 PM (46) 46 (17) 17 9.9 9.3-10.0 40 min 9:35 PM (41) 41 (15) 15 9.9 9.3-10.0 1 hr 9:55 PM (37) 37 (13) 13 9.9 9.3-10.0 2 hrs 10:55 PM (23) 26 (6) 7 9.9 9.3-10.0 3 hrs 11:55 PM (10) 13 (0) 1 9.8 9.3-10.0 Finish 12:55 AM (0) 9.1 7.5-8.5 NOTE: (1) If pH not as specified, notify supervisor & note in log (2) If final pH is above 8.5, adjust to 7.5-8.5 & Record: pH 8.4 Assume 78%				
	30 Sift in 1 bag		26 50	27-D 128-A	50
357 7	31 Run 30" (216 G) water into V-357 and heat to 135-140°F 32 Pump in and stir to dissolve for S 61		239 477	15-A	238 477
302 8	33 Add 38" (465 G) water to V-302 34 Add & stir 2 min for S 64	Assume 50%	149 296	7-D	24 148
PT 9	35 During strike pump into PT 36 Pump in 37 Pump in 38 Stir 10-min with lightning mixer for S 42		482 241 54 57 54 57	169-A 155-A 160-A	24 1482 27 54 27 54
356 10	39 During strike, Run 22" (268 G) water into V-356 40 Turn on steam 41 Add to 30" (366 G) at 178-182°F 82°C 42 Pump PT. mixture from S 38 thru undersurface distributor AFAP 43 Rinse PT with HOT water from hot water mixer & pump in 44 Shut off pump 82°C 45 Stir 30 min at 178-182°F for S 55 46 Do Not Shut Off Agitator				
SV 11	47 When V-349 MTY, rinse in with minimum water then set pump to zero setting 48 When V-343 MTY, rinse in with minimum water then turn off pump motor 49 Stir 60 min at 190-194°F 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 2800-3100 PSI maintain SV at 198-200°F 56 While Homog V-356 to SV, Shut off water valve at stearate pump ASAP				

K1280 REV.

DUP050095249



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



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