

CG 04 CODE KO-909-D PKG.

→ JAN 30 34074
EST. WGT. 1530-1974 *LBS.

STD. HRS. TIME 11 P M (2)

01 YC-16-B 93 4 Lot 33755, 50 #
 01 YC-16-B 93 4 Lot 31567, 200 #
 01 YC-16-B 93 4 Lot 33753, 1050 #

5130

TOTAL WGT 5274# (Req. 0589)

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

01 YC-16-B 93 31747 250 #
 01 YC-16-B 93 33846 2050 #

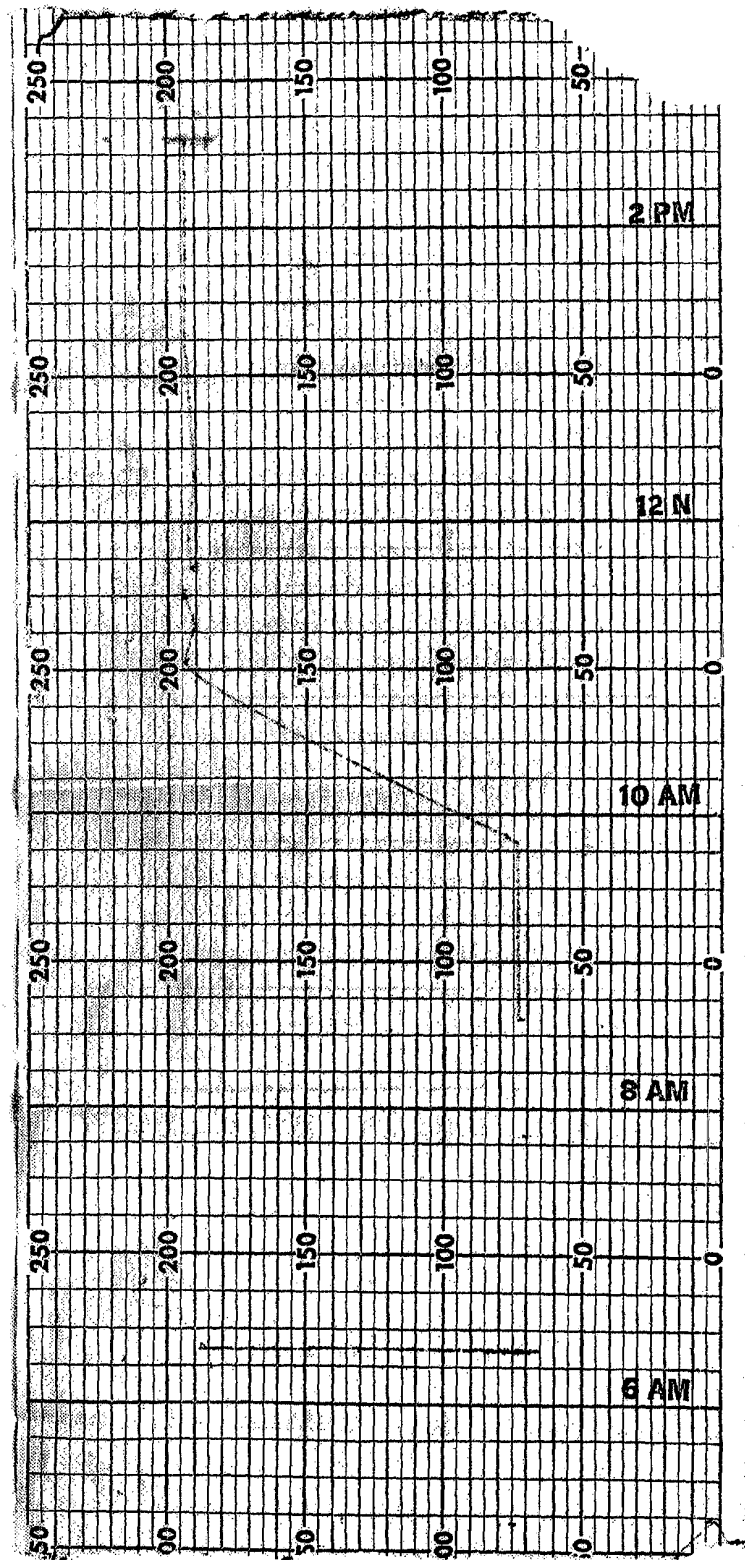
Homog #2

NON-BLEEDING

EQUIPMENT	NAME: KROLOR® ORANGE Y (604-9906)	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 30" (488 G) water into V-211			430
&	1/2 Pump in	480 430	32-D	480
208	3 Dump in	72 x 50	YC-16-B	3600
1	Record: Start: 10:50 A.M. 33755	50		
	Fin: 1:15 P.M. 31567	200		
	75" (12756) 33753	1050		
	4 Adj to 63" (1065 G) 2800-3200 31747	250		
	5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208 33846	2050		
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water.			
	7 Record: V-208 Vol 44" and adj to 54" (1981 G)			
	8 Inspect homog strainer & clean if necessary			
208	9 Run 10" (514 G) water into V-247 Install Temp chart			
&	10 start agitator			
SV	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start 10:30 P.M. 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 and pump thru Homog at 4800-5200 psi			
349	12 While Homog, run 6" (284 G) water into V-349			
&	12 Run #1000# water into V-384 and heat to 110-120°F	2500		2500
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: Be 1.093 (14.3 ± 0.2) (1.091-1.094)			
SV	18 When S 10 Homog complete, adjust SV to 60" (3084 G)			
4	19 Record: pH 10.8 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%	12	7-D	6
	Siphon N-7-D into SV & Record: pH 11.2			
	20 Heat to 190-194°F in 55-65 min and Record: HT 192°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			
&	22 Water in from V-386 M 14 9.38 #/Gal 37.5 Gal		27-D	414
386	23 Stir 15 min or longer			373
5	24 Record: Be 1.020 (13.4 ± 0.1) (1.018-1.020)			

V-247

EQUIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N ^o CODE	ACCT. LBS.
SV 6	2	04	KO-909-D (C)	5274				
	25	When 20 heating complete, Record: pH (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	10:20	2:55				
		V-349	10:05 AM	9:15 A	1:90			
		Record:	Time	V-343	V-349	SV pH	Normal pH	
				Inches	Inches			
		at 20 min	6:25 A	(46) 46	(17) 17	9.8	9.3-10.0	
		40 min	6:45 A	(41) 41	(15) 15	9.8	9.3-10.0	
		1 hr	7:05 A	(37) 37	(13) 13	9.8	9.3-10.0	
		2 hrs	8:05 A	(23) 23	(6) 6	9.7	9.3-10.0	
		3 hrs	9:05 A	(10) 23	(0) 1+	9.7	9.3-10.0	
		Finish	9:50 A	(0)		7.0	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 Assume 78%						
	30	Start in 1 bag				50	27-D 128-A	50
357 7	31	Run 30" (216 G) water into V-357 and heat to 135-140°F						
	32	Dump in and stir to dissolve for S 61						
						477	15-A	477
302 8	33	Add 38" (465 G) water to V-302						
	34	Add & stir 2 min for S 64						
						296	7-D	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	169-A	482
						54	155-A	54
						54	160-A	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 51"						
	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 10:25 AM						
	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						



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