246 24 ~~25~~ 24 Y added to 5V. C.V. MAKING INSTRUCTIONS: BATCH UNIT

D.V.

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		

TO 04 CODE KO-789-B PKG.

JAN 26 34005

WT. WGT. ~~1032-1132~~ LBS.

OK! AP

PH RNG. 10.8 TIME 7:A ~~P~~ M

01	YC-16-B	93	4	Lot 32521 , 50 #	01	YC-16-B	33838	93	2150
01	YC-16-B	93	4	Lot 33751 , 50 #	01	YC-16-B	33910	98	350
01	YC-16-B	93	4	Lot 33841 , 1600#	01	YC-16-B	32769	98	570

5532

Total Weight ~~5332~~# (Req) NON-BLEEDING

FIT		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	530	32-D	530
208	3	Dump in & stir 5 min Pw Lot	84 x 50	YC-16-B	4200
1		Record: Start 3.30 Pw			
		Fin 5.30			
	4	Adj to 70" 1200 G) 3800-3200			
	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 48 " & 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			
&					
SV	10	Pump V-208 thru Homog at 4800-5200 psi into SV-247			
2		Record: Time Start 5.30 p , Total Min 180			
		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			
384	14	Weigh into V-384 & pump to V-349	~~2930~~ 2545	32-D	~~2930~~ 2545
3	15	Run ± 1000 # water into V-384 & pump to V-349			
	16	Adj V-349 to ~~80" (1400 G)~~ & stir 15 min or longer 22" (1040 G)			
	17	Record: °Be ~~11.0 (10.0 ± 0.2)~~ (1.082 - 1.086) g/mL			
SV	18	When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19	Record: pH 10.2 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	36	7-D	18
		Siphon N-7-D into SV & Record: pH 11.3			
	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 90 52" (1430 G)			
343	21	While heating SV, run ~~70" (1920 G)~~ water into V-343			
&	22	Meter in from V-386 M 13 , 2433 #/Gal 42.5 Gal		27-D	~~440~~ 440
386	23	Stir 15 min or longer			
5	24	Record: °Be ~~1.0 (2.5 ± 0.1)~~ (1.019 - 1.021) g/mL			

NT

V-247

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 10.2 (9.6-10.2)			
	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 10:40 pm / 3:45 / 305.			
		V-349 / 2:40A / 240			

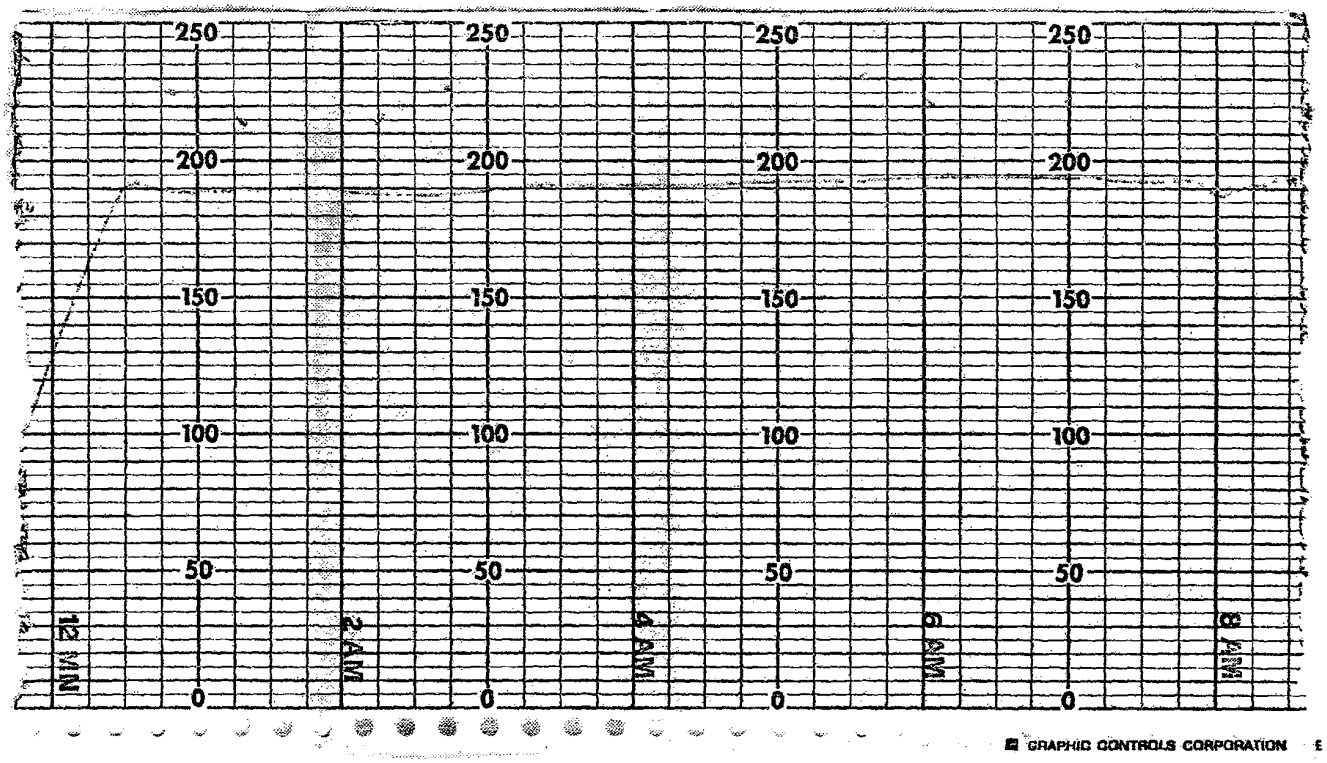
Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min	11:00	(~~66~~) 49	(~~27~~) 20	10.0	9.3-10.0
40 min	11:20	(~~60~~) 45 +	(~~24~~) 18 18	10.0	9.3-10.0
1 hr	11:40	(~~53~~) 41 +	(~~21~~) 16 16	10.0	9.3-10.0
2¼ hrs	12:55	(~~34~~) 25 25+	(~~11~~) 8 8	9.8	9.3-10.0
3½ hrs	2:10	(~~13~~) 9 6	(0) 3	9.8	9.3-10.0
Finish	2:55	(0) 4		6.7	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

NOTE	30A	Add 1 drum at end of strike	570	K0909D	570
357 7	30	Run 33" (238 G) water into V-357 & heat to 135-140°F			
	31	Dump in & stir to dissolve	530	15-A	530
302 8	32	Add 42" (514 G) water to V-302			
	33	Add & stir 2 min USE ELECTRIC PUMP → Assume 50%	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 4:00 Am			
	37	Run in V-357 from S 31 & stir 5 min			
	38	Record: pH 3.1 (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 5.8 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.2 Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	6	7-D	3
		Siphon N-7-D into SV			
	41	Pour in & stir 15 min	~~50~~ 25	978-A	~~25~~ 50
	42	Stop agitator			

START	FIN	OPTR
7:00 AM	8:00 PM	320-144
8:00 PM	11:00 PM	438
11 P.M.	1:45 A.M.	101

DUP050094170



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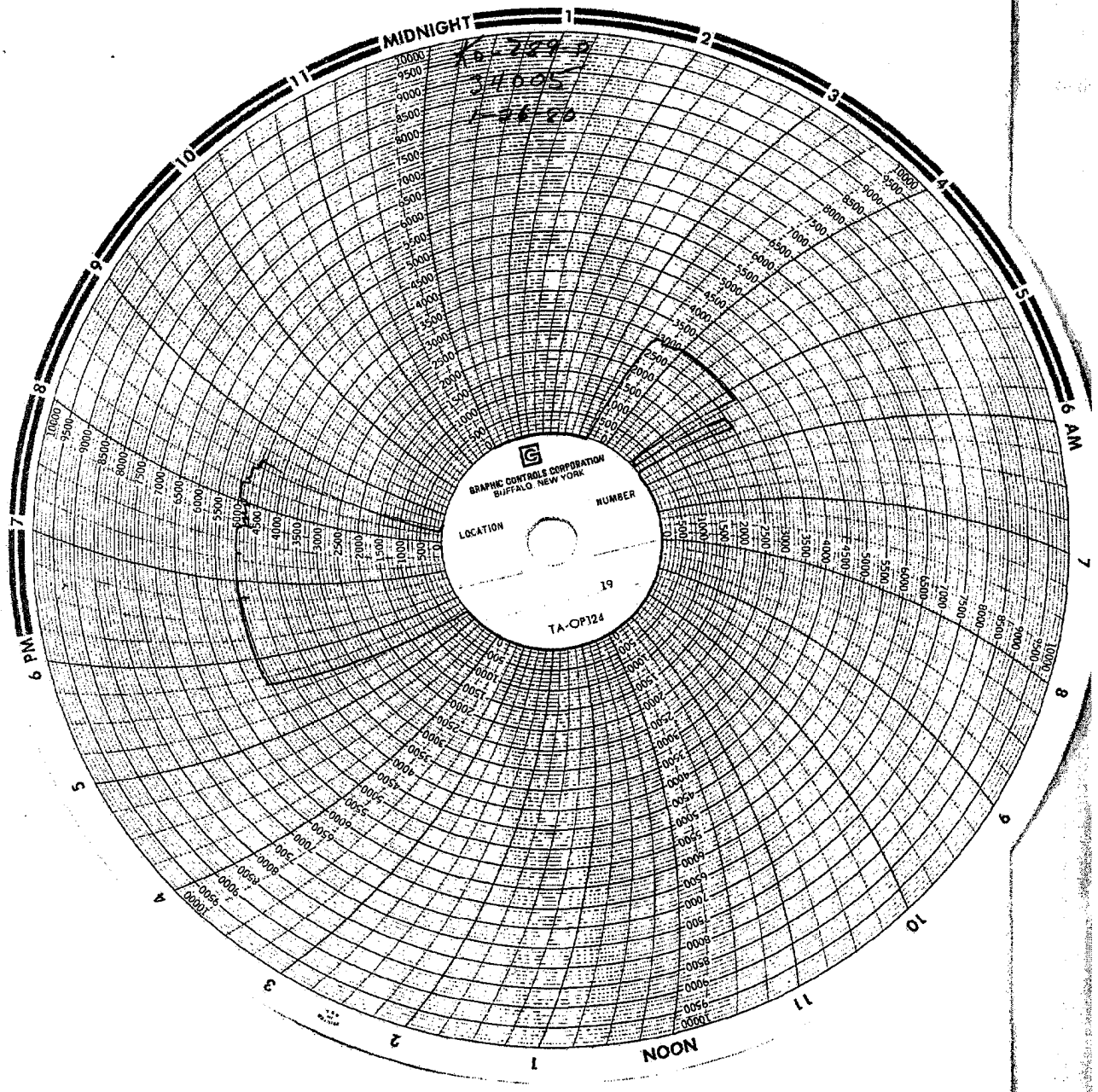

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