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

C 04 CODE KO-789-D PKG.

JAN 16 33857

WST 509 ~~1132~~ LBS.

10.8 TIME 11 P 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

AP

01 YC-16-B 93 4 Lot 33610, 1050#

01 YC-16-B 93 4 Lot 33608, 750#

01 YC-16-B 93 4 Lot 33608, 300#

V-247 'M'T' 8:30 AM

Total Weight ~~5332#~~ 2609 (Req 0551)

Homog #2

NON-BLEEDING

ENT		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	1	Run 60" (990 G) water into V-211			265
&	2	Weigh in drum & pour in	265 ~~530~~	32-D	~~530~~
208	3	Dump in & stir 5 min Lot 42	~~84~~ x 50	YC-16-B	~~4200~~
1		Record: Start 3:15 P.M. 33610	1050#		2100
		Fin 4:30 P.M. 33609	750#		
		33608	300#		
	4	Adj to 70" 1200 G)			
	5	Pump V-211 thru Homog #2 at ~~1800-2200~~ 2800-3200 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 45" & 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-			
2		Record: Time Start 8:40 AM Total Min 155			
		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" (1040G)			
	17	Record: °Be 1.042 ~~(20.0 ± 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 10.8 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) 11.1 Assume 50%	6	7-D	3
		Siphon N-7-D into SV & Record: pH			
	20	Heat to 190-194°F in 55-65 min & Recrod: HT 185 °F & Rec 192 °F			
		NOTE: Strike must be started immediately on completion of heating			
343	21	While heating SV, run ~~70" (1920 G)~~ 52" (1430G) 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			
5	24	Record: °Be 1.010 ~~(2.5 ± 0.1)~~ (1.008-1.009) g/ml			

V-247

PAGE 2 CG 04 CODE KO-789-D (I) EST. WGT. 5332 LBS.

EQPMENT			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 8 setting (± 255 minutes) 6.5			
	27	Set V-349 silicate pump at 12 setting (± 210 minutes) 5.3			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start Fin Min V-343 2:15 P 6:40 P 265 V-349 3:45 P 210			

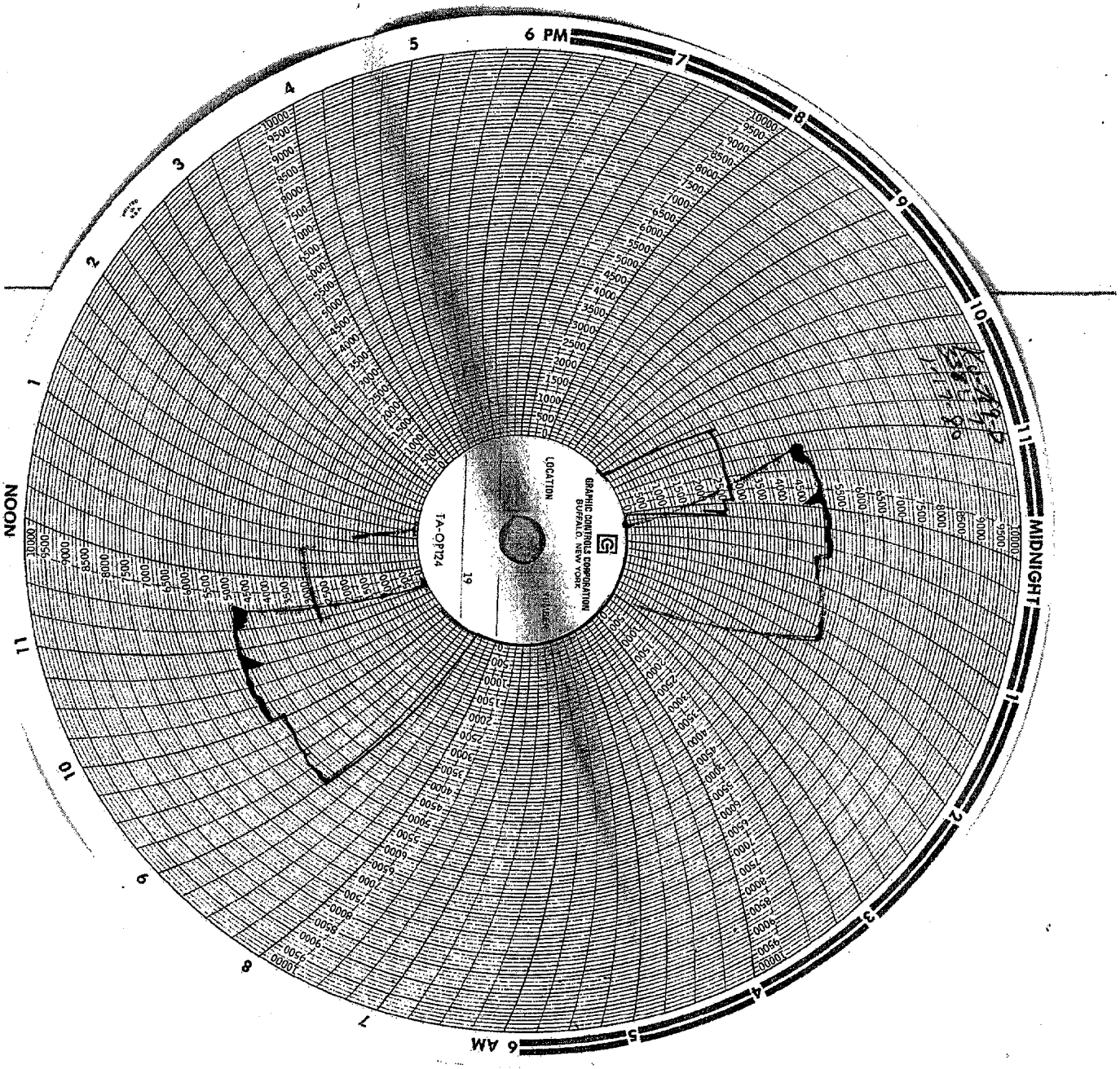
Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
	2:15				
at 20 min	2:35	(56) 49	(27) 20	10.0	9.3-10.0
40 min	2:55	(68) 45+	(24) 18	10.0	9.3-10.0
1 hr	3:15	(55) 41-	(21) 16	9.9	9.3-10.0
2¼ hrs	4:30	(34) 25	(11) 8	9.9	9.3-10.0
3½ hrs	5:45	(12) 9	(0)	9.9	9.3-10.0
Finish	6:30	(0)		7.1	7.5- 8.5

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			265
7	31	Dump in & stir to dissolve ✓	265 530	15-A	530
302	32	Add 42" (514 G) water to V-302			
8	33	Add & stir 2 min Assume 50%	167 330	7-D	165 82
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 6:30 P			
	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 5.4 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.4			
		Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
		Siphon N-7-D into SV			
	41	Pour in & stir 15 min ✓	15 25	978-A	25
	42	Stop agitator			

START	FIN	OPTR
10:30P	11:00P	126-201
7:06AM	3:00PM	235-327
3:00P	7:15P	201-203

DUP050095336



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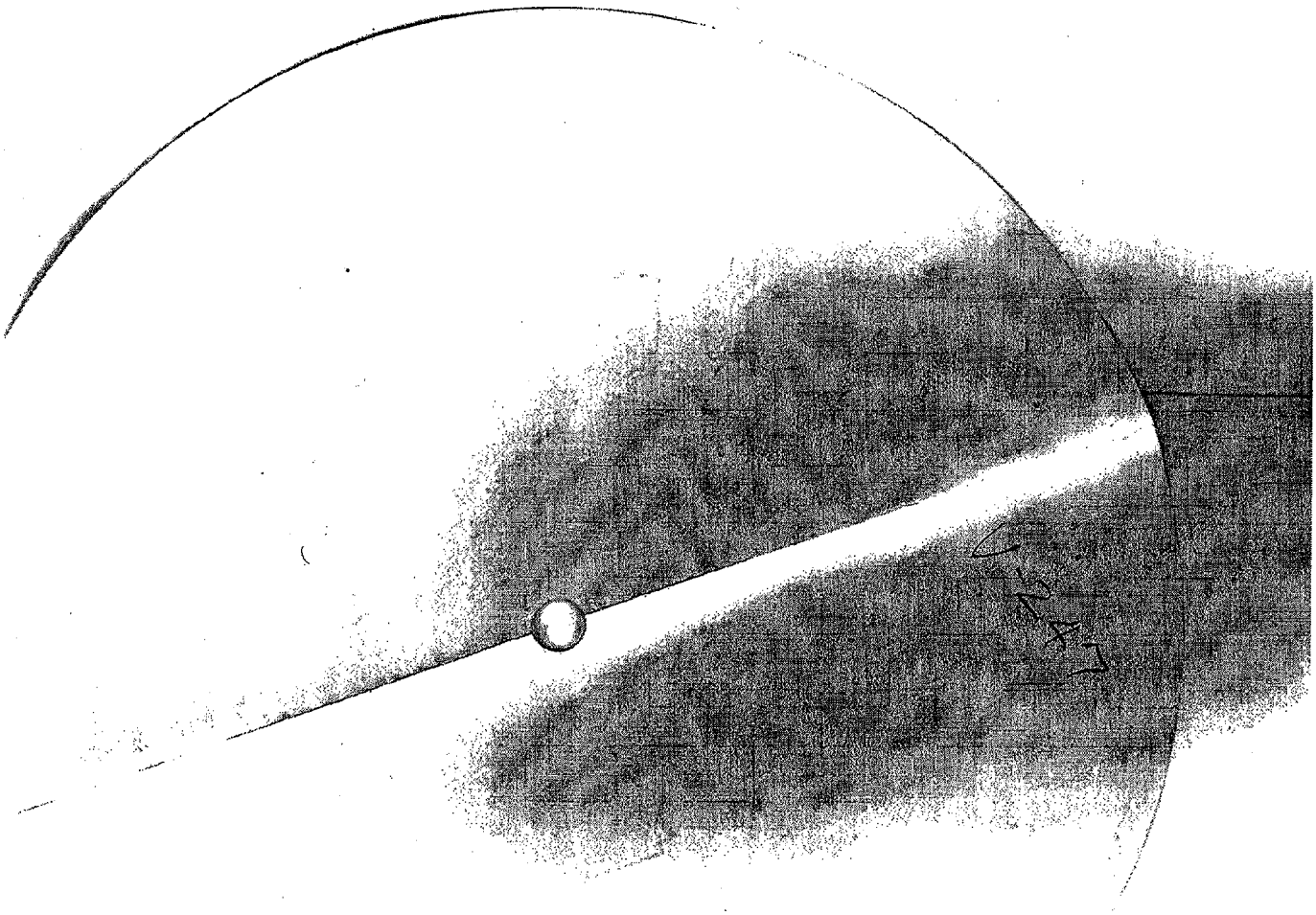

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