

APR 25 1980

MAY - 5 1980

MAKING INSTRUCTIONS: BATCH UP

CG 04 CODE KO-909-D PK05

C.V.

D.V.

EST. WGT. 1596 LBS.

STD. HRS. TIME 7 P M

01 YC-16-B 93 4 Lot 34782 450

01 YC-16-B 93 4 Lot 34781 700

01 YC-16-B 93 4 Lot 34574 2550

5296 TOTAL WGT 5274 (Req.)

PROCESSES		APPROVED
() KO-909-D	(C)	WIK 1-27-7
()	()	DCG 1-30-7
()	()	MTW 2-27-7
()	()	
TYPED BY		
NSA 3-13-78		

INSTRUMENT		NAME	KROLODOR ORANGE Y	USE LBS.	N CODE	ACC LBS
211	1	Run 30" (488 G) water into V-211. SET AGITATOR ON HIGH SPEED		480	32-D	480
208	2	Pour in				
1	3	Dump in				
		Record: Start: 12:00 PM	34782	74 x 50	YC-16-B	3600
		Fin: 1:45 PM	34574	51 x 50		3700
		Adj to 60" (1065 G)	2800-3200	34781	14 x 50	
	4	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				
	7	Record: V-208 Vol 39 " and adj to 54" (1981 G)				
	8	Inspect homog strainer & clean if necessary				
SV	9	Run 10" (514 G) water into V-245 Install Temp chart & start agitator				
2	10	Pump V-208 thru Homog at 4800-5200 psi into SV	345			
		Record: Time Start 2:30 PM Total Min 18.0				
		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				
384	13	Run #1000# water into V-384 and heat to 110-120°F		2500		
3	14	Weigh into V-384 and pump to V-349		2775	32-D	2775
	15	Run #1000# water into V-384 and pump to V-349		2500		
	16	Adj V-349 to 19" (899 G) and stir 15 min or longer				2500
	17	Record: 98.1 1.072 (1.072-1.074)				
SV	18	When S 10 Homog complete, adjust SV to 60" (3084 G)				
4	19	Record: pH 11.1 and add to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%			7-11	
		Siphon N-7-D into SV & Record: pH 11.1				
	20	Heat to 190-194°F in 55-65 min and Record: HT 190°F and Rec 190°F				
		NOTE: Strike must be started immediately on completion of heating				
43	21	While heating SV, run 49" (1348 G) water into V-343				
16	22	Meter in from V-386 M 21 1610 #/Gal 33.6 Gal 2.6			27-D	370
	23	Stir 15 min or longer				
	24	Record: 98.1 1.018 (3.4-0.1) (1.018-1.020)				

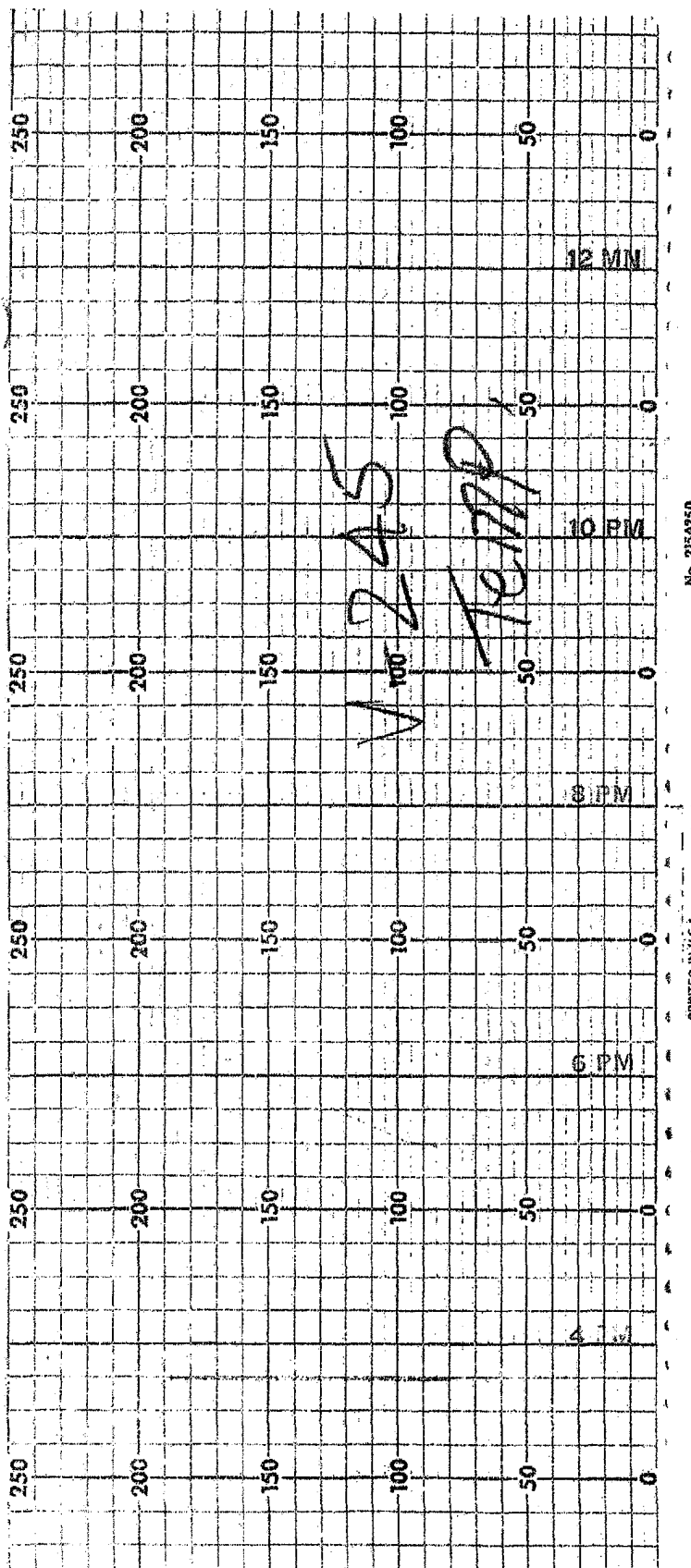
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V-24525 1980

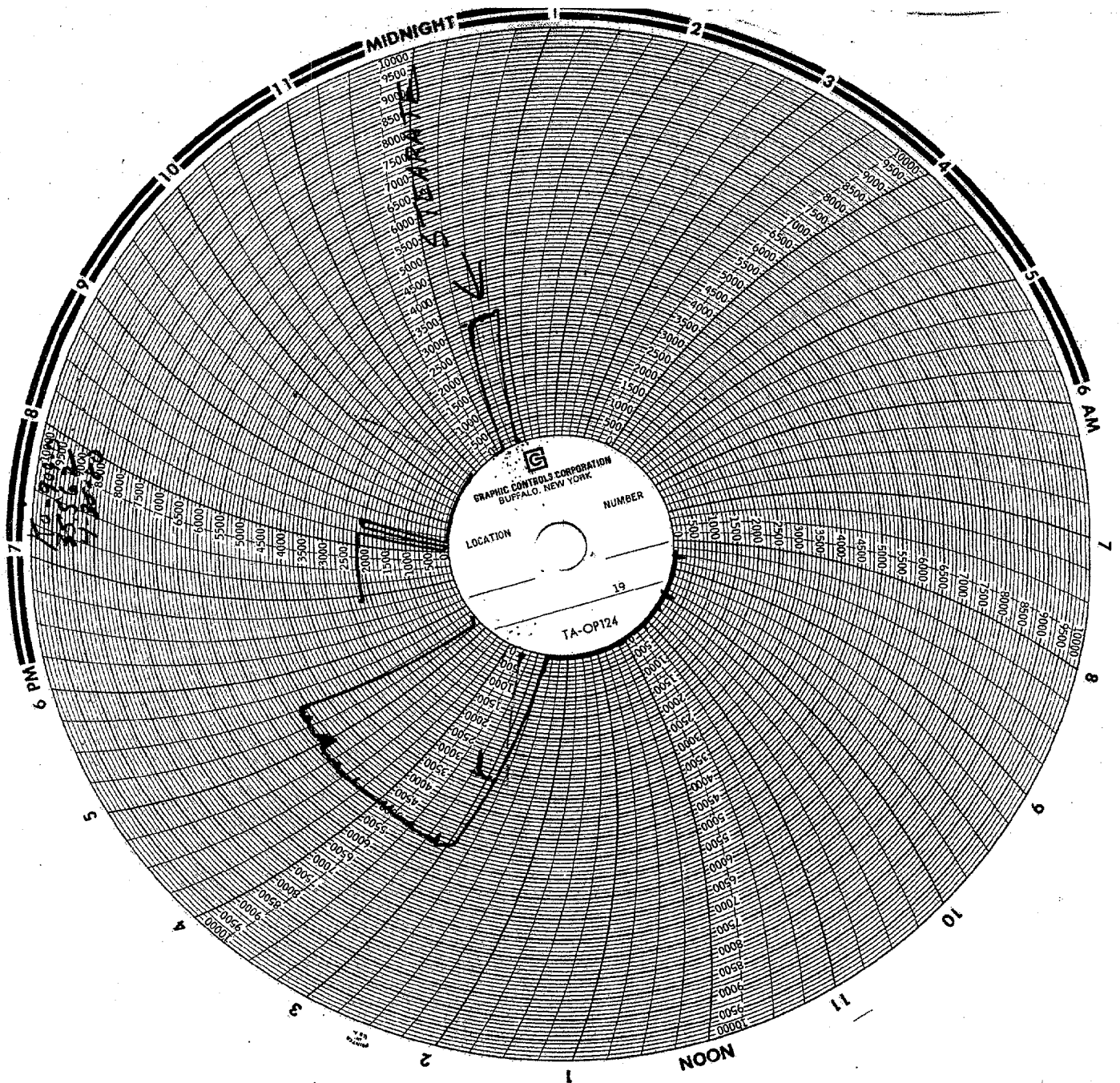
MENT	PAGE 3 CG 04 CODE K0-909-D (C) EST. WGT. 5274 LBS.	USE LBS	N CODE	AC LB															
57	When Homog complete, rinse in V-356 with hot water from hot water mixer																		
58	When S57 complete, turn off Homog & stearate pump																		
59	Stir 5 min at 198-200°F																		
60	Shut off steam																		
61	Run in V-356 from S 32 and stir 5 min																		
62	Record: pH 3.5 (3.4-3.8)																		
63	If necessary, adj pH to 3.4-3.8 (Downward only) and Record: pH		15-A																
64	Run in N-7-D from S 34 in 4-6 min and stir 5 min																		
65	Record: pH 7.0 (6.2-6.4) and if necessary, adj to pH 6.2-6.4 and Record: pH 6.4 Assume 78% 12 27.0																		
	(Dilute 10 parts water to 1 part N-7-D) Assume 50% 7.0																		
	Siphon N-7-D into SV																		
66	Do Not Stop Agitator																		
<table><tr><th>START</th><th>FIN</th><th>OPTR</th></tr><tr><td>7:00 P</td><td>11:00 P</td><td>240-126</td></tr><tr><td>7:00 P</td><td>3:00 P</td><td>223-282</td></tr><tr><td>7:00 P</td><td>11:00 P</td><td>126-120</td></tr><tr><td>11:00 P</td><td>2:00 AM</td><td>235</td></tr></table>					START	FIN	OPTR	7:00 P	11:00 P	240-126	7:00 P	3:00 P	223-282	7:00 P	11:00 P	126-120	11:00 P	2:00 AM	235
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35-66
Blank
Q40 200



N32369.01

DUP050457736



N32369.02

DUP050457737

V-245

DUP050457738