

CG 03 CODE KY-787-D PKG.

JAN 30 34107

EST. WGT. 1980-2230 LBS.

STD. HRS. TIME M

14 YC-2-B 93 4 Lot 24470, 5000 #

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Total Wgt. 7230# (REQ 599)

D.V.		PROCESSES	APPROVED BY
()	KY-787-D	(S)	EWK 10-19-77
()	Alternate	()	DCG 10-25-77
()		()	MTW 10-26-77
()		()	FWP 02-01-79
TYPED BY			
emw020179			

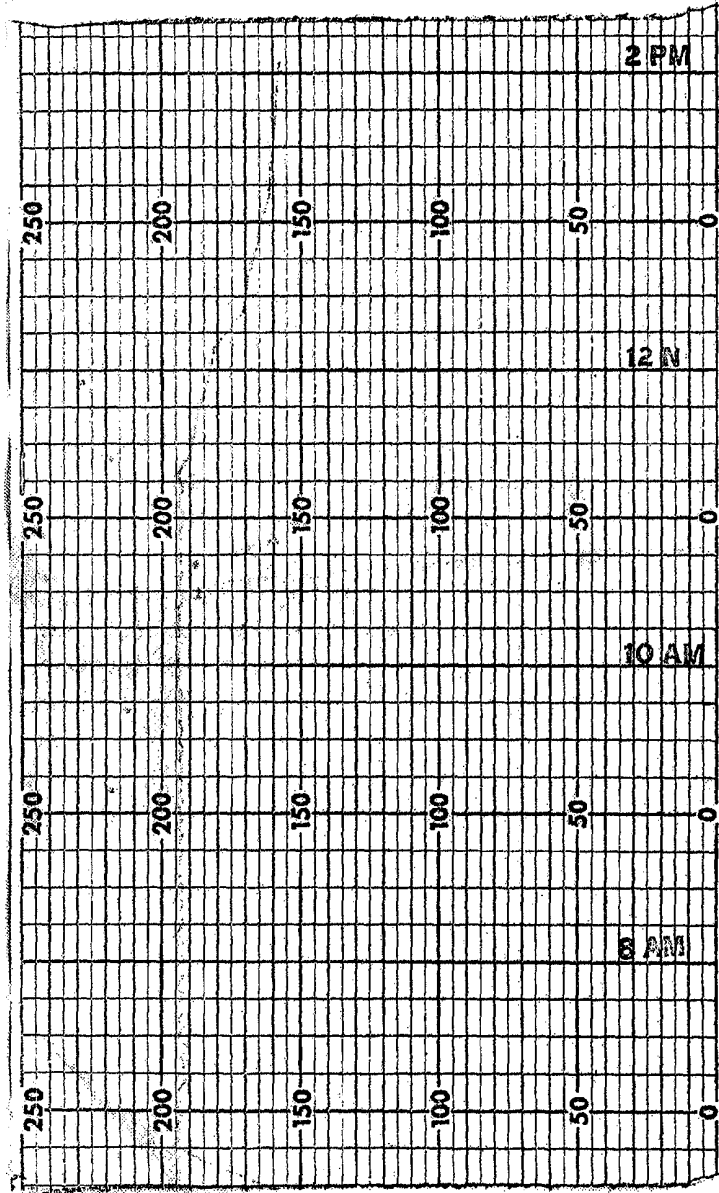
Homog #4 - 1st Pass
" #4 - 2nd "

NON-BLEEDING

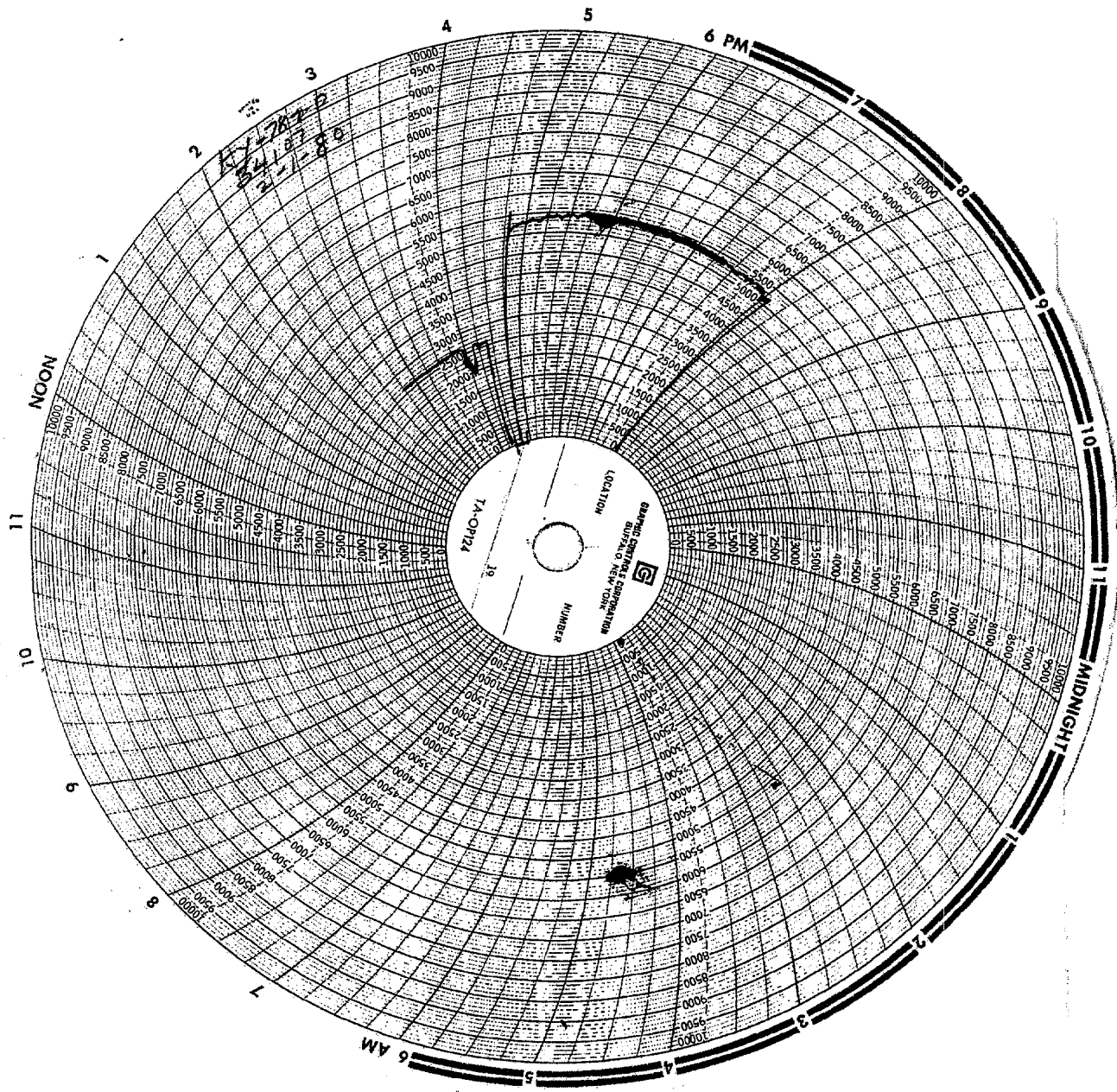
IPMENT	NAME:	USE LBS.	N CODE	ACCT, LBS.
203	1 Run 50" (827 G) water into V-203			
&	2 Weigh in drum & pour in	670	32-D	670
205	3 Dump in & stir 5 min	100 x 50	YC-2-B	5000
1	Record: Start 12:05 PM			
	Fin 1:45 PM			
	75" (1275 G)	24470	5000	
	4 Adj to 80" (1360 G)			
	5 Pump V-203 thru Homog at 2400-2600 psi into V-205			
	6 When V-203 MTY, wash color thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7 Record: V-205 V-263 " & adj to 54" (1900 G)			
	8 Inspect Homog strainer & clean if necessary			
SV	9 Run 2" (200 G) water into V-262 & install temp chart			
&	& start agitator			
262	10 Pump V-205 thru Homog at 4800-5200 psi into SV-			
2	Record: Time Start 4:45 PM Total Min 190			
	NOTE: If Homog pressure falls below 4800 psi 3-way valve will recirculate slurry to V-205			
	11 When V-205 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	3830	32-D	3830
3	15 Run ± 1000 # water into V-384 & pump to V-349			
	16 Adj V-349 to 25" (1163 G) & stir 15 min or longer			
	17 Record: 986' 1.114 (15.2 ± 0.2) (1.113-1.117)			
	g/ml			
SV	18 When S 11" Homog complete, adj SV to 26" (2100 G)			
4	19 Record: pH 10.7 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%			
	Siphon into SV & Record: pH 11.1			
	20 Heat to 190-194°F in 35-45 min (V-262) or in 55-65 min (V-243, 244, 246, 247) &			
	Record: HT 94 °F & Rec 187 °F			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 56" (1520 G) water into V-343			
&	22 Meter in from V-386 M 14-, 7.38 #/Gal 61.1 Gal		27-D	573
386	23 Stir 15 min or longer			
5	24 Record: 986' 1.027 (7.1 ± 0.1) (1.027-1.028)			
	g/ml			

V-262

EQUIPMENT	PAGE 2	CG03	CODE KY-787-D (S)	EST. WGT.	7230 LBS.	USE LBS.	N CODE	ACC LB
SV	25	When S 20 heating complete, Record: pH <u>10.1</u> (9.6-10.2)						
	26	Set V-343 acid pump at 69 setting (± 255 min)						
	27	Set V-349 silicate pump at 60 setting (± 210 min)						
	28	Immediately meter V-343 & 349, maintain SV at 190-194°F during strike						
	29	Record:	Start	Fin	Min			
		V-343	<u>9:40</u>					
		V-349	<u>10</u>					
		Record:	Time	V-343	V-349	SV	Normal	
						pH	pH	
		at 20 min	<u>10:00</u>	(52) <u>53+</u>	(22) <u>+</u>	<u>10.0</u>	9.3-10.0	
		40 min	<u>10:20</u>	(48) <u>50-</u>	(20) <u>+</u>	<u>9.9</u>	9.3-10.0	
		1 hr	<u>10:40</u>	(43) <u>45+</u>	(18) <u>+</u>	<u>9.9</u>	9.3-10.0	
		2 1/2 hrs	<u>11:55</u>	(27) <u>27+</u>	(7) <u>+</u>	<u>9.7</u>	9.3-10.0	
		3 1/2 hrs	<u>1:10</u>	(10) <u>11</u>	(0) <u>1</u>	<u>9.7</u>	9.3-10.0	
		Finish	<u>1:55</u>	(0) <u>-</u>	(0) <u>-</u>	<u>7.5</u>	7.5-8.5	
		NOTE: (1) If pH not as specified, notify Supervisor & note in log						
		(2) If final pH is above 8.5, adj pH to 7.5-8.5 & Record: pH Assume 78%						
		27-D						
330	30	Run 22" (431 G) water into V-330 & heat to 160-170°F						
7	31	Add in 12-13 min				700	530-A	700
	32	Stir 5 min & Record: pH <u>10.2</u> (9.5-10.5)						
	33	Stir 20 min or longer to dissolve for S 46						
357	34	Run 29" (210 G) water into V-357 & heat to 135-140°F						
8	35	Dump in & stir to dissolve for S 42				350	15-A	350
302	36	Run 36" (440 G) water into V-302						
9	37	Add & stir 2 min for S 44			Assume 50%	380	7-D	190
SV	38	When V-349 MTY, rinse in with minimum water then set pump to zero setting						
10	39	When V-343 MTY, rinse in with minimum water then turn off pump motor						
	40	Turn off steam						
	41	Sift in				250	128-A	250
	42	Run in V-357 from S 35 & stir 5 min						
	43	Record: pH <u>3.9</u> (3.7-4.2)						
	44	Run in N-7-D from S 37 in 10-12 min & stir 5 min						
	45	Record: pH <u>9.6</u> (9.0-9.5) & if necessary, adj to pH 9.0-9.5 &						
		Record: pH			Assume 78%		27-D	
		(Dilute 10 parts water to 1 part N-7-D)			Assume 50%		7-D	
		Siphon N-7-D into SV						
	46	Run in V-330 thru 20 mesh screen & stir 20 min						
313	47	Run 15" (222 G) water into V-313 & dump in				270	20-A	270
11	48	Stir 5 min to dissolve for S 49						
SV	49	Run V-313 into SV in 15-20 min						
12	50	Stir 15 min						
	51	Record: pH <u>9.3</u> (9.0-10.0)						
	52	Stop agitator <u>Do not stop V-262</u>						
		Step	V-2	3PM	V-243, 244, 246, 247			
		9	2"	4"				
		18	26"	50"				
		START	FIN	OPTR				
		<u>3:00</u>	<u>11:00 P</u>	<u>235-373</u>				
		<u>11</u>	<u>4:30 A</u>	<u>282-438</u>				



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



V-262