

246, (247)

C.V.

D.V.

04 CODE KO-789-D PKG.

JAN 21 33942

WGT 762 1132 LBS.

10.8

TIME

01 YC-16-B 93 4 Lot 33478, 150#

01 YC-16-B 93 4 Lot 33474, 800#

01 YC-16-B 93 4 Lot 33580, 2150#

Total Weight 5332# (Req 0568)

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		

NAME		USE LBS.	N CODE	ACCT. LBS.
KROLQR® ORANGE Y				
211	1 Run 60" (990 G) water into V-211			390
208	2 Weigh in drum & pour in	390 530	32-D	530
1	3 Dump in & stir 5 min	84 x 50	YC-16-B	4200
	Record: Start 2:45 P.m.	Lot 62 33478		3100
	Fin 9:45 P.m.	33474		
		33580		
	4 Adj to 70" (1200 G)	2800-3960		
	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 4 & 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 8:30 Total Min 145			
	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			
384	13 Run ± 1000# water into V-384 & heat to 110-120°F	1880		1880
3	14 Weigh into V-384 & pump to V-349	2930	32-D	2930
	15 Run ± 1000# water into V-384 & pump to V-349			
	16 Adj V-349 to 30" (1100 G) & stir 15 min or longer 22" (1040 G)			
	17 Record: 0Be 1.062 (1.061-1.064)			
SV	18 When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19 Record: pH 10.5 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		7-D	10
	20 Siphon N-7-D into SV & Record: pH 11.2			
	Heat to 190-194°F in 55-65 min & Record: HT 190 OF			
	& Rec 190 OF			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 70" (1920 G) water into V-343			
386	22 Meter in from V-386	M 10, 9.50#/Gal	30.5 Gal	27-D 440
5	23 Stir 15 min or longer			290
	24 Record: 0Be 1.015 (2.5 ± 0.1) (1.013-1.015)			

V-247

MENT	PAGE 2	CG 04	CODE K0-789-D (I)	EST. WGT.	5332 LBS.	USE LBS.	N CODE	ACCT LBS.
SV	25	When S 20 heating complete, Record: pH <u>10.1</u> (9.6-10.2)						
6	26	Set V-343 acid pump at <u>85</u> setting (± 255 minutes) <u>65</u>						
	27	Set V-349 silicate pump at <u>78</u> setting (± 210 minutes) <u>54</u>						
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike						
	29	Record:	Start	Fin	Min			
		V-343	<u>2:45 P</u>	<u>1:15 A M</u>	<u>2:10</u>			
		V-349		<u>6:30 P M</u>	<u>2:25</u>			
		Record:	Time	V-343	V-349	SV	Normal	
				in	in	pH	pH	
		at 20 min	<u>3:05 P</u>	<u>(85) 49</u>	<u>(28) 20</u>		<u>9.3-10.0</u>	
		40 min	<u>3:25 P</u>	<u>(60) 45-46</u>	<u>(24) 18-19</u>	<u>9.8</u>	<u>9.3-10.0</u>	
		1 hr	<u>3:45 P</u>	<u>(55) 41-42</u>	<u>(25) 16-16</u>	<u>9.8</u>	<u>9.3-10.0</u>	
		2 1/2 hrs	<u>3:00 P</u>	<u>(34) 25-28</u>	<u>(18) 8-8</u>	<u>9.8</u>	<u>9.3-10.0</u>	
		3 1/2 hrs	<u>6:15</u>	<u>(12) 9-13</u>	<u>(0) 0</u>	<u>9.8</u>	<u>9.3-10.0</u>	
		Finish	<u>7:00</u>	<u>(0) 0</u>	<u>0</u>	<u>6.8</u>	<u>7.5-8.5</u>	
		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						<u>390</u>
7	31	Dump in & stir to dissolve				<u>390</u>	15-A	<u>530</u>
302	32	Add 42" (514 G) water to V-302						
8	33	Add & stir 2 min				Assume 50%	<u>240</u>	7-D <u>330</u>
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	<u>1:15 P M</u>				
	37	Run in V-357 from S 31 & stir 5 min						
	38	Record: pH <u>3.7</u> (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 <u>6.2</u> (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH				Assume 77%	<u>10</u>	27-D <u>7</u>
		(Dilute 10 parts water to 1 part N-7-D)				Assume 50%	7-D	
		Siphon N-7-D into SV						
	41	Pour in & stir 15 min					<u>37</u>	978-A <u>25</u>
	42	Stop agitator						
		START	FIN	OPTR				
		<u>11:00 P M</u>	<u>7:00 P M</u>	<u>320-144</u>				
		<u>7:00 A</u>	<u>3:10 P M</u>	<u>235</u>				
		<u>3:00 P M</u>	<u>4:45 P M</u>	<u>381.438</u>				



