

246 (247)

C.V.

D.V.

04 CODE KO-789-D PKG.

~~33974~~ 33974 JAN 23

WGT 762 1132 LBS.

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			
EIMW020579			

RS. 10.8

TIME 11 PM 24A M

G1 YC-16-B 93 4 Lot 33752, 900#

D1 YC-16-B 93 4 Lot 32521, 950#

O1 YC-16-B 93 4 Lot 33654, 1250#

3862

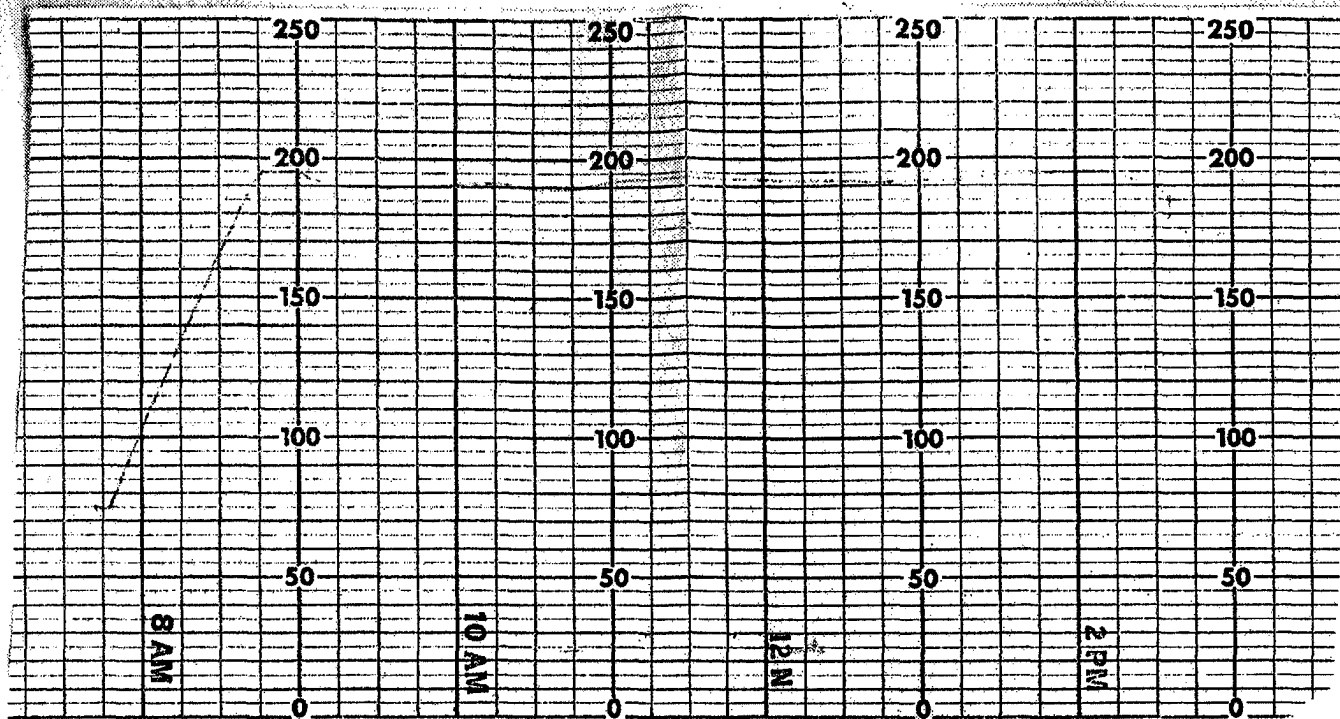
Total Weight 5332# (Req 0574)

NON-BLEEDING

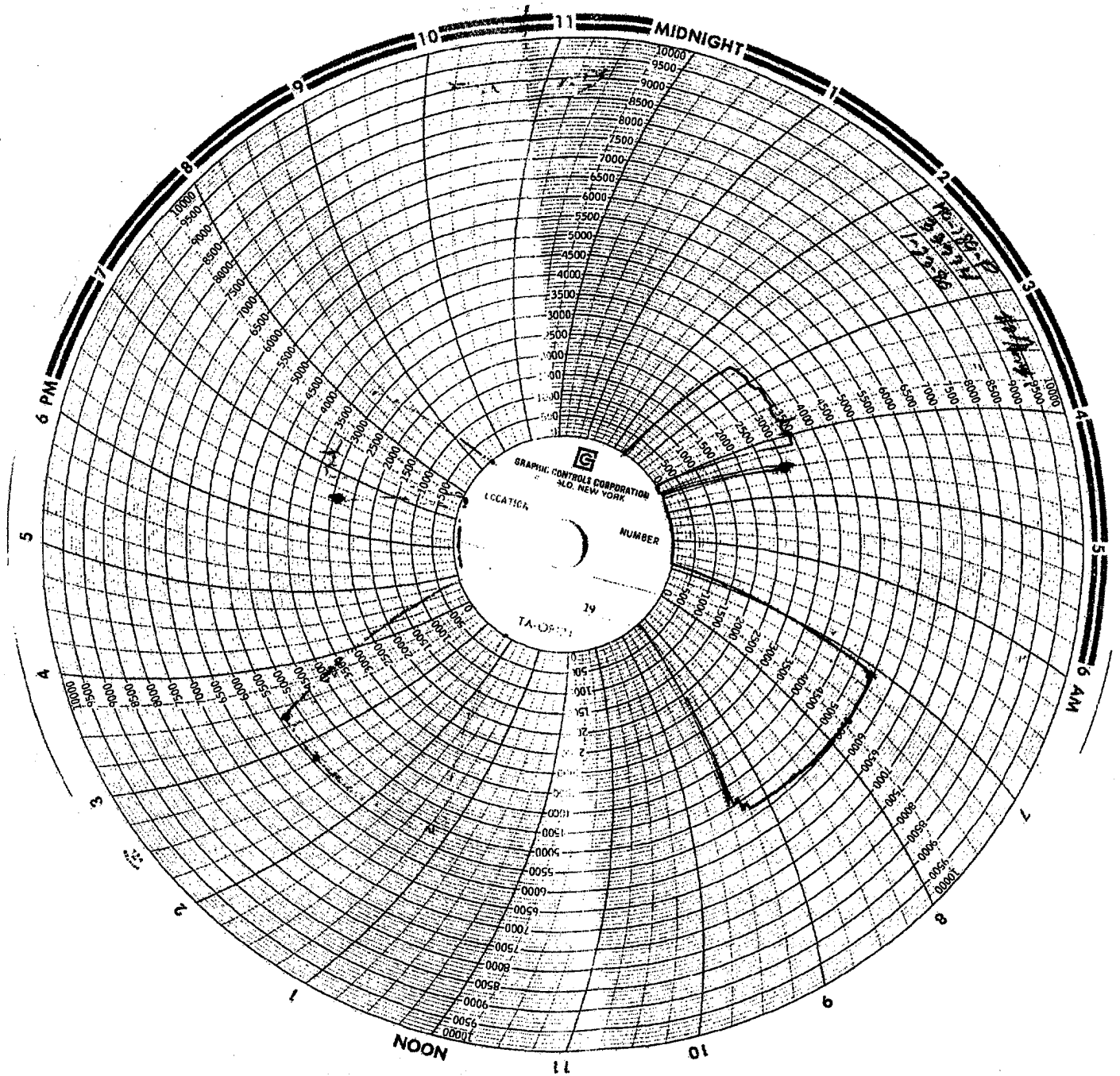
Homog#2

NAME: KROLOR® ORANGE Y		USE LBS.	N CODE	ACCT. LBS.
211	1 Run 60" (990 G) water into V-211			390
&	2 Weigh in drum & pour in	390 530	32-D	530
208	3 Dump in & stir 5 min	Lot 62 84 x 50	YC-16-B	4200
1	Record: Start 12:41 A.M.	53752	900	3100
	Fin 1:15 A.M.	32521	950	
		33654	1250	
	4 Adj to 70" (1200 G)	2800-3200	3100	
	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 41 " & 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			
&	10 Pump V-208 thru Homog at 4800-5200 psi into SV-			
SV	2 Record: Time Start 7:10 A Total Min 160			
	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	32-D	2930
3	15 Run ± 1000 # water into V-384 & pump to V-349	1880		1880
	16 Adj V-349 to 30" (1400 G) & stir 15 min or longer 30" (1400 G)			
	17 Record: 0.95 1.06 310.0 ± 0.2 (1.061-1.064)			
SV	18 When S 10 Homog complete, adj SV to 45" (2300 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%	22	7-D	11
	Siphon N-7-D into SV & Record: pH 11.1			
20	Heat to 190-194°F in 55-65 min & Record: HT 194 OF			
	& Rec 186 OF			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 70" (1920 G) water into V-343			
&	22 Meter in from V-386 M10 7.50 #/Gal 30.5		27-D	440
386	23 Stir 15 min or longer			290
5	24 Record: 0.95 1.01 32.5 ± 0.1 (1.013-1.015)			

COMPONENT	PAGE 2 CG 04 CODE K0-789-D (I) EST. WGT.	5332 LBS.	USE LBS.	N CODE	ACC'T LBS.
SV	25 When S 20 heating complete, Record: pH 10.0 (9.6-10.2)				
6	26 Set V-343 acid pump at 25 setting (± 255 minutes) 65				
	27 Set V-349 silicate pump at 22 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 12:40 5:15 PM 275				
	V-349 12:40 4:25 PM 220				
	Record: Time V-343 V-349 SV Normal				
	12:40 54 in 22 in pH pH				
	at 20 min 1:00 (58) 49.50 (87) 20 9.9 9.3-10.0				
	40 min 1:20 (58) 45.46 (84) 18 9.8 9.3-10.0				
	1 hr 1:40 (58) 41.42 (81) 16 9.8 9.3-10.0				
	2 1/4 hrs 2:55 (58) 25.27 (81) 8.7 9.3-10.0				
	3 1/2 hrs 4:10 (58) 21.13 (81) 11/2 9.4 9.3-10.0				
	Finish 4:55 (0) 2 7.3 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	
352	30 Run 33" (238 G) water into V-357 & heat to 135-140°F				376
	31 Dump in & stir to dissolve		370.530	15-A	530
302	32 Add 42" (514 G) water to V-302				
8	33 Add & stir 2 min		Assume 50% 240 230	7-D	165
SV	34 When V-349 MTY, rinse in with minimum water then set pump at zero setting				100
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 5:15 PM				
	37 Run in V-357 from S 31 & stir 5 min				
	38 Record: pH 3.4 (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 6.3 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH		Assume 77%	27-D	
	(Dilute 10 parts water to 1 part N-7-D)		Assume 50%	30 7-D	15
	Siphon N-7-D into SV				
	41 Pour in & stir 15 min		37.25	978-A	25
	42 Stop agitator				37
	START FIN OPTR				
	7:08 PM 3:00 PM 7:35				
	3:08 PM 4:40 PM 4:09				



CONTROLS CORPORATION BUFFALO, NEW YORK



V-247