

S.V. 246, 247 (245) C.V.

D.V.

CG 04 CODE KO-909-D PKG.

→ JAN 13 33795
EST. WGT. 812 1674 LBS.

STD. HRS. TIME 7A

01 YC-16-B 93 4 Lot 28821 50 #
 01 YC-16-B 93 4 Lot 28821 50 #
 01 YC-16-B 93 4 Lot 33475 800 #

TOTAL WGT 527.1 (Req.)

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

EQUIPMENT		NAME: KROLOD ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	1	Run 30" (408 G) water into V-211			
8	2	Pour in	480 240	32-D	480 240
208	3	Dump in Lot 36 30 x 50 VC-16-B			3600
1		Record: Start: 8.00 Fin: 8.30 75" (1275 G)			1800
	4	Adj to 63" (1065 G) 2800-3200			
	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			
	7	Record: V-208 Vol 46 " and adj to 54" (1981 G)			
	8	Inspect homog strainer & clean if necessary			
208	9	Run 10" (514 G) water into V-245 Install Temp chart			
8		& start agitator			
SV	10	Pump V-208 thru Homog at 4800-5200 psi into SV			
2		Record: Time Start 12.35 PM Total Min 130			
		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			
8	13	Run #1000# water into V-384 and heat to 110-120°F	1388		1388
384	14	Wash into V-384 and pump to V-349	2775	32-D	2775
3	15	Run #1000# water into V-384 and pump to V-349			
	16	Adj V-349 to (19") (899 G) and stir 15 min or longer			
	17	Record: Be 1.05 (14.3 ± 0.2) 1.057 (1.061) g/ml			
SV	18	When S 10 Homog complete, adjust SV to 60" (3084 G)			
4	19	Record: pH 10.5 and adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	26	7-D	13
		Siphon N-7-D into SV & Record: pH 11.3			
	20	Heat to 190-194°F in 55-65 min and Record: HT °F and Rec 192 °F			
		NOTE: Strike must be started immediately on completion of heating			
343	21	While heating SV, run (49) (1348 G) water into V-343			
8	22	Meter in from V-386 MS 9.64 #/Gal 21.5 Gal		27-D	414
386	23	Stir 15 min or longer			207
5	24	Record: Be 1.01 (3.4 ± 0.1) 1.009 (1.01) g/ml			

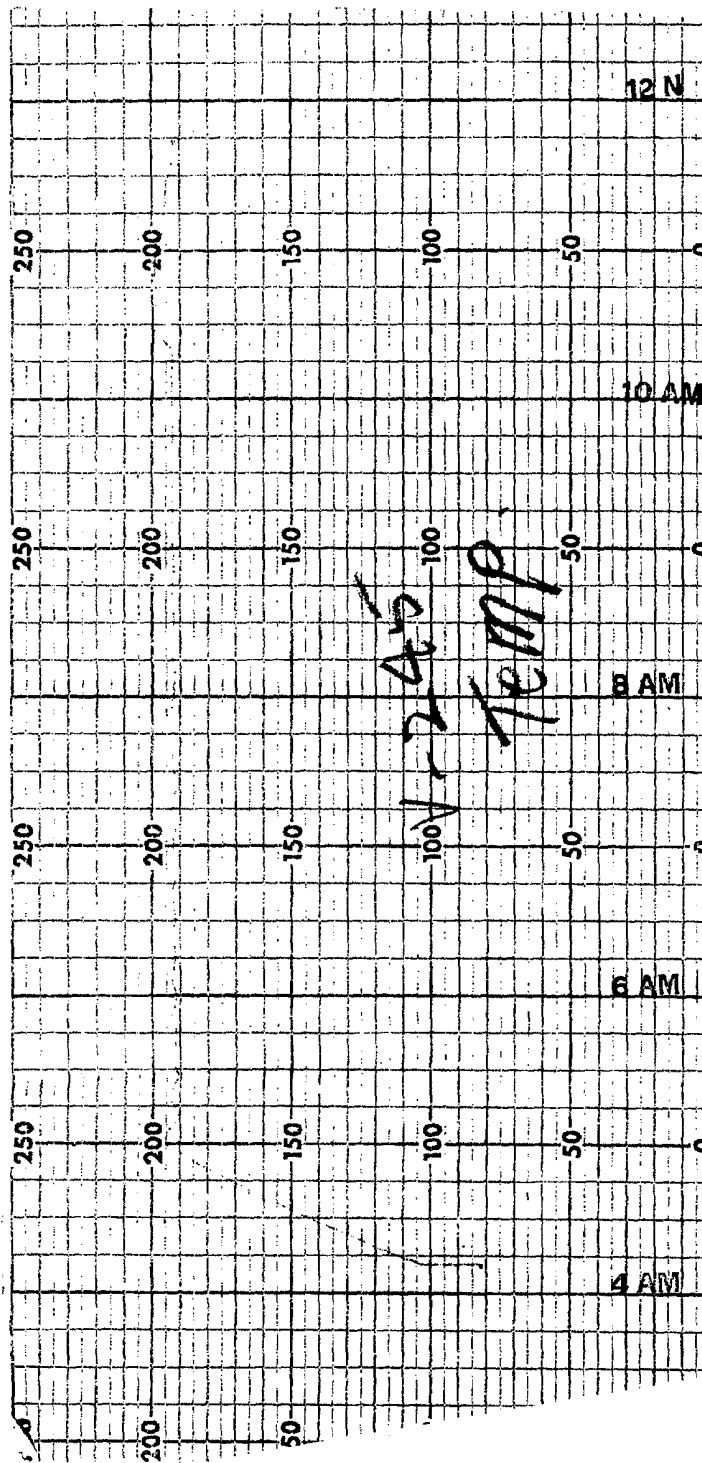
V-245

EQUIPMENT	PAGE	CG	04	CODE	KO-909-D (C)	EST. WGT.	5274	LBS.	USE	N	ACCT.
									LBS.	CODE	LBS.
SV	25	When S 20 heating complete, Record: pH	0.2	(9.6-10.2)							
6	26	Set V-343 acid pump at (69) setting (± 225 min)									
	27	Set V-349 silicate pump at (54) setting (± 180 min)									
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike									
	29	Record: Start Finish Min									
		V-343 0.55 12:55 A 240									
		V-349 0 PM 12:05 AM 140									
	Record:	Time	V-343	V-349	SV pH	Normal pH					
			Inches	Inches							
	at 20 min	9:15 PM	(46) 46	(17) 17	9.9	9.3-10.0					
	40 min	9:35 PM	(41) 41	(15) 15	9.9	9.3-10.0					
	1 hr	9:55 PM	(37) 37	(13) 13	9.9	9.3-10.0					
	2 hrs	10:55 PM	(23) 26	(6) 7	9.9	9.3-10.0					
	3 hrs	11:55 PM	(10) 13	(0) 1	9.8	9.3-10.0					
	Finish	12:55 AM	(0)		9.1	7.5-8.5					
	NOTE:	(1) If pH not as specified, notify supervisor & note in log									
		(2) If final pH is above 8.5, adjust to 7.5-8.5 & Record: pH	8.4	Assume 78%							
	30	Sift in 1 bag							26	27-D	
									50	128-A	50
357	31	Run 30" (216 G) water into V-357 and heat to 135-140°F							238		238
7	32	Pump in and stir to dissolve for S 61							477	15-A	477
302	33	Add 38" (465 G) water to V-302									
8	34	Add & stir 2 min for S 64							Assume 50%	148 296	7-D 74 148
PT	35	During strike pump into PT							482 41	169-A 41 482	
9	36	Pump In							54 57	155-A 57 54	
	37	Pump In							54 57	160-A 57 54	
	38	Stir 10 min with lightning mixer for S 42									
356	39	During strike, Run 22" (268 G) water into V-356									
10	40	Turn on steam									
	41	Add to 30% (366 G) at 178-182°F 82°C									
	42	Pump PT mixture from S 38 thru undersurface distributor AFAP									
	43	Rinse PT with HOT water from hot water mixer & pump in									
	44	Shut off pump 82°C									
	45	Stir 30 min at 178-182°F for S 55									
	46	Do Not Shut Off Agitator									
SV	47	When V-349 MTY, rinse in with minimum water then set pump to zero setting									
11	48	When V-343 MTY, rinse in with minimum water then turn off pump motor									
UP	49	Stir 60 min at 190-194°F									
2:10	50	Heat to 198-200°F in 5-10 min									
	51	Close water line & discharge valves at stearate pump									
	52	Open V-356 discharge valves to stearate pump inlet									
	53	Open water valve at stearate pump & run water thru Homog at 2900-3100 PSI to sewer									
	54	While Homog water at 2900-3100 PSI, open Homog discharge valve to SV & close valve to sewer									
	55	Immediately open stearate pump discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 PSI maintain SV at 198-200°F									
	56	While Homog V-356 to SV, Shut off water valve at stearate pump ASAP									

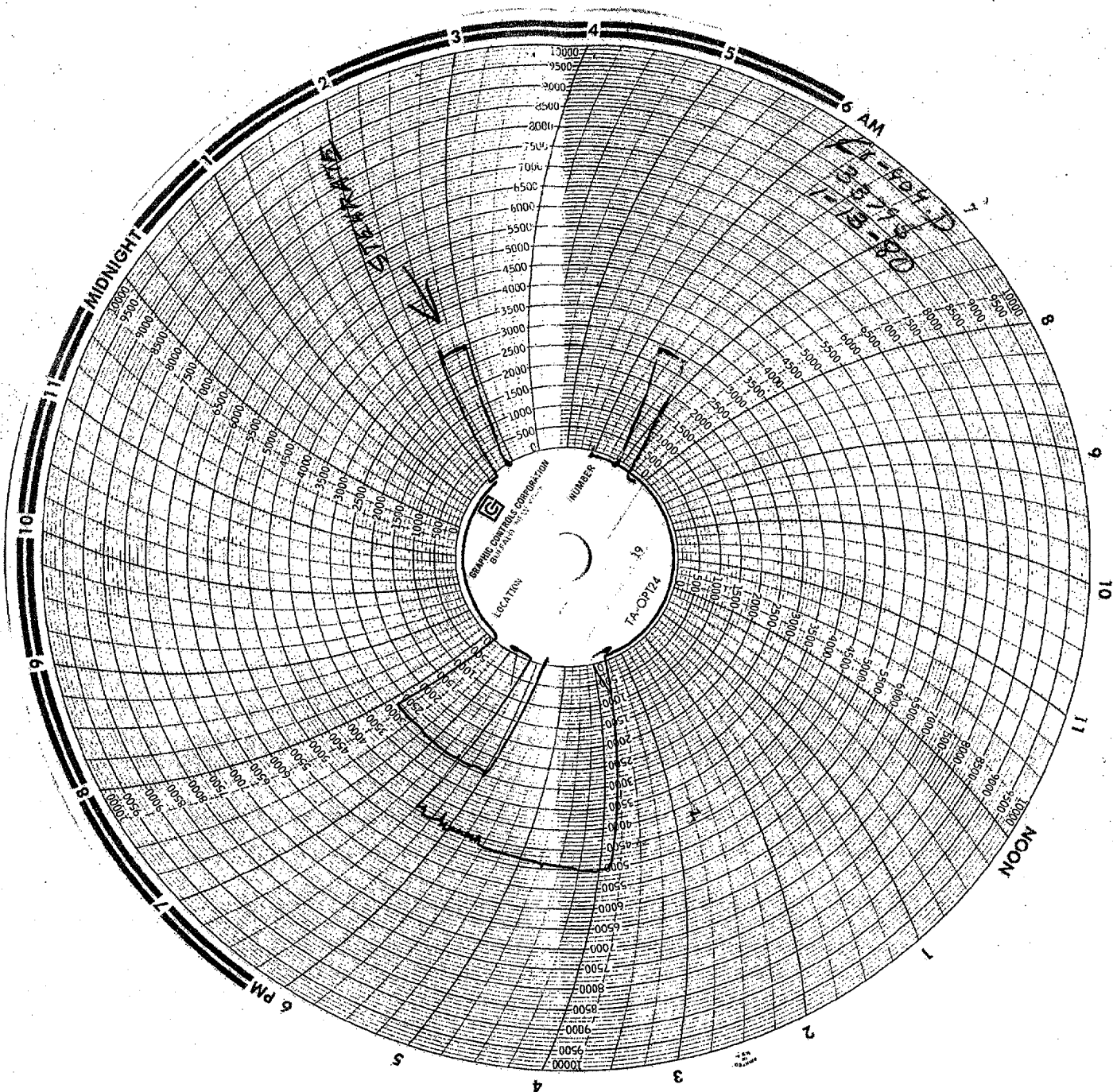
K 1389 REV.

V-245

EQUIPMENT	PAGE 3	CG 04	CODE	KO-909-D (C)	EST. WGT.	5274	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV	57	When Homog complete, rinse in V-356 with hot water								
11		from hot water mixer								
(Con't)	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-357 from S 32 and stir 5 min								
	62	Record: pH <u>3.2</u> (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 <u>6.6</u> (6.2-6.4) and if necessary, adj to								
		pH 6.2-6.4 and Record: pH <u>6.6</u> Assume 78%							27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%							7-D	
		Siphon N-7-D into SV								
	66	Do Not Stop Agitator								
		START	FIN	OPTR						
		<u>3:00 PM</u>	<u>11:00 AM</u>	<u>320-144</u>						
		<u>7:00 AM</u>	<u>3:00 PM</u>	<u>409-88</u>						
		<u>3:00 PM</u>	<u>11 PM</u>	<u>144</u>						
		<u>11:00 P</u>	<u>3:40 AM</u>	<u>235-342</u>						



GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



V-245

