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

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		

04 CODE KO-789-D PKG. _____
JAN 16 33858
WGT 509 ~~1132~~ LBS.
012
AP
DATE 10.8 TIME 7 AM

01 YC-16-B 93 4 Lot 33610, 2100#
01 YC-16-B 93 4 Lot _____, _____#
01 YC-16-B 93 4 Lot _____, _____#
AW
2609
Total Weight ~~5332~~# (Req _____)

NON-BLEEDING

		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run 60" (990 G) water into V-211			265
	2	Weigh in drum & pour in	~~265~~ ~~530~~	32-D	~~530~~
	3	Dump in & stir 5 min Lot 42	~~84~~ x 50	YC-16-B	~~4200~~
		Record: Start ~~7000~~ PM 33610	2100		2100
		Fin 1106 PM			
	4	Adj to 70" 1200 G) 2800-3300			
	5	Pump V-211 thru Homog #2 at ~~1600-2200~~ 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 " & adj to 54" (1890 G)			
	8	Inspect Homog strainer & clean if necessary			
208 & SV 2	9	Run 10" (514 G) water into V-245 & start agitator & install temperature chart			
	10	Pump V-208 thru Homog at 4800-5200 psi into SV-			
		Record: Time Start 430P Total Min 180			
		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 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ± 1000# water into V-384 & heat to 110-120°F	1272		1272
	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 ~~20"~~ ~~(1400 G)~~ & stir 15 min or longer 22" (1540G)			
	17	Record: °Be' 1.043 ~~(10.0 ± 0.2)~~ (1.040 - 1.044) g/mL			
SV 4	18	When S 10 Homog complete, adj SV to 45" (2300 G)			
	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%	20	7-D	10
		Siphon N-7-D into SV & Record: pH 11.2			
	20	Heat to 190-194°F in 55-65 min & Recrod: HT 192 °F			
		& Rec 194 °F			
		NOTE: Strike must be started immediately on completion of heating			
		52" (1430G)			
343 & 386 5	21	While heating SV, run ~~70"~~ (1920 G) water into V-343			
	22	Meter in from V-386 M 7, 9.55 #/Gal 20.4 Gal		27-D	~~440~~ 195
	23	Stir 15 min or longer			
	24	Record: °Be' 1.009 ~~(2.5 ± 0.1)~~ (1.008 - 1.009) g/mL			

V-245

PMENT		PAGE 2 CG 04 CODE KO-789-D (I) EST. WGT. 5332 LBS.	USE LBS.	N CODE	ACC LBS
SV	~~25~~	When S 20 heating complete, Record: pH 10.0 (9.6-10.2)			
6	~~26~~	Set V-343 acid pump at ~~86~~ setting (± 255 minutes) 65			
	~~27~~	Set V-349 silicate pump at ~~28~~ setting (± 210 minutes) 53			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start / Fin. / Min V-343 1.05AM / 5.30 / 265 V-349 / 4.40 / 215			

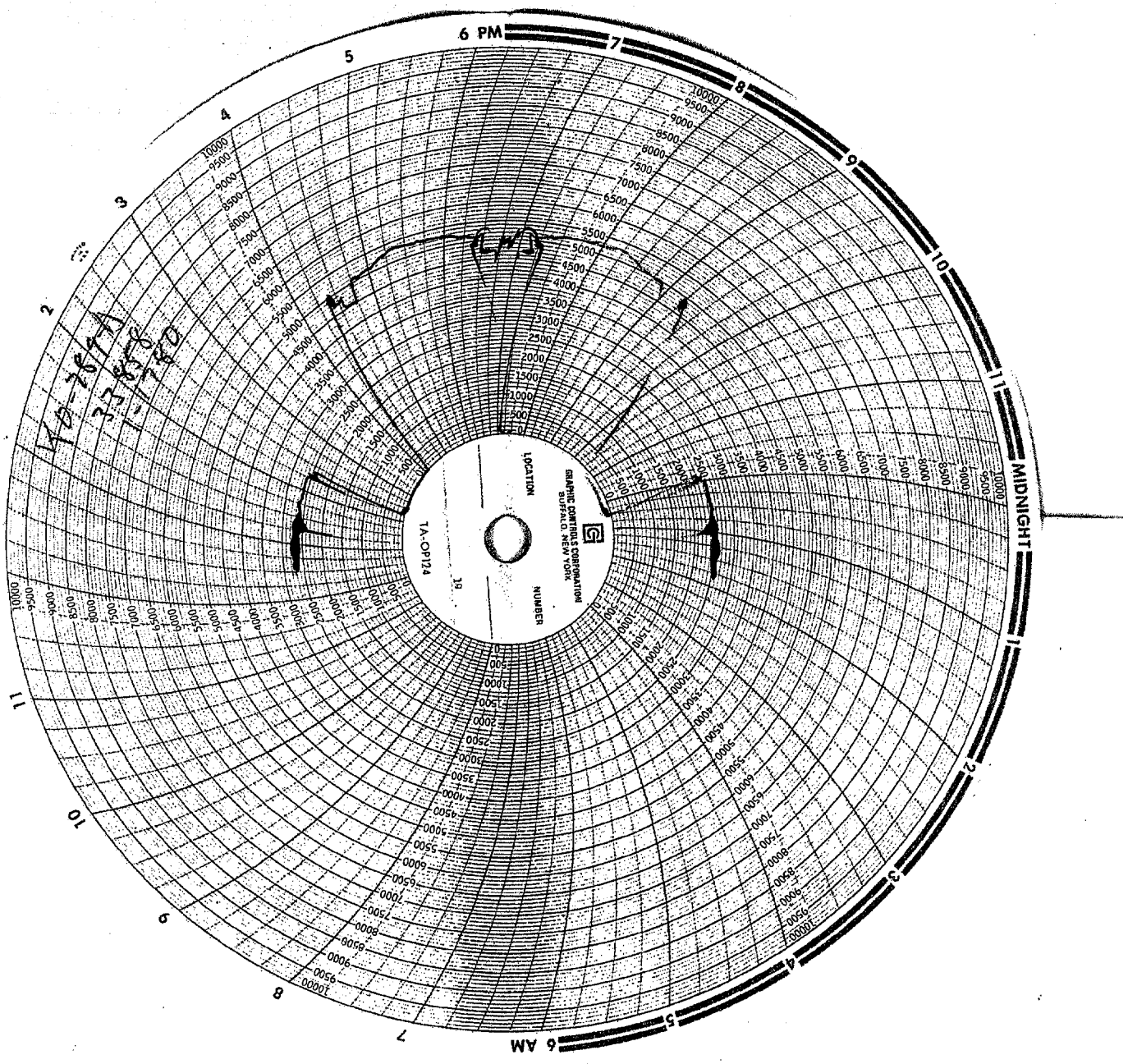
Record: Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min 1.25 AM	(~~56~~) 49 49	(~~28~~) 30 20	10.0	9.3-10.0
40 min 1.45 AM	(~~60~~) 45 45	(~~24~~) 18 18	10.0	9.3-10.0
1 hr 2.05 AM	(~~56~~) 41 41	(~~20~~) 16 16	10.0	9.3-10.0
2¼ hrs 3.20 AM	(~~34~~) 25 25	(~~12~~) 8 8	9.9	9.3-10.0
3½ hrs 4.35 AM	(~~18~~) 9 9	(0) 0	9.9	9.3-10.0
Finish 5.20 AM	(0) 0	0	8.5	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	
357	~~30~~	Run 33" (238 G) water into V-357 & heat to 135-140°F			~~265~~
7	~~31~~	Dump in & stir to dissolve	~~265~~ 530	15-A	~~530~~
302	~~32~~	Add 42" (514 G) water to V-302			
8	~~33~~	Add & stir 2 min	Assume 50% ~~164~~ ~~330~~	7-D	~~165~~ 83
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 5.35AM			
	~~37~~	Run in V-357 from S 31 & stir 5 min			
	~~38~~	Record: pH 4.3 (3.4-3.8) & if necessary, adj (DOWN ONLY) to 3.4-3.8 & Record: pH 3.6 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	30	15-A	30
	~~39~~	Run in N-7-D from S 33 in 10-12 min & stir 5 min			
	~~40~~	Record: pH 5.8 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.4	Assume 77%	27-D	
		(Dilute 10 parts water to 1 part N-7-D)	Assume 50% 12	7-D	6
		Siphon N-7-D into SV			
	~~41~~	Pour in & stir 15 min	~~102~~ 25	978-A	~~102~~ 25
	~~42~~	Stop agitator			

START	FIN	OPTR
4.30	1000 Kg	126-201
11.00 PM	6.45 AM	185-244

DUP050095275



DUP050095276

0
50
100
150
200
250
2 PM
4 PM
6 PM
8 PM
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