

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

CG 04 CODE KO-909-D PKG. 33802

JAN 14 1974 EST. WGT. 812 LBS. TIME 7 A M

STD. HRS. \_\_\_\_\_

01 YC-16-B 93 4 Lot 30094 100 #  
 01 YC-16-B 93 4 Lot 32435 500 #  
 01 YC-16-B 93 4 Lot 33475 1200 #

TOTAL WGT 5274# (Req. 544)

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

APPROVED BY  
 ENK 1-27-78  
 DCG 1-30-78  
 MTW 2-27-78

Homog #2

| EQUIPMENT  | NAME: KROLOR® ORANGE Y                                                                                       | USE LBS. | N CODE | ACCT. LBS. |
|------------|--------------------------------------------------------------------------------------------------------------|----------|--------|------------|
| 211 & 208  | 1 Run 30" (498 G) water into V-211                                                                           |          |        |            |
|            | 2 Pour in                                                                                                    | 480 240  | 32-D   | 480 240    |
|            | 3 Dump in                                                                                                    |          |        |            |
| 1          | Record: Start: 8:32 P.M. Lot 30094                                                                           | 100      |        | 100        |
|            | Fin: 9:20 P.M. 32435                                                                                         | 500      |        | 500        |
|            | 25" (1275 G) 33475                                                                                           | 1200     |        | 1200       |
|            | 4 Adj to 63" (1065 G) 2801-3300                                                                              |          |        |            |
|            | 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 40" and adj to 54" (1981 G)                                                              |          |        |            |
|            | 8 Inspect homog strainer & clean if necessary                                                                |          |        |            |
| 208 & SV 2 | 9 Run 10" (514 G) water into V-245. Install Temp chart & start agitator                                      |          |        |            |
|            | 10 Pump V-208 thru Homog at 4800-5200 psi into SV                                                            |          |        |            |
|            | Record: Time Start 3:25 P Total Min 205                                                                      |          |        |            |
|            | 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 & 384  | 12 While Homog, run 6" (284 G) water into V-349                                                              |          |        |            |
| 3          | 13 Run #1000# water into V-384 and heat to 110-120°F                                                         | 1388     |        | 1388       |
|            | 14 Weigh into V-384 and pump to V-349                                                                        | 2775     | 32-D   | 2775       |
|            | 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 1.057 (11.3 ± 0.2) (1.057 - 1.061) g/mL                                                        |          |        |            |
| SV 4       | 18 When S 10 Homog complete, adjust SV to 60" (3084 G)                                                       |          |        |            |
|            | 19 Record: pH 9.4 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% | 10       | 7-D    | 5          |
|            | Siphon N-7-D into SV & Record: pH 11.15                                                                      |          |        |            |
|            | 20 Heat to 190-194°F in 55-65 min and Record: HT 197°F and Rec 11.15°F                                       |          |        |            |
|            | NOTE: Strike must be started immediately on completion of heating                                            |          |        |            |
| 343 & 386  | 21 While heating SV, run 49" (1348 G) water into V-343                                                       |          |        |            |
| 5          | 22 Meter in from V-386 M 4 9.5 #/Gal 21.7 Gal                                                                |          | 27-D   | 414        |
|            | 23 Stir 15 min or longer                                                                                     |          |        | 207        |
|            | 24 Record: Be 1.010 (3.4 ± 0.1) (1.009 - 1.011) g/mL                                                         |          |        |            |

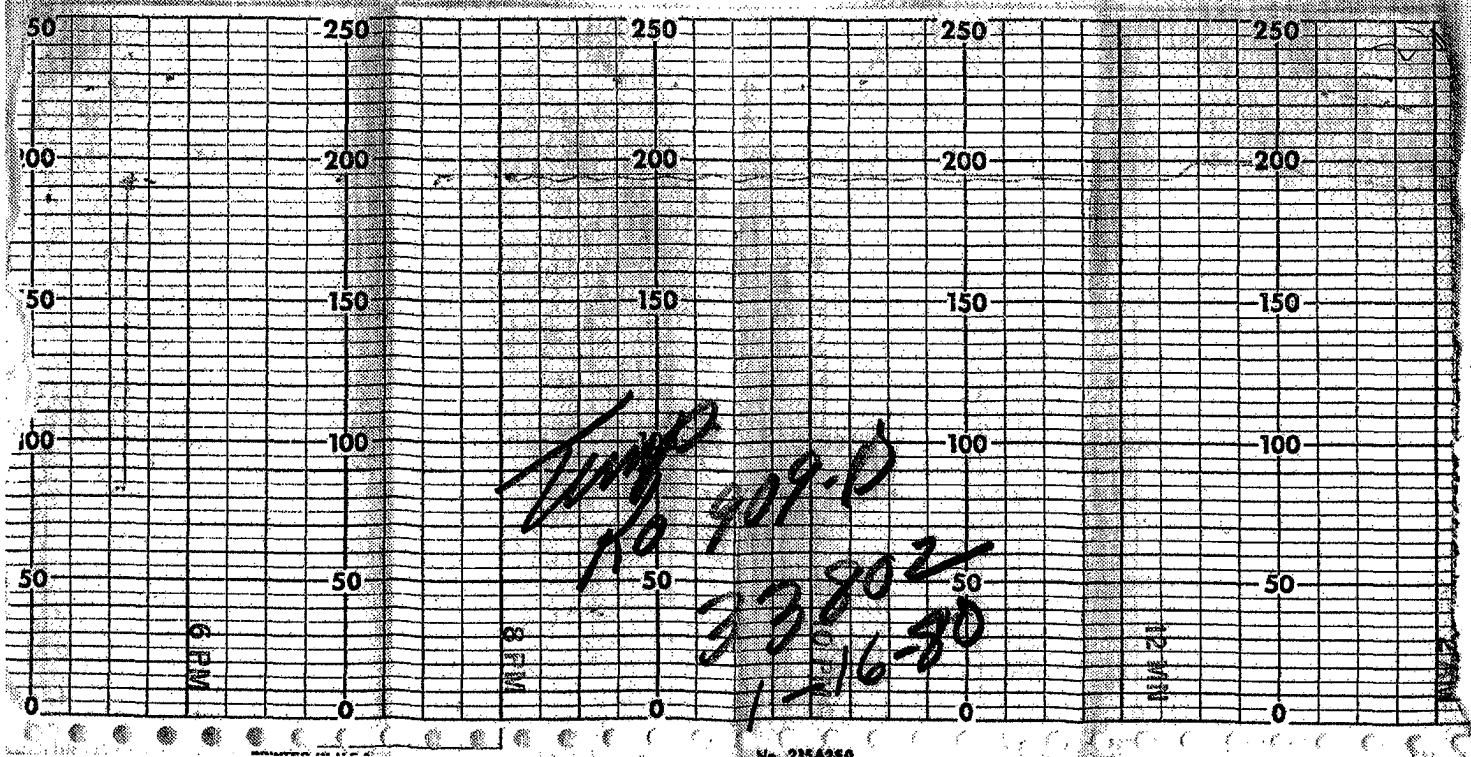
V-245

| EQUIPMENT | PAGE 2 | CG 04                                                                                                                      | CODE K0-909-D (C) | EST. WGT. 5274 | LBS.       | USE LBS.   | N CODE.            | ACCT. LBS.                                           |
|-----------|--------|----------------------------------------------------------------------------------------------------------------------------|-------------------|----------------|------------|------------|--------------------|------------------------------------------------------|
| SV 6      | 25     | When S 20 heating complete, Record: pH <u>10.0</u> (9.6-10.2)                                                              |                   |                |            |            |                    |                                                      |
|           | 26     | Set V-343 acid pump at 69 setting ( $\pm 225$ min)                                                                         |                   |                |            |            |                    |                                                      |
|           | 27     | Set V-349 silicate pump at 54 setting ( $\pm 180$ min)                                                                     |                   |                |            |            |                    |                                                      |
|           | 28     | Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike                                                 |                   |                |            |            |                    |                                                      |
|           | 29     | Record: Start Finish Min                                                                                                   |                   |                |            |            |                    |                                                      |
|           |        | V-343 <u>11:00</u>                                                                                                         |                   | <u>3:00 AM</u> |            | <u>240</u> |                    |                                                      |
|           |        | V-349 <u>11:00</u>                                                                                                         |                   | <u>2:10A</u>   |            | <u>190</u> |                    |                                                      |
|           |        | Record: Time                                                                                                               | V-343             | V-349          | SV pH      | Normal pH  |                    |                                                      |
|           |        | <u>11:00</u>                                                                                                               | Inches            | Inches         |            |            |                    |                                                      |
|           |        | at 20 min <u>11:30</u>                                                                                                     | (46)              | (17)           | <u>9.8</u> | 9.3-10.0   |                    |                                                      |
|           |        | 40 min <u>11:40</u>                                                                                                        | (41) <u>+</u>     | (15)           | <u>9.8</u> | 9.3-10.0   |                    |                                                      |
|           |        | 1 hr <u>12:00</u>                                                                                                          | (37) <u>3.2</u>   | (13) <u>+</u>  | <u>9.7</u> | 9.3-10.0   |                    |                                                      |
|           |        | 2 hrs <u>1:00</u>                                                                                                          | (23) <u>2.5</u>   | (6) <u>7-</u>  | <u>9.8</u> | 9.3-10.0   |                    |                                                      |
|           |        | 3 hrs <u>2:00</u>                                                                                                          | (10)              | (0) <u>1</u>   | <u>9.7</u> | 9.3-10.0   |                    |                                                      |
|           |        | Finish <u>3:00</u>                                                                                                         | (0)               |                | <u>8.0</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, adjust to 7.5-8.5 &                                                                          |                   |                |            |            |                    |                                                      |
|           |        | Record: pH                                                                                                                 |                   |                |            |            | Assume 78%         |                                                      |
|           | 30     | <del>Stir in 1 bag</del>                                                                                                   |                   |                |            |            | <del>50</del>      | <del>27-D</del><br><del>128-A</del><br><del>50</del> |
| 357 7     | 31     | Run 30" (216 G) water into V-357 and heat to 135-140°F                                                                     |                   |                |            |            |                    |                                                      |
|           | 32     | Dump in and stir to dissolve for S 61                                                                                      |                   |                |            |            |                    |                                                      |
|           |        |                                                                                                                            |                   |                |            |            | <del>477-238</del> | <del>15-A 238 477</del>                              |
| 302 8     | 33     | Add 38" (465 G) water to V-302                                                                                             |                   |                |            |            |                    |                                                      |
|           | 34     | Add & stir 2 min for S 64                                                                                                  |                   |                |            |            |                    |                                                      |
|           |        |                                                                                                                            |                   |                |            |            | Assume 50%         | <del>148 296</del>                                   |
|           |        |                                                                                                                            |                   |                |            |            | 7-D                | <del>74 148</del>                                    |
| PT 9      | 35     | During strike pump into PT                                                                                                 |                   |                |            |            |                    |                                                      |
|           | 36     | Pump In                                                                                                                    |                   |                |            |            |                    |                                                      |
|           | 37     | Pump In                                                                                                                    |                   |                |            |            |                    |                                                      |
|           | 38     | Stir 10 min with lightning mixer for S 42                                                                                  |                   |                |            |            |                    |                                                      |
|           |        | <u>15"</u>                                                                                                                 |                   |                |            |            |                    |                                                      |
| 356 10    | 39     | During strike, Run 22" (268 G) water into V-356                                                                            |                   |                |            |            |                    |                                                      |
|           | 40     | Turn on steam                                                                                                              |                   |                |            |            |                    |                                                      |
|           | 41     | Add to 30" (366 G) at 178-182°F <u>82°C</u>                                                                                |                   |                |            |            |                    |                                                      |
|           | 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 <u>82°C</u>                                                                                                  |                   |                |            |            |                    |                                                      |
|           | 45     | Stir 30 min at 178-182°F for S 55                                                                                          |                   |                |            |            |                    |                                                      |
|           | 46     | Do Not Shut Off Agitator                                                                                                   |                   |                |            |            |                    |                                                      |
| SV 11     | 47     | When V-349 MTY, rinse in with minimum water then set pump to zero setting                                                  |                   |                |            |            |                    |                                                      |
|           | 48     | When V-343 MTY, rinse in with minimum water then turn off pump motor                                                       |                   |                |            |            |                    |                                                      |
|           | 49     | Stir 60 min at 190-194°F                                                                                                   |                   |                |            |            |                    |                                                      |
|           | 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 10330, 2V.

DUP050095255

| EQUIPMENT | PAGE 3 | CG 04                                                    | CODE           | KO-909-D (C)   | EST. WGT. | 5274 | LBS. | USE<br>LBS. | N<br>CODE | ACCT.<br>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>3.0</u> (3.4-3.8)                          |                |                |           |      |      |             |           |               |
|           | 63     | If necessary, adj pH to 3.4-3.8 (Downward only) and      |                |                |           |      |      |             |           |               |
|           |        | Record: pH                                               |                |                |           |      |      |             |           |               |
|           | 64     | Run in N-7-D from S 34 in 4-6 min and stir 5 min         |                |                |           |      |      |             |           |               |
|           | 65     | Record: pH <u>4.2</u> (6.2-6.4) and if necessary, adj to |                |                |           |      |      |             |           |               |
|           |        | pH 6.2-6.4 and Record: pH <u>6.4</u> Assume 78%          |                |                |           |      |      |             |           |               |
|           |        | (Dilute 10 parts water to 1 part N-7-D) Assume 50%       |                |                |           |      |      |             |           |               |
|           |        | Siphon N-7-D into SV                                     |                |                |           |      |      |             |           |               |
| 60        |        | Do Not Stop Agitator                                     |                |                |           |      |      |             |           |               |
|           |        | START                                                    | FIN            | OPTR           |           |      |      |             |           |               |
|           |        | <u>11:00 PM</u>                                          | <u>7:00 AM</u> | <u>235-342</u> |           |      |      |             |           |               |
|           |        | <u>7:00 AM</u>                                           | <u>3:00 PM</u> | <u>438-405</u> |           |      |      |             |           |               |
|           |        | <u>3 P</u>                                               | <u>11 P</u>    | <u>101-120</u> |           |      |      |             |           |               |
|           |        | <u>11:00 P</u>                                           | <u>5:46 AM</u> | <u>235-301</u> |           |      |      |             |           |               |



DUP050095257

