

CG 04 CODE KD-789-D

PKG

PROCESSES

APPROVED BY

EST'D WGT 1032 LBS

() KD-789-D (I)

FWP 5/22/80

STANDARD HRS. 10.8 TIME 7 P M

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TYPED BY: FWP 5/22/80

CG	CODE	PQ	LOT	LBS
01	YC016B	93		
01	YC016B	93		
01	YC016B	93		

TOTAL EST'D WGT 5232

REQ. NO. ()

NON-BLEEDING

EQUIP	NAME : "KROLOR" ORANGE Y	USE LBS	NCODE	ACCT LBS
211	1 RUN 60" (990 G) WATER IN V-211. SET AGITATOR ON & HIGH SPEED.			
208	2 WEIGH IN DRUM AND POUR IN	530	32-D	530
	3 DUMP IN AND STIR 5 MIN LOT	84X50	YC16B	4206
	RECORD: START			
1	FIN			
	4 ADJUST TO 75" (1275 G)			
	5 WITH AGITATOR ON LOW SPEED PUMP V-211 THRU HOMOG AT 2800-3200 PSI INTO V-208			
	6 WHEN V-211 MTY, WASH COLOR THRU HOMOG WITH MIN HOT WATER AT 2800-3200 PSI INTO V-208			
	7 RECORD: V-208 VOL. & ADJUST TO 54" (1890G)			
	8 INSPECT HOMOG STRAINER & CLEAN IF NECESSARY			
208	9 RUN 10" (514 G) WATER INTO V- , START & AGITATOR & INSTALL TEMP CHART			
SV	10 PUMP V-208 THRU HOMOG AT 4800-5200 PSI INTO SV. RECORD: TIME START TOTAL MINUTES			
2	NOTE: IF HOMOG PRESSURE FALLS BELOW 4800 PSI, 3-WAY VALVE WILL RECIRCULATE SLURRY TO V-208			
111	WHEN V-208 MT, RUN IN 5" (240 G) WATER & PUMP THRU HOMOG AT 4800-5200 PSI INTO SV			
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	2545	32-D	2545
	15 RUN 1000# WATER INTO V-384 & PUMP TO V-349			
3	16 ADJ V-349 TO 22" (1040 G) & STIR 15 MIN			
	17 RECORD DENSITY: G/ML (1.082-1.086)			
SV	18 WHEN S-10 HOMOG COMPLETE, ADJ SV TO 45" (2300 G)			
	19 RECORD: PH & ADJ TO 11.1-11.3 USING N-7-D AT 5% (10 PARTS WATER TO 1 PART N-7-D)			
4	ASSUME 50%		7-D	
	SIPHON N-7-D INTO SV & RECORD: PH			
	20 HEAT TO 190-194°F IN 55-65 MIN & REC: HT. °F & RECORD: °F			
	NOTE: STRIKE MUST BE STARTED IMMEDIATELY ON COMPLETION OF HEATING.			

N34606

343	21	WHILE HEATING SV, RUN 52" (1430 G) WATER INTO V-343			
&	22	METER IN FROM V-386 M _____ #/GAL, _____ GAL		27-D	390
386	23	STIR 15 MIN OR LONGER			
5	24	RECORD: DENSITY _____ G/ML (1.018-1.020)			
	25	WHEN S 20 HEATING COMPLETE, RECORD: PH _____			
	26	SET V-343 ACID PUMP AT 65 SETTING (255 MIN)			
	27	SET V-349 SILICATE PUMP AT 54 SETTING (210 MIN)			
SV	28	IMMEDIATELY METER IN V-343 & V-349. MAINTAIN SV AT 190-194°F DURING STRIKE			
	29	RECORD: START FINISH MINUTES			
		V-343 _____			
		V-349 _____			
		TIME V-343 V-349 SV NORMAL			
		INCHES INCHES PH PH			
		AT 20 MIN (49) (20) (9.3-10.0)			
		40 MIN (45) (18) (9.3-10.0)			
		1 HR (41) (16) (9.3-10.0)			
		2 1/4 HR (25) (8) (9.3-10.0)			
		3 1/2 HR (9) (0) (9.3-10.0)			
		FINISH (0) (7.5-8.5)			
		NOTE: IF PH DROPS BELOW 9.3 IN FIRST HOUR, STOP PUMPS & SEE SUPV. IF FINAL PH IS ABOVE 8.5, ADJ TO 7.5-8.5 & RECORD: _____ PH			
		ASSUME 77%		27-D	
385	30	RUN 31" (238 G) WATER INTO V-385 & HEAT TO 135-140°F			
7	31	DUMP IN & STIR TO DISSOLVE	530	15-A	530
302	32	ADD 42" (514 G) WATER TO V-302			
8	33	ADD & STIR 2 MIN	330	7-D	165
SV	34	WHEN V-349 MT, RINSE IN WITH MINIMUM WATER & SET PUMP AT ZERO SETTING			
9	35	WHEN V-343 MT, RINSE IN WITH MINIMUM WATER & TURN OFF PUMP MOTOR			
	36	STIR 30 MIN AT 190-194°F, THEN TURN OFF STEAM			
		RECORD: START _____			
	37	RUN IN V-385 FROM S 31 & STIR 5 MIN			
	38	RECORD: PH (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 GAL 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 (6.2-6.4) & IF NECESSARY ADJ TO PH 6.2-6.4. RECORD: PH _____ ASSUME 77%		27-D	
		DILUTE N-7-D 10 TO 1 WITH WATER ASSUME 50%		7-D	
		SIPHON N-7-D INTO SV			
	41	POUR IN STIR 15 MIN	50	978-A	50
	42	STOP AGITATOR			
		START FINISH OPERATOR			

CO 04 CODE K0-789-D PKG.
→ JUN 19 36193
EST. WGT. 1199 LBS.

PROCESSING INSTRUCTIONS: BATCH I

PROCESSES	APPROVE
K0-789-D (I)	EWK 9-2
	DCG 9-2
	MTW 10-

TYPED BY
jlc 10-8-76

MAKING NOTES

REMARKS

Total Weight 5232 (Req. 5199)

NAME: "KROLOR" ORANGE Y

NON-BLEEDING

INSTRUCTIONS					- PRESSING -	RECORD			
DATE					PRESSLOAD	1ST	2ND	3RD	4TH
TIME					STARTED				
RELEASED BY					CAKES USED				
PRESS	22	23	24	25	WATER ON				
NO. OF CAKES	46	46	52	48	HRS. WASHED				
PRESS	with				OHMS				
	AGITATION				HRS. WASHED				
WASH TO	5000	OHMS with 35-750F water				OHMS			
TEST AFTER	6	HOURS				HRS. WASHED			
LOAD	on 6 cars				OHMS				
					CAKE CONDITION				
					NO. CARS LOADED				
					EXPLAIN LOSSES				

SAMPLES 1 - 8 oz. jar
DELIVER TO CIL for color

SAMPLED BY RELEASED BY

-DRYING-

DRY 16 HOURS AT 220°F	LUMP: - OK - WET - SALTS - CONTAMIN
TEMP.	
	ADDITIONAL DRYING HOURS REQUIRED
SAMPLES	NO. DRUMS:
DELIVER TO	NO. CARS PULLED
	SAMPLED BY
	LUMP WGT.
	RELEASED BY

-GRINDING-

ILL 938 HSP 3/32" RP SCREEN 3500 RPM	SCREEN	RPM
MAX. TEMP. 210 °F	MAX. TEMP.	°F
	EXPLAIN LOSSES	
SAMPLE 1 Env. + 1 Pint Can	DATE MIXED	
DELIVER TO CIL	SAMPLED BY	RELEASED BY

DUP050104611