

(246) (247)

C.V.

D.V.

06 04 CODE K0-786-D PKG.

DEC 21 33444

EST. WGT. 862 LBS.

STD. HRS. 10.5 TIME

7A M

PROCESSES		APPROVED BY
() K0-786-D	(P)	EWK 9-21-76
()	()	DCG 9-21-76
()	()	MTW 10-1-76
()	()	
TYPED BY		
JIC 11-16-76		

01 YC-10-B 93 4 32912 1300 # Bay 2
 01 YC-10-B 93 4 32895 2650 #
 01 YC-10-B 93 4 33051 150 # Bay 1

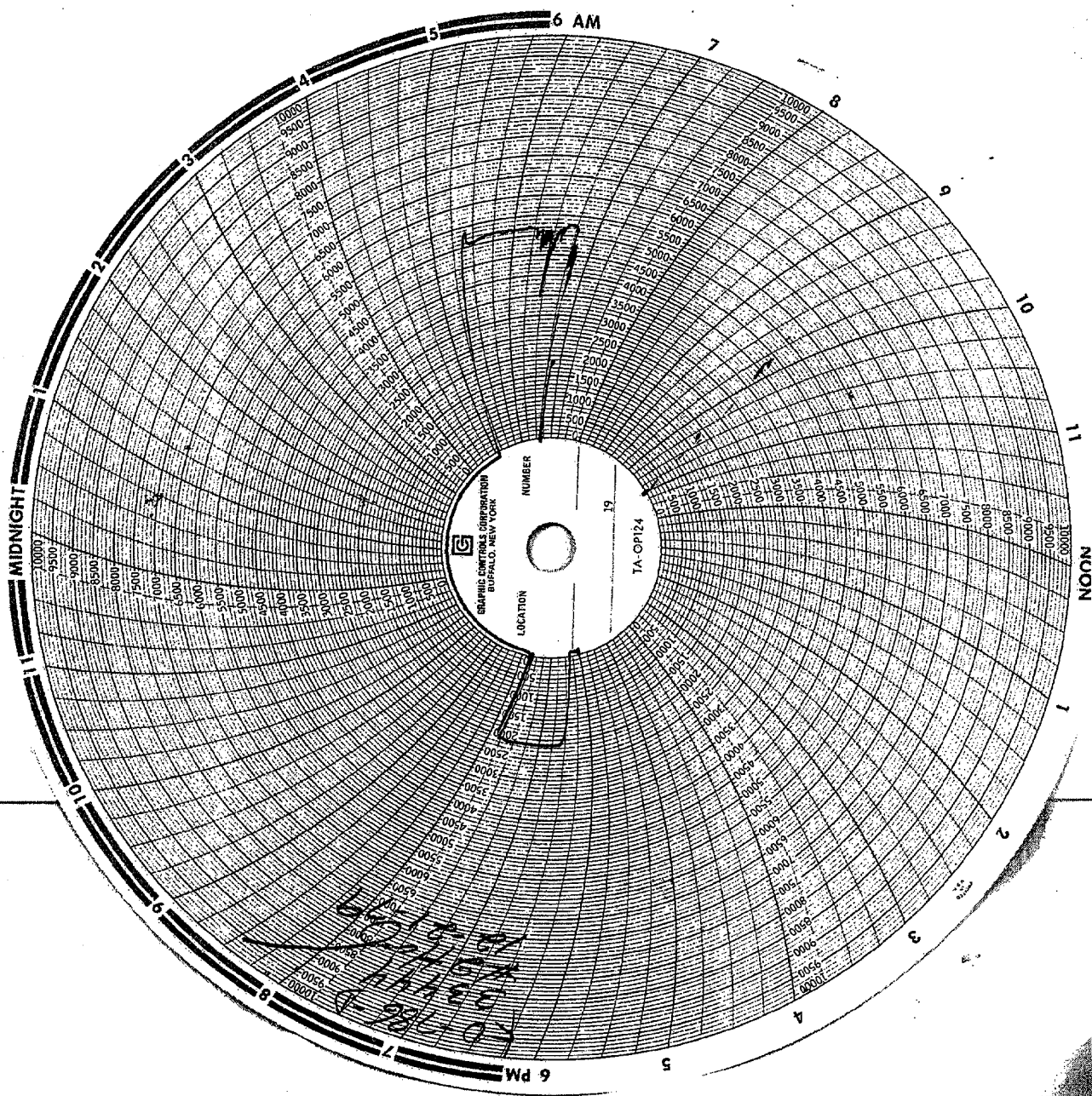
Total Weight 4962# (Req. 0493)

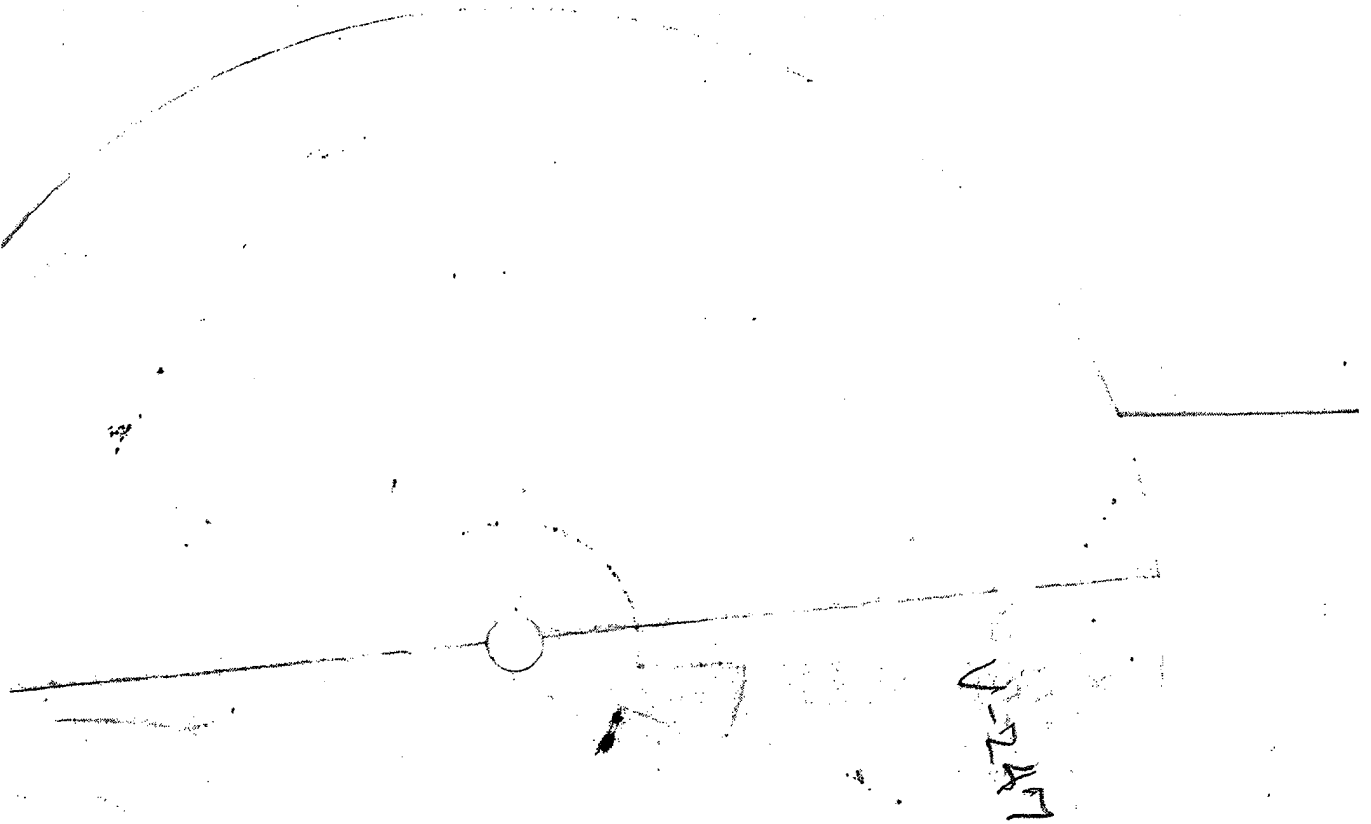
NON-BLEEDING

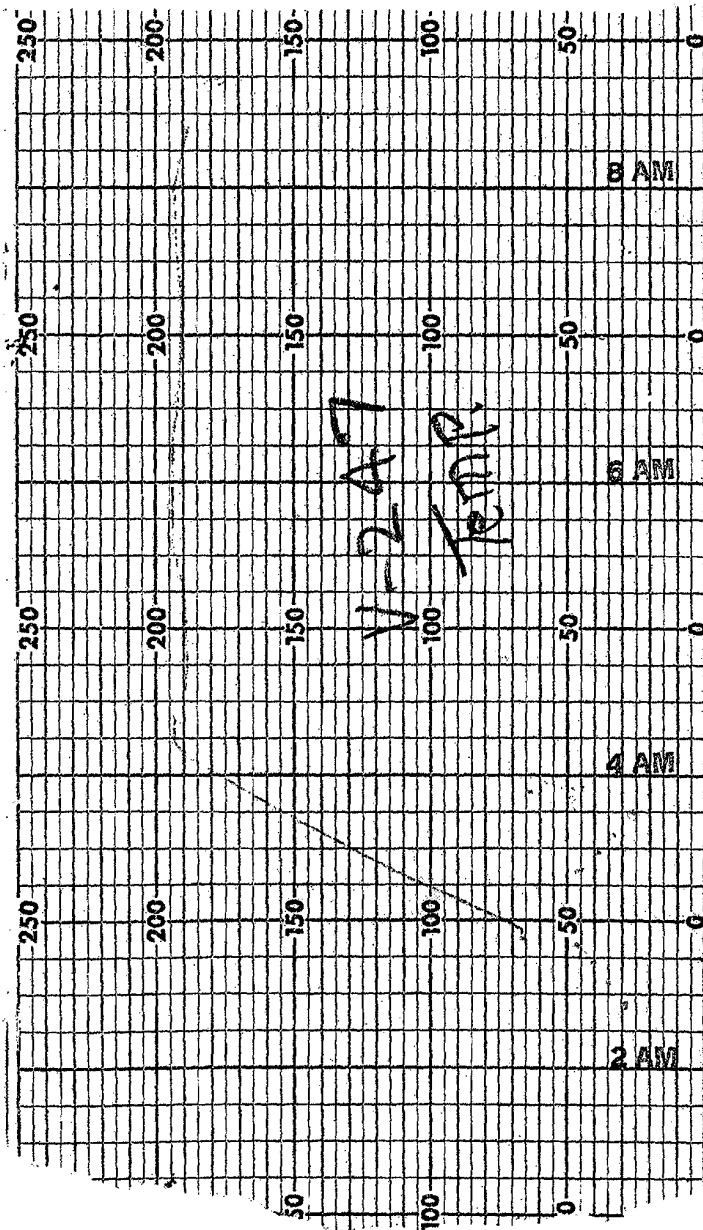
UPMENT	NAME: "KROLOR" ORANGE R	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1 Run 60" (990 G) water in V-211 and add Assume 50%	30	7-D	15
	2 Weigh in drum and pour in V-211	270	32-D	270
	3 Dump in and stir 5 minutes LOT	82 x 50	YC-10-B	4100
	Record: Start 11:45 A.M. 32912	1300		
	Fin 2:00 P.M. 32895	2650		
	5" (1275 G) 33051	150		
	4 Adjust to 80" (1370 G)			
	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 50 " and adjust to 50" (1840 G)			
	8 Inspect homog strainer and clean if necessary			
208 & SV 2	9 Run 15" (771 G) water into V-247 and start agitator and install temperature chart			
	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
	Record: Time Start 5:00 AM Total Minutes 95			
	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 3	12 While Homog, run 6" (284 G) water into V-349			
	13 Run ±1000# water into V-384 and heat to 110-120°F			
	14 Weigh into V-384 and pump to V-349	2400	32-D	2400
	15 Run ±1000# water into V-384 and pump to V-349			
	16 Adjust V-349 to 22" (1040 G) & stir 15 minutes or longer			
	17 Record: $\phi Be 1.081 (10.9 \pm 0.2) (1.078 - 1.081)$			
SV 4	18 When S 11 Homog complete, adjust to 66" (3400 G) in SV			
	19 Record: pH 10.8 and adjust to 10.4-10.8 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%		7-D	
	Siphon N-7-D into SV and Record: pH			
	20 Heat to 190-194°F in 55-65 minutes & Record: HT 194 F			
	Note: Strike must be started immediately on completion of heating			
343 & 385 5	21 While heating SV, run 51" (1400 G) water into V-343			
	22 Meter in from V-386 M 33 #/Gal 9.88 Gal 35.9		27-D	355
	23 Stir 15 minutes or longer			
	24 Record: $\phi Be 1.019 (2.8 \pm 0.1) (1.017 - 1.019)$			

V-247

EQUIPMENT	PAGE	CG 04	CODE	KO-786-D (H)	EST. WGT.	4962	LBS.	USE	N	ACTY.
								LBS.	CODE	LBS.
SV 6	25	When S 20 heating complete. Record: pH <u>9.8</u> (9.6-10.2)								
	26	Set V-343 acid pump at 72 setting (± 225 minutes)								
	27	Set V-349 silicate pump at 66 setting (± 180 minutes)								
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-193°F during strike								
	29	Record: Start Finish Minutes								
		V-343	10:20	V-349	2:15 P	235				
		V-349	10:20	V-343	1:22 P	182				
	Record:	Time	V-343	V-349	SV	Normal				
			10:20	5.8 Inches	2.2 Inches	pH	pH			
	at 20 min	10:40	(47) +	(20)	9.6	9.3-10.0				
	40 min	11:00	(43) +	(17) +	9.6	9.3-10.0				
	1 hr	11:20	(38) 39+	(15)	9.6	9.3-10.0				
	2 hrs	12:20	(24) 26	(7) +	9.6	9.3-10.0				
	3 hrs	1:20	(10) 11+	(0)	9.7	9.3-10.0				
	Finish	2:15	(0)		7.5	7.5-8.5				
	Note: if pH drops below 9.3 in 1st hour, stop pumps and see supervisor. If final pH is above 8.5, adjust to (7.5-8.5) and Record: pH Assume 77%									
									27-D	
357 7	30	Run 21" (150 G) water into V-357 and heat to 135-140°F								
	31	Dump in and stir to dissolve								
							300	15-A	300	
302 8	32	Add 42" (514 G) water to V-302								
	33	Add and stir 2 minutes								
							150	7-D	75	
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump to zero setting								
	35	When V-343 MTY, rinse in with minimum water, then turn off pump motor								
	36	TURN OFF STEAM								
	37	Run in V-357 from S 31 and stir 5 minutes								
	38	Record: pH <u>3.0</u> (3.3-3.7)								
	39	If necessary, adjust pH to 3.3-3.7 (Downward only) Record: pH								
	40	Run in N-7-D from S 33 in 4-6 minutes and stir 5 minutes								
	41	Record: pH <u>3.7</u> (4.0-4.2) & if necessary, adjust to pH 4.0-4.2 and Record: pH <u>4.2</u> Assume 77%								
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%								
							8	27-D	4	
								7-D		
	42	Siphon N-7-D into SV								
		Stop agitator								
		START	7:00 A	FINISH	2:15 P	OBTR	27-126			
							235-54			







GRAPHIC CONTROLS CORPORATION BUFFALO, N