

S.V. (245) 247

C.V.

D.V.

CG 04 CODE KO-906-D PKG.

JAN-3 33601

EST. WGT. 1377 LBS.

STD. HRS. TIME 11P M

01 YC-10-B	93	4	33351	200 #
01 YC-10-B	93	4	33354	600 #
01 YC-10-B	93	4	31686	1000 #

PROCESSES		APPROVED BY	
()	KO-906-D	(C)	EWK 1/24/78
()		()	DCG 1/26/78
()		()	MW 1/26/78
()		()	
TYPED BY			
rj 3/2/78			

TOTAL WEIGHT 5077# (Req. 6513)

01 YC-10-B 93 4 33354 1900#

Homog #2

NON-BLEEDING

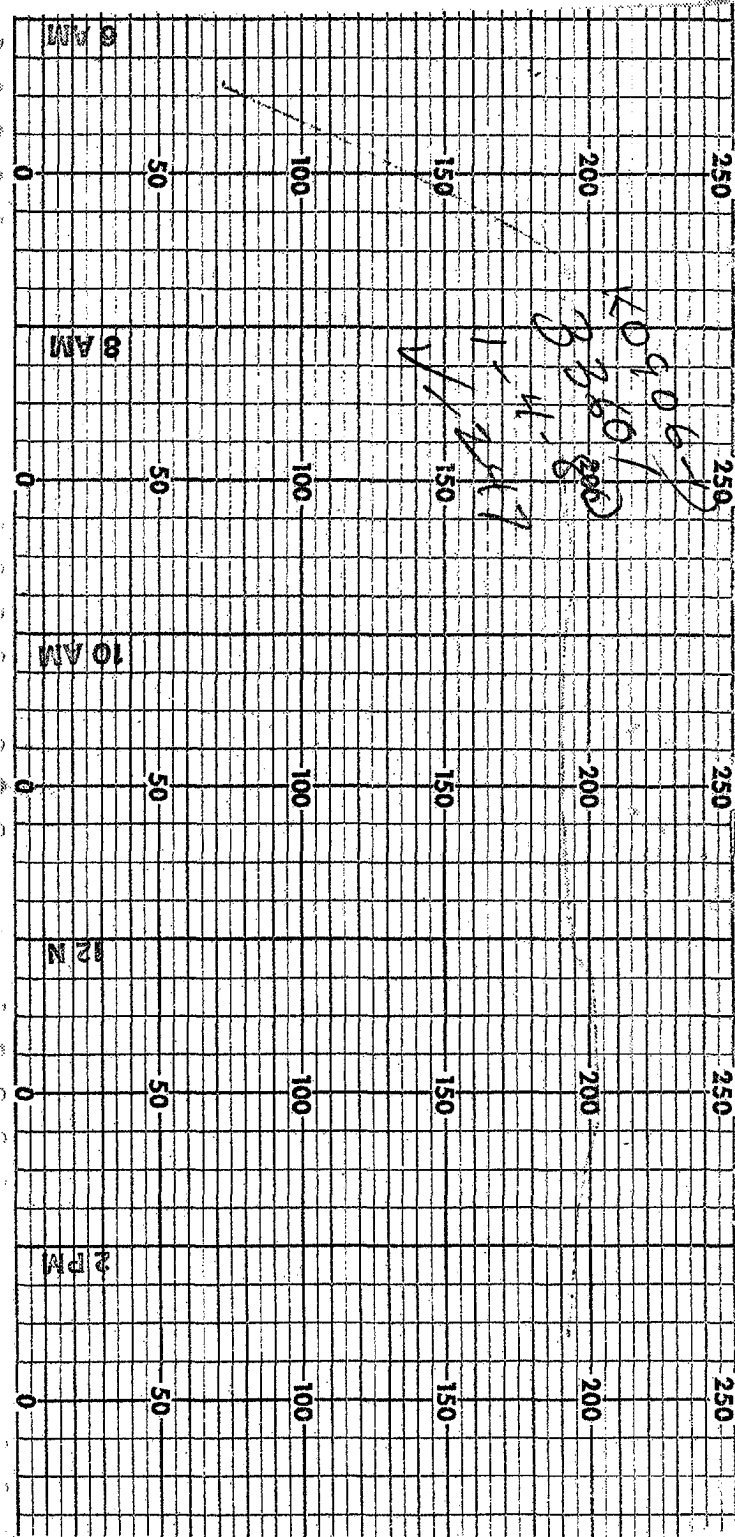
EQUIPMENT	NAME	USE LBS.	N CODE	ACCT. LBS.
211 & 208	60" KROLOR® ORANGE R			
1	1 Run 30" (505 G) water in V-211 and add Assume 50%	26	7-D	13
	2 Weigh in drum and pour in	245	32-D	245
	3 Dump in and stir 5 min	74 x 50	YC-10-B	3700
	Record: Start 3:30 PM	33351		
	Finish 3:35 PM	33354		
	75" (1273 G) 80" (1360 G)	31686		
	4 Adjust to 64" (1082 G)	33357		
	5 Pump V-211 thru Homog #2 at 1800-2200 psi into V-208	1,900		
	6 When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7 Record: V-208 Vol 43" & adjust to 45" (1662 G)			
	8 Inspect Homog strainer and clean if necessary			
208 SV	9 Run 15" (793 G) water into V-247 & start agitator			
	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
	11 Record: Time Start 3:30 Total Min 140			
	Note: If Homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	12 When V-208 MTY, run 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384	13 While Homog, run 5" (237 G) water into V-349			
	14 Run 1000# water into V-384 and heat to 110-120°F			
	15 Weigh into V-384 and pump to V-349	2165	32-D	2165
	16 Run 1000# water into V-384 and pump to V-349			
	17 Adjust V-349 to 20" (946 G) and stir 15 min or longer			
	18 Record: 98° 1.078 (10.9 + 0.2) 1.078-1.081			
	9/mL			
SV	19 When S12 Homog complete, adi to 59" (3033 G) in SV			
	20 Record: pH 10.9 & adi 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, stir 5 min & record: pH			
	21 Heat to 190-194°F in 55-65 min & Record: HT 18% Rec 194 of			
	Note: Strike must be started immediately on completion of heating			
343 & 386	22 While heating SV, run 46" (1265 G) water into V-343			
	23 Meter in from V-386 M 1, 9.70 #/Gal, 33.0 Gal		27-D	320
	24 Stir 15 min or longer			
	25 Record: 98° 1.018 (2.9 + 0.1) 1.018-1.019			
	9/mL			

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EQUIPMENT	PAGE 2	CG 04	CODE K0-906-D (C)	EST. WGT. 5077	LBS.	USE LBS.	N CODE	ACCT LBS.
SV	6	26	When S20 heating complete, Record: pH 9.9 (9.6-10.2)					
		27	Set V-343 acid pump at 65 setting (+225 min)					
		28	Set V-349 Silicate pump at 57 setting (+180 min)					
		29	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike					
		30	Record: Start Finish Minutes					
			V-343 8:00 12:00 PM 240					
			V-349 8:10 11:20 PM 200					
			Record: Time V-343 V-349 SV pH Normal pH					
			8:00 18 inches 20 inches					
			at 20 min 8:20 (43) (18) 9.6 9.3-10.0					
			40 min 8:40 (39) + (16) - 9.6 9.3-10.0					
			1 hr 9:00 (35) + (13) + 9.6 9.3-10.0					
			2 hrs 10:00 (22) 23 (7) 8 9.6 9.3-10.0					
			3 hrs 11:00 (10) 12+ (0) 1 9.65 9.3-10.0					
			Finish 11:45 (0) 1 7.0 7.5-8.5					
			Note: (1) If pH not as specified notify supervisor & note in Log (2) If final pH is above 8.5, adj to 7.5-8.5 and					
			Record: pH Assume 78%				27-D	
		31	Sift in 1 bag			✓ 50	128-A	50
357	7	32	Run 19" (137 G) water into V-357 & heat to 135-140°F					
		33	Dump in & stir to dissolve for S61			270	15-A	270
302	8	34	Run 24" (294 G) water into V-302					
		35	Add & stir 2 min for S64 Assume 50%			136	7-D	68
PT	9	36	During strike pump into PT			464	169-A	464
		37	Pump in			52	155-A	52
		38	Pump in			52	160-A	52
		39	Stir 10 min with lightning mixer for S43					
356	10	40	During strike, run 15" (268 G) water into V-356					
		41	Turn on steam					
		42	Adj to 30% (366 G) at 178-182°F 81-82°C					
		43	Pump PT. mixture from S39 thru undersurface Distributor AFAP					
		44	Rinse PT with hot water from hot water mixer & pump in					
		45	Shutoff pump 81-82°C					
		46	Stir 30 min at 178-182°F for S55					
		47	Do not shutoff agitator					
SV	11	48	When V-349 MTY, rinse in with minimum water then set pump to zero setting					
		49	When V-343 MTY, rinse in with minimum water then turn off pump motor					
		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 2900-3100 psi Maintain SV at 198-200°F					
		56	While Homog V-356 to SV, shutoff water valve at Stearate pump ASAP					

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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 S33 and stir 5 min									
	62	Record: pH 3.6 (3.3-3.7)									
	63	If necessary, adj pH to 3.3-3.7 (Downward only) and								15-A	
		Record: pH									
	64	Run in N-7-D from S35 in 4-6 min and stir 5 min									
	65	Record: pH 4.4 (4.0-4.2) and if necessary, adj to									
		pH 4.0-4.2 and Record: pH 4.1 Assume 78%							2	27-D	1
		(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			
		7:00 PM			3:00 PM			27-120			
		8:00 PM			11:00 PM			235-54			
		11:00 PM			2:30 AM			404-25-3			

8. GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK



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