

CO 04 CODE K0-909-D PKG.

→ JAI 11 33740
EST. WGT. 862 1674 LBS.

STD. HRS. TIME

01 YC-16-B 93 4 Lot 29684 100 #
 01 YC-16-B 93 4 Lot 33373 700 #
 01 YC-16-B 93 4 Lot 33474 1000 #

2662
TOTAL WGT 5274# (Req. 0536)

D.V.

PROCESSES		APPROVED BY	
() K0-909-D	(C)	EWK 1-27-78	
()	()	DCG 1-30-78	
()	()	MTW 2-27-78	
()	()		
TYPED BY			
NSA 3-13-78			

Homog #2

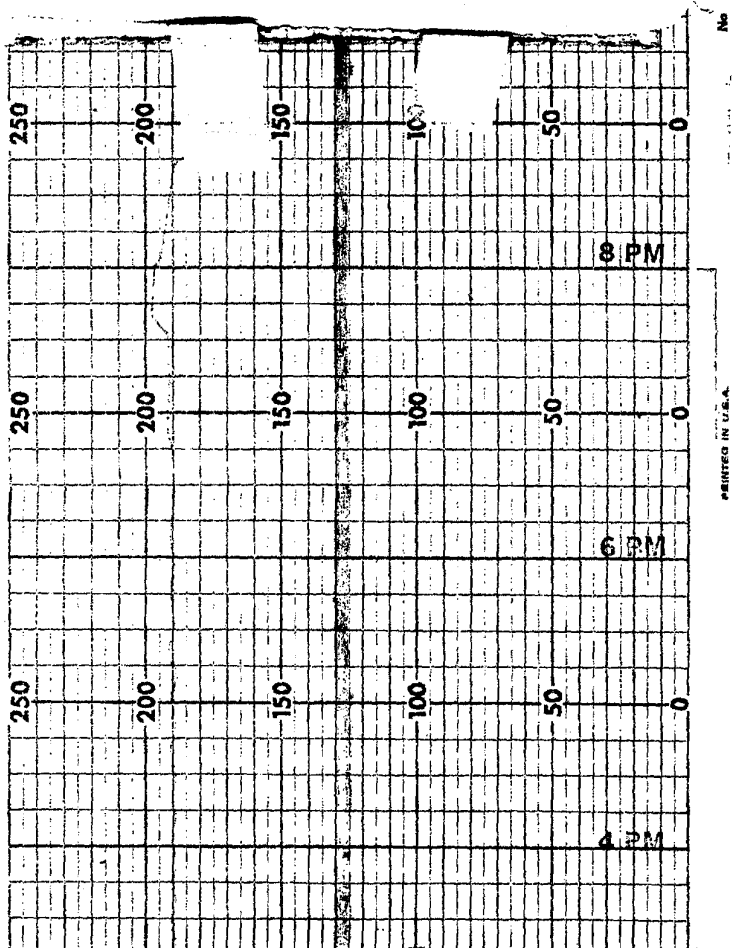
NON-BLEEDING

EQUIPMENT	NAME: KROLOR® ORANGE Y 60" (908)	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 30" (489 G) water into V-211			
8	2 Pour in	480 246	32-D	480 246
208	3 Dump in			
1	Record: Start: 11:30 PM 29684 Fin: 12:30 PM 33474	36	72 x 50	3600 1800
75" (2250)	4 Adj to 63" (1665 G) 2800-3200			
	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 148" and adj to 54" (1981 G)			
	8 Inspect homog strainer & clean if necessary			
208	9 Run 10" (514 G) water into V-245 Install Temp chart			
8	10 start agitator			
SV	11 Pump V-208 thru Homog at 4800-5200 psi into SV 245			
2	Record: Time Start 10:00 AM Total Min 14.5			
	NOTE: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
	12 When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349	13 While Homog, run 6" (284 G) water into V-349			
8	14 Run 1000# water into V-384 and heat to 110-120°F	1387		1387
384	15 Weigh into V-384 and pump to V-349	2775	32-D	2775
3	16 Run 1000# water into V-384 and pump to V-349			
	17 Adj V-349 to 19" (899 G) and stir 15 min or longer 14" (6626)			
	18 Record: Bt 1.578 (14.3 ± 0.2) (1.071-1.072)			
	21 ml			
SV	19 When S 10 Homog complete, adjust SV to 60" (3084 G)			
4	20 Record: pH 10.5 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%	30	7-D	15
	Siphon N-7-D into SV & Record: pH 11.3			
	21 Heat to 190-194°F in 55-65 min and Record: HT °F and Rec °F			
	NOTE: Strike must be started immediately on completion of heating			
343	22 While heating SV, run 49" (1388 G) water into V-343			
8	23 Water in from V-386 M 2 9.50 #/Gal 21.3 Gal		27-D	414
386	24 Stir 15 min or longer			207
5	25 Record: Bt 1.013 (3.4 ± 0.1) (1.013-1.015)			
	3/ml			

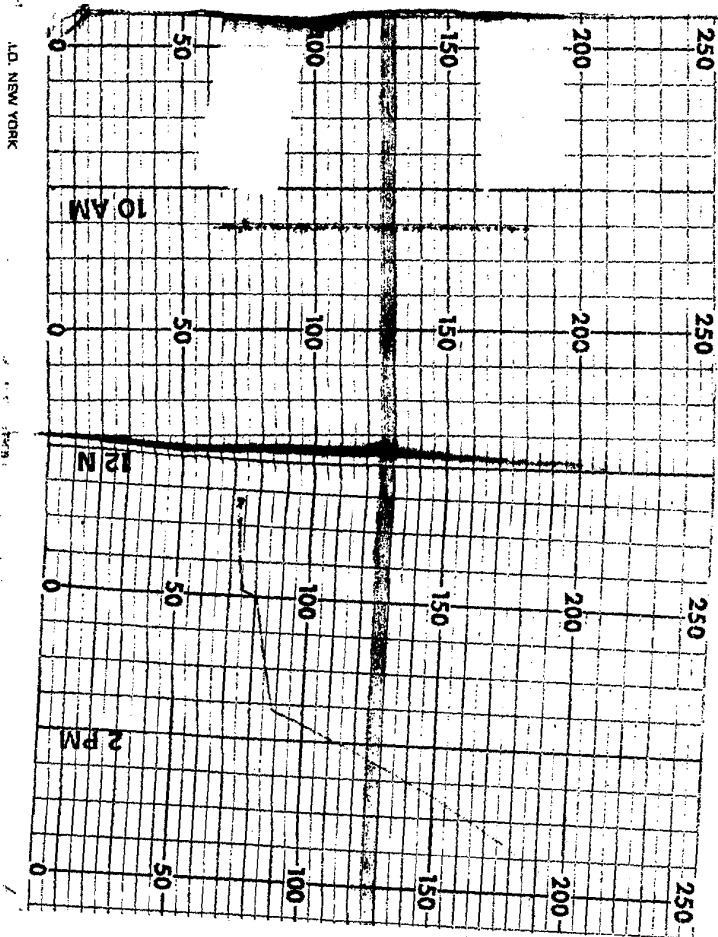
U-245

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/0.2 (9.6-10.2) 26 Set V-343 acid pump at 69 setting (± 225 min) 27 Set V-349 silicate pump at 54 setting (± 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 3:45 PM 7:30 PM 225 V-349 3:45 PM 6:45 PM 180 <table border="1"> <thead> <tr> <th>Record: Time</th><th>V-343 Inches</th><th>V-349 Inches</th><th>SV pH</th><th>Normal pH</th></tr> </thead> <tbody> <tr> <td>at 20 min 4:05 PM</td><td>(46) 46</td><td>(17) 17</td><td>9.7</td><td>9.3-10.0</td></tr> <tr> <td>40 min 4:25</td><td>(41) 41</td><td>(15) 15</td><td>9.7</td><td>9.3-10.0</td></tr> <tr> <td>1 hr 4:45</td><td>(37) 37</td><td>(13) 13</td><td>9.7</td><td>9.3-10.0</td></tr> <tr> <td>2 hrs 5:45</td><td>(23) 23</td><td>(6) 6</td><td>9.7</td><td>9.3-10.0</td></tr> <tr> <td>3 hrs 6:45</td><td>(10) 10</td><td>(0) —</td><td>9.6</td><td>9.3-10.0</td></tr> <tr> <td>Finish 7:30 PM</td><td>(0) —</td><td>—</td><td>8.2</td><td>7.5-8.5</td></tr> </tbody> </table> 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%	Record: Time	V-343 Inches	V-349 Inches	SV pH	Normal pH	at 20 min 4:05 PM	(46) 46	(17) 17	9.7	9.3-10.0	40 min 4:25	(41) 41	(15) 15	9.7	9.3-10.0	1 hr 4:45	(37) 37	(13) 13	9.7	9.3-10.0	2 hrs 5:45	(23) 23	(6) 6	9.7	9.3-10.0	3 hrs 6:45	(10) 10	(0) —	9.6	9.3-10.0	Finish 7:30 PM	(0) —	—	8.2	7.5-8.5			
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	30 Sift in 1 bag	50	27-D 128-A	50																																			
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	477	238 15-A	238 477																																			
302 8	33 Add 38" (465 G) water to V-302 34 Add & stir 2 min for S 64 Assume 50%	296	148 7-D	74 148																																			
PT 9	35 During strike pump into PT 36 Pump In 37 Pump In 38 Stir 10 min with lightning mixer for S 42	482	241 169-A 241 482	27 54 155-A 27 54 160-A 27 54																																			
356 10	39 During strike, Run 22" (268 G) water into V-356 40 Turn on steam 41 Adj to 302 (366 G) at 178-182°F 82°C 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 82°C 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																																						

DUP050095239



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