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

PROCESSES		APPROVED BY
( ) KO-789-D	(I)	EWK 09-21-76
( )	( )	DCG 09-21-76
( )	( )	MTW 10-02-76
( )	( )	FWP 02-05-79
TYPED BY emw020579		

04 CODE KO-789-D PKG.

JAN 15 33828

WGT 509 ~~1132~~ LBS.

OK

10.8 TIME 7 A M

01 YC-16-B 93 4 Lot 32510, 400 #

01 YC-16-B 93 4 Lot 33473, 1700 #

01 YC-16-B 93 4 Lot _____, _____ #

Total Weight ~~5332#~~ 2609 (Req 0548)

NON-BLEEDING

		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run 60" (990 G) water into V-211			265
	2	Weigh in drum & pour in	265 ~~530~~	32-D	~~530~~
	3	Dump in & stir 5 min Lot 42	~~84~~ x 50	YC-16-B	~~4200~~ 3100
		Record: Start 7.45 32510	8		
		Fin 7.10 33473	34		
	4	Adj to 70" 1200 G)	42		
	5	Pump V-211 thru Homog #2 at ~~1800-2200~~ 2800-3200 psi into V-208			
	6	When V-211 MTY, wash coldr thru Homog at 1800-2200 psi using minimum water. Use Hot Water			
	7	Record: V-208 Vol 39 " & adj to 54" (1890 G)			
	8	Inspect Homog strainer & clean if necessary			
208 & SV 2	9	Run 10" (514 G) water into V-247 & start agitator & install temperature chart			
	10	Pump V-208 thru Homog at 4800-5200 psi into SV-247			
		Record: Time Start 8:Am, Total Min 130			
		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 & pump thru Homog at 4800-5200 psi. Rinse in using Hot Water			
349 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run ± 1000 # water into V-384 & heat to 110-120°F	1272		1272
	14	Weigh into V-384 & pump to V-349	~~2930~~	32-D	~~2930~~
	15	Run ± 1000 # water into V-384 & pump to V-349			
	16	Adj V-349 to ~~30" (1400 G)~~ & stir 15 min or longer 22" (1041 G)			
	17	Record: °Be 1.041 g/ml ~~(10.0 ± 0.2)~~ (1.040-1.044)			
SV 4	18	When S 10 Homog complete, adj SV to 45" (2300 G)			
	19	Record: pH 10.6 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	12	7-D	6
		Siphon N-7-D into SV & Record: pH 11.3			
	20	Heat to 190-194°F in 55-65 min & Recrod: HT 192 °F & Rec 192 °F			
		NOTE: Strike must be started immediately on completion of heating			
343 & 386 5	21	While heating SV, run ~~70" (1920 G)~~ 52" (1430 G) water into V-343			
	22	Meter in from V-386 M 4, 7.55 #/Gal 204 Gal		27-D	~~440~~ 195
	23	Stir 15 min or longer			
	24	Record: °Be 1.008 g/ml ~~(2.5 ± 0.1)~~ (1.008-1.009)			

V-247

.PMENT		PAGE 2 CG 04 CODE K0-789-D (I) EST. WGT. 5332 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete, Record: pH 10.0 (9.6-10.2)			
	26	Set V-343 acid pump at ~~26~~ setting (± 255 minutes) 65			
	27	Set V-349 silicate pump at ~~32~~ setting (± 210 minutes) 53			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start / Fin / Min			
		V-343: 245 / 8:00 pm / 315			
		V-349: 245 / 6:45 pm / 240			

Record: Time	V-343 in	V-349 in	SV pH	Normal pH
at 20 min 305	(~~66~~) 49-50	(~~27~~) 20 21	10.0	9.3-10.0
40 min 325	(~~80~~) 45 46	(~~24~~) 18 14	10.0	9.3-10.0
1 hr 345	(~~96~~) 41 42	(~~21~~) 16 16	10.0	9.3-10.0
2¼ hrs 500	(~~34~~) 35 36	(~~13~~) 8 8	9.9	9.3-10.0
3½ hrs 615	(~~23~~) 9 10	(0) +1	9.9	9.3-10.0
Finish 700	(0)		7.3	7.5- 8.5

		NOTE: If pH drops below 9.3 in 1st hr, stop pumps & see Supervisor. If final pH is above 8.5, adj to 7.5-8.5 & Record: pH Assume 77%		27-D	
357 7	30	Run 33" (238 G) water into V-357 & heat to 135-140°F			265
	31	Dump in & stir to dissolve	~~265~~ 530	15-A	~~530~~
314 ~~302~~ 8	~~32~~	Add 42" (514 G) water to V-~~357~~ 314			302
	33	Add & stir 2 min Assume 50%	164 ~~330~~	7-D	~~165~~
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump at zero setting			
	~~35~~	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	~~36~~	Stir 30 min at 190-194°F then turn off steam Record: Start 8:00 pm			
	~~37~~	Run in V-357 from S 31 & stir 5 min			
	~~38~~	Record: pH 2.7 (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 G 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 5.2 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.4 Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	10	7-D	5
		Siphon N-7-D into SV			
	~~41~~	Pour in & stir 15 min	~~12~~ 28	978-A	~~12~~ 28
	~~42~~	Stop agitator			

START	FIN	OPTR
7:15 P	11:08	120 - 101
7AM	3PM	223-282
3 P.M.	10:30 P.M.	101-121

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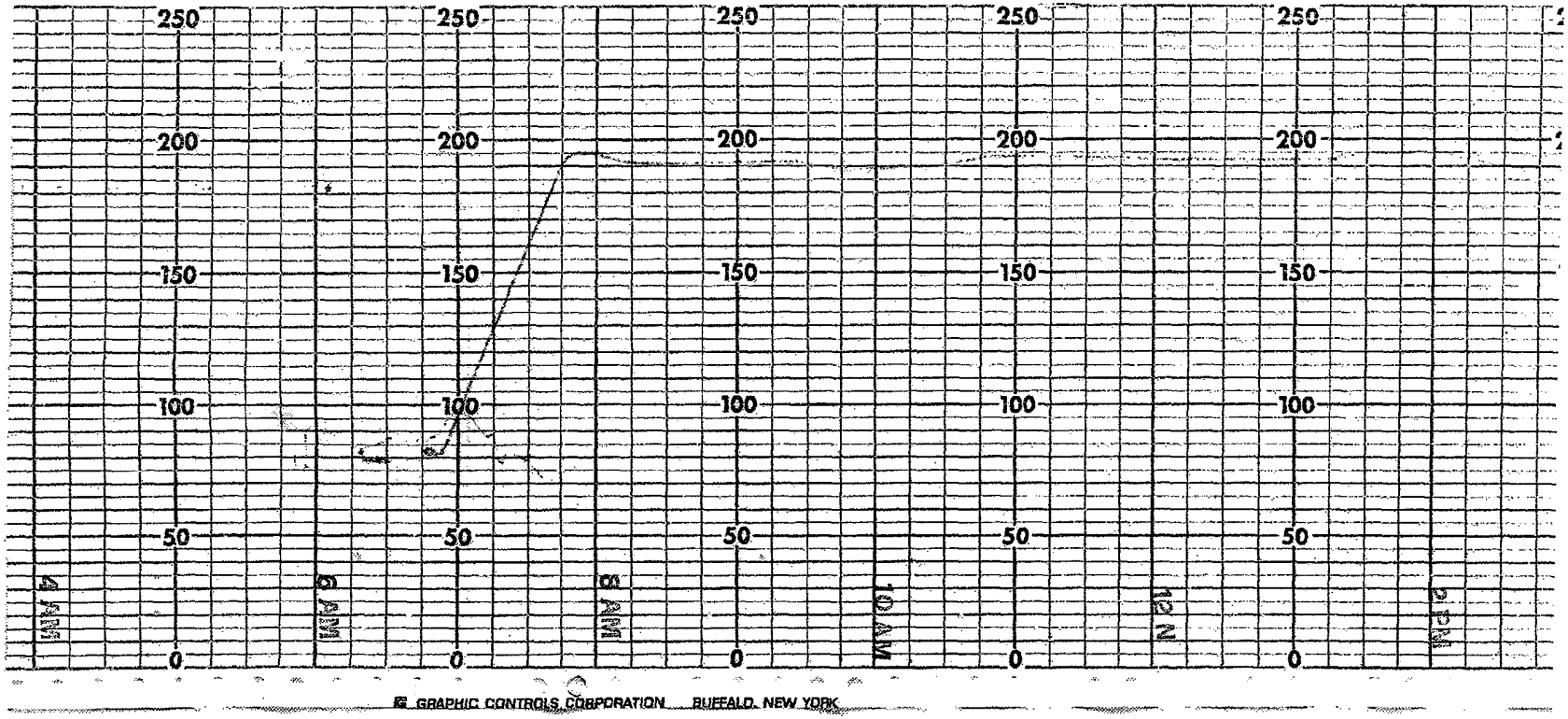
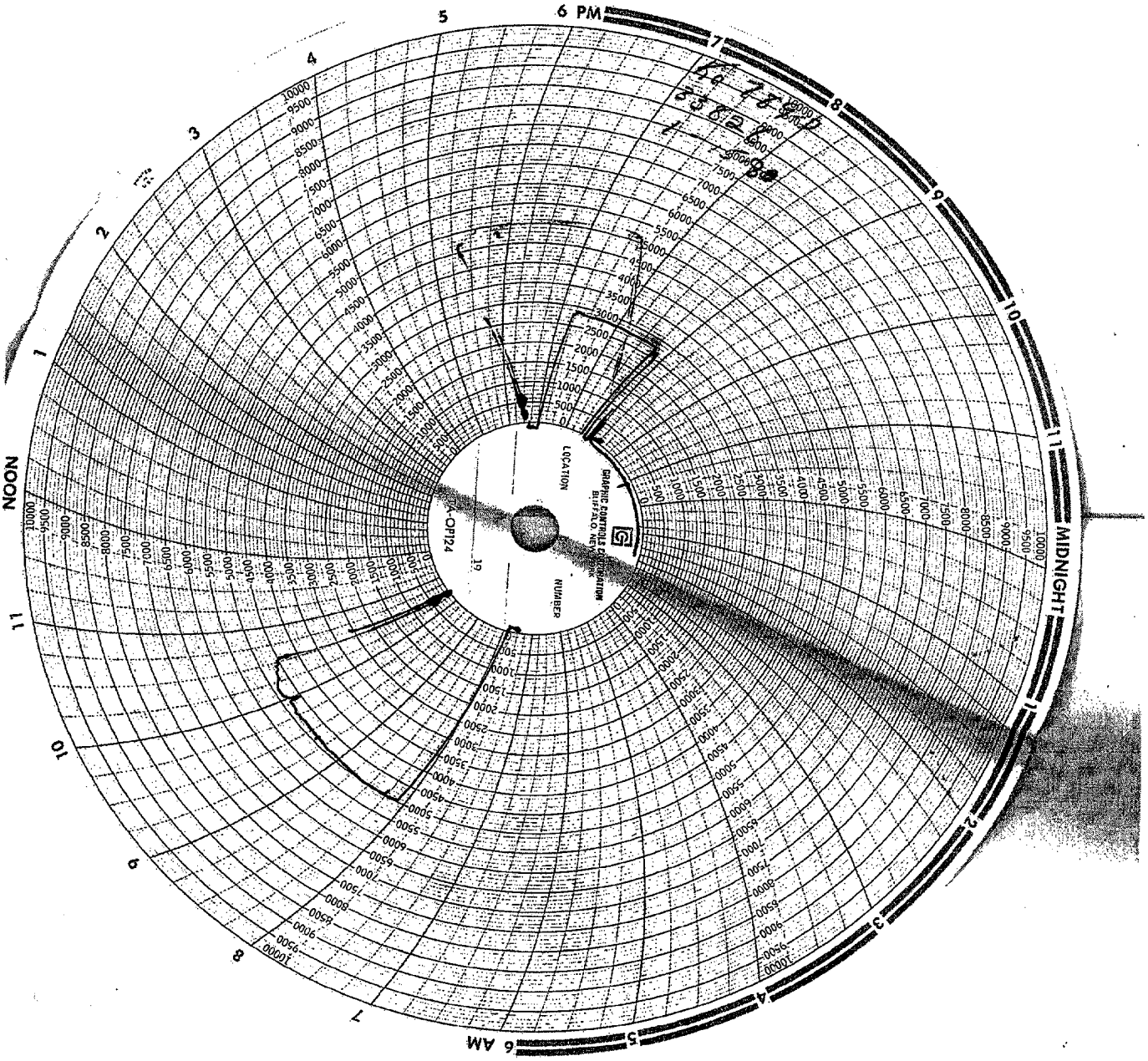
DUP050095267





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