

CG 04 CODE KO-909-D PKG.

EST. WGT. 812 1674 33778 LBS.

STD. HRS. TIME 7 A M

01 YC-16-B 93 4 Lot 32436 900 #

01 YC-16-B 93 4 Lot 32475 900 #

01 YC-16-B 93 4 Lot 2912

TOTAL WGT 5274# (Req. 0539)

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

04 KO909D 98 32969 570#

Homog #2

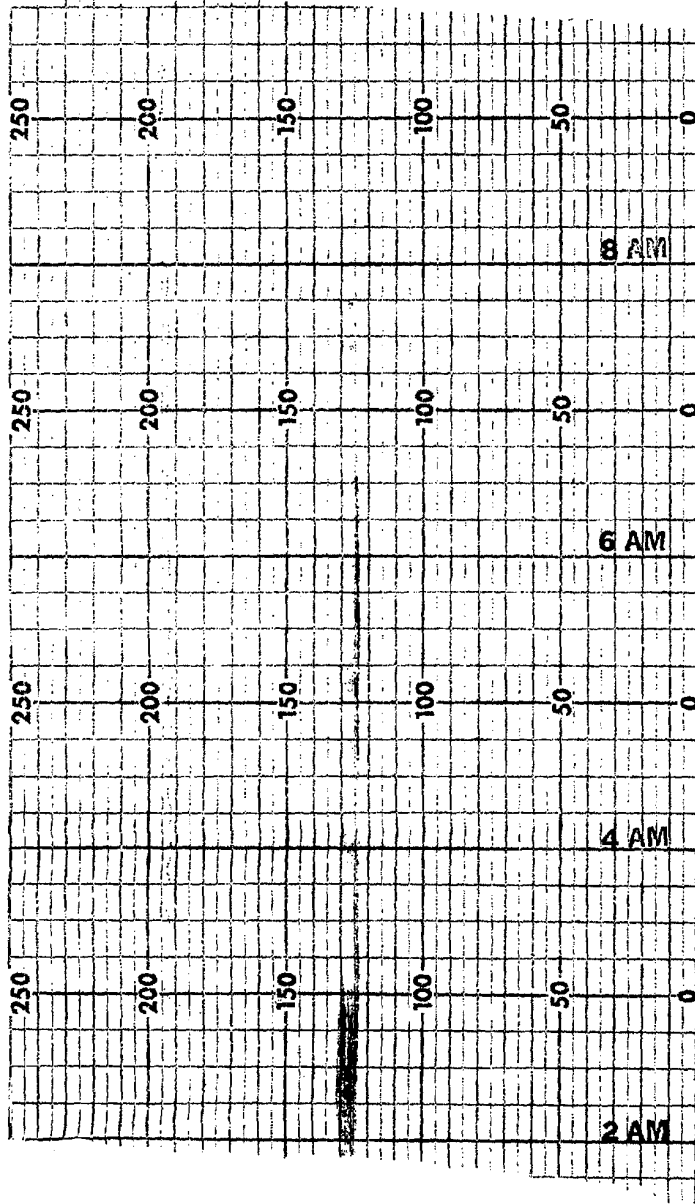
NON-BLEEDING

EQUIPMENT	NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	60" (996 G)			
8	1 Run 30" (488 G) water into V-211			
208	2 Pour in	488 240	32-D	488 240
1	3 Dump in	36	75 x 50	YC-16-B 3600/1800
	Record: Start: 5:45 P.M.	32475		
	Fin: 11:40 P.M.	32510		
75 (12756)	4 Adj to 63" (1065 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 54" 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			
SV	10 Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start 5:40 P.M. Total Min 110			
	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	12 While Homog, run 6" (284 G) water into V-349			
8	13 Run #1000# water into V-384 and heat to 110-120°F	1388		1388
384	14 Weigh into V-384 and pump to V-349	2775	32-D	2775
3	15 Run #1000# water into V-384 and pump to V-349			
	16 Adj V-349 to 19" (899 G) and stir 15 min or longer			
	17 Record: Sp 1.057 (14.3 ± 0.2) (-1.106 -1.107) (1.057-1.061) g/ml			
SV	18 When S 10 Homog complete, adjust SV to 60" (3084 G)			
4	19 Record: pH 10.6 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 11.2			
	20 Heat to 190-194°F in 55-65 min and Record: HT 193°F and Rec 194°F			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 49" (1348 G) water into V-343			
8	22 Meter in from V-386 M 2 9.70 #/Gal 207 Gal 21.3		27-D	414
386	23 Stir 15 min or longer			207
5	24 Record: Sp 1.010 (3.4 ± 0.1) (-1.021 -1.023) (1.009-1.011) g/ml			

V-745

EQUIPMENT	PAGE	CG	CODE	EST. WGT.	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	2	04	KO-909-D (C)	5274				
	25	When S 20 heating complete, Record: pH <u>9.6</u> (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 <u>8:50 PM</u> <u>12:50 PM</u> <u>240</u>						
		V-349 <u>8:50 PM</u> <u>12:10 PM</u> <u>200</u>						
		Record: Time	V-343	V-349	SV pH	Normal pH		
			Inches	Inches				
		at 20 min <u>9:10 PM</u>	(46) <u>47</u>	(17) <u>12</u>	<u>9.5</u>	9.3-10.0		
		40 min <u>9:30</u>	(41) <u>42</u>	(15) <u>15</u>	<u>9.5</u>	9.3-10.0		
		1 hr <u>9:50</u>	(37) <u>38</u>	(13) <u>13</u>	<u>9.5</u>	9.3-10.0		
		2 hrs <u>10:50</u>	(23) <u>24</u>	(6) <u>7</u>	<u>9.5</u>	9.3-10.0		
		3 hrs <u>11:50 PM</u>	(10) <u>13</u>	(0) <u>2</u>	<u>9.7</u>	9.3-10.0		
		Finish <u>12:35 AM</u>	(0) <u>4</u>		<u>8.2</u>	7.5-8.5		
		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%						
	90	Sift in 1 bag						
	26	Add 2 drums of KO-909-D, 32969 Assume						
357 7	21	Run 30" (216 G) water into V-357 and heat to 135-140°F						
	22	Dump in and stir to dissolve for S 61						
302 8	23	Add 38" (465 G) water to V-302						
	24	Add & stir 2 min for S 64 Assume 50%						
PT 9	25	During strike pump into PT						
	26	Pump In						
	27	Pump In						
	28	Stir 10 min with lightning mixer for S 42						
356 10	39	During strike, Run <u>22"</u> (268 G) water into V-356						
	40	Turn on steam						
	41	Adj to <u>20"</u> (366 G) at <u>178-182°F</u> <u>820 C</u>						
	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 <u>820 C</u>						
	45	Stir 30 min at <u>178-182°F</u> 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						

EQUIPMENT	PAGE	CG	04	CODE	K0-909-D (C)	EST. WGT.	5274	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 11 (Con't)	57	When Homog complete, rinse in V-356 with hot water from hot water mixer									
	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 S 32 and stir 5 min									
	62	Record: pH <u>2.9</u> (3.4-3.8)									
	63	If necessary, adj pH to 3.4-3.8 (Downward only) and Record: pH								15-A	
	64	Run in N-7-D from S 34 in 4-6 min and stir 5 min									
	65	Record: pH <u>6.2</u> (6.2-6.4) and if necessary, adj to pH 6.2-6.4 and Record: pH									
		(Dilute 10 parts water to 1 part N-7-D)									
		Siphon N-7-D into SV									
	66	Do Not Stop Agitator									
		START		FIN		OPTR					
		<u>11:00P</u>		<u>7:00A</u>		<u>235-54</u>					
		<u>3:00 PM</u>		<u>11:00 PM</u>		<u>320-144</u>					
		<u>11:00 PM</u>		<u>3:16 PM</u>		<u>342</u>					



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