

CG 04 CODE K0-909-D PKG. _____

→ JAN 25 34014

EST. WGT. 1530 1674 LBS.

STD. HRS. _____ TIME 11 P M

01 YC-16-B 93 4 Lot 33654 1550 #

01 YC-16-B 93 4 Lot 33755 900 #

01 YC-16-B 93 4 Lot 33750 1150 #

5430
TOTAL WGT 5274# (Req. 581)

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			

OK
AP
0A K0909D 98 32769 570

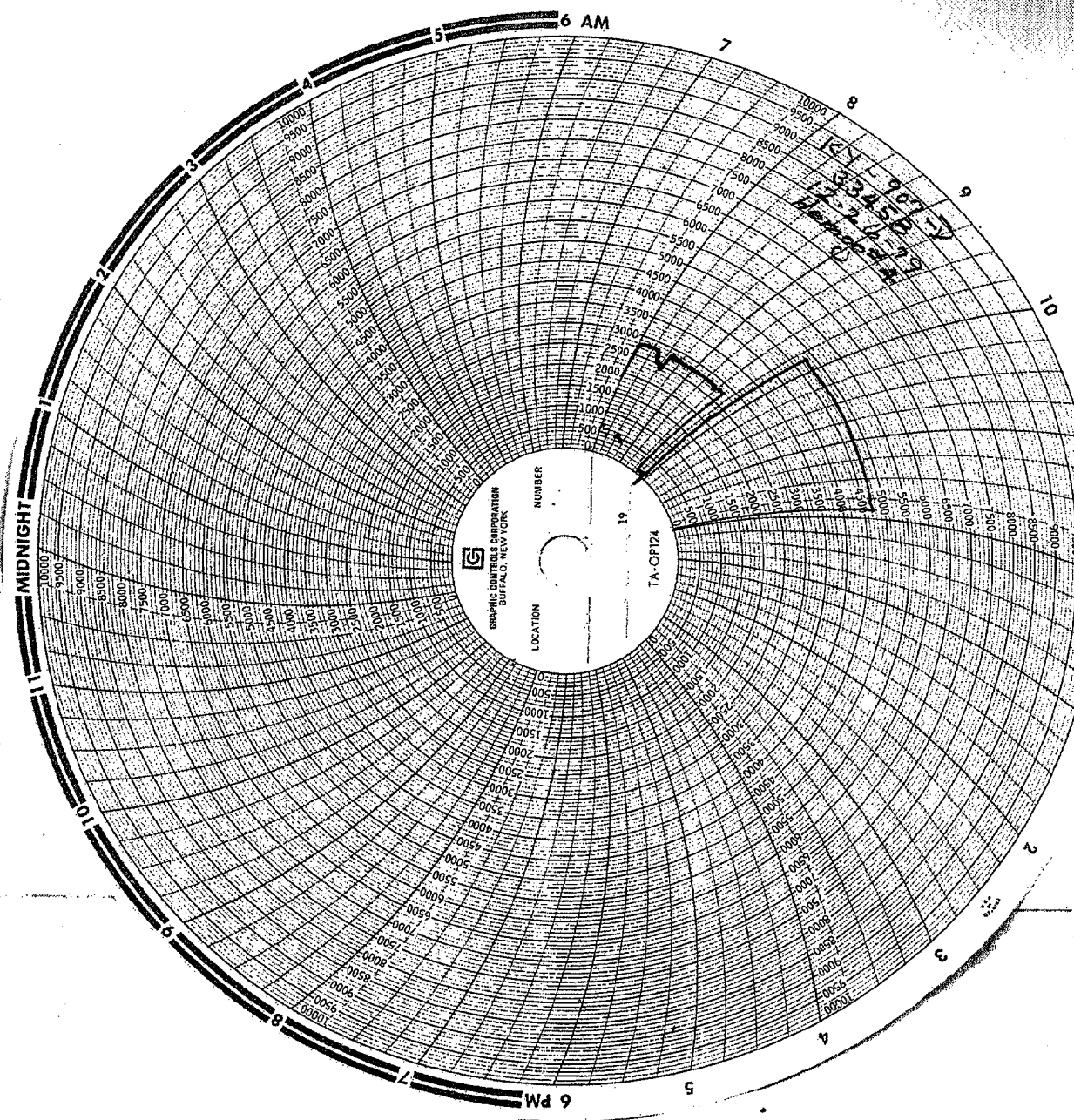
		NON-BLEEDING		
EQUIPMENT	NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 30" (488 G) water into V-211			
&	2 Pour in	488 430	32-D	488 430
208	3 Dump in	72 x 50	YC-16-B	3600
1	Record: Start: 9:00 PM Lot 33654 1550			
	Fin: 10:30 PM 33755 900			
	25" (12756) 33750 1150			
	4 Adj to 63" (1065 G) 2500-3200			
	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 50" and adj to 54" (1981 G)			
	8 Inspect homog strainer & clean if necessary			
208	9 Run 10" (514 G) water into V-242. Install Temp chart			
&	10 start agitator			
SV	11 Pump V-208 thru Homog at 4800-5200 psi into SV			
2	Record: Time Start 9:45 PM Total Min 130			
	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			
&	14 Run 1000# water into V-384 and heat to 110-120°F	2500		2500
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			
	18 Record: Be 1.02 (14.3 ± 0.2) (1.091-1.094)			
SV	19 When S 10 Homog complete, adjust SV to 60" (3084 G)			
4	20 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%	10	7-D	
	Siphon N-7-D into SV & Record: pH 11.2			
	21 Heat to 190/194°F in 55-65 min and Record: HT 19.2°F and Rec 19.2°F			
	NOTE: Strike must be started immediately on completion of heating			
343	22 While heating SV, run 49" (1348 G) water into V-343			
&	23 Meter in from V-384 M-23 9.433#/Gal 39.3		27-D	414
386	24 Stir 15 min or longer			373
5	25 Record: °Be 1.020 (3.4 ± 0.1) (1.018-1.020)			

V-247

IPMENT	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 <u>10.1</u> (9.6-10.2)							
	26 Set V-343 acid pump at <u>(69)</u> setting (± 225 min)							
	27 Set V-349 silicate pump at <u>(54)</u> 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>6:30A</u>	<u>260</u>				
		V-349	<u>5:00AM</u>	<u>260</u>				
	Record:	Time	V-343	V-349	SV pH	Normal pH		
		Inches	Inches					
	at 20 min	<u>46</u>	<u>(17) 17</u>	<u>9.9</u>	9.3-10.0			
	40 min	<u>41</u>	<u>(15) 15</u>	<u>9.9</u>	9.3-10.0			
	1 hr	<u>37</u>	<u>(13) 13</u>	<u>9.9</u>	9.3-10.0			
	2 hrs	<u>24</u>	<u>(6) 6</u>	<u>9.9</u>	9.3-10.0			
	3 hrs	<u>10</u>	<u>(0) 0</u>	<u>9.9</u>	9.3-10.0			
	Finish	<u>(0)</u>		<u>8.0</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%							
	30	Stir in 1 bag				50	27-D	50
	31	Add 1 drum at end of strike				570	128-A	570
357 7	31	Run 30" (216 G) water into V-357 and heat to 135-140°F						
	32	Pump in and stir to dissolve for S 61				477	15-A	477
302 8	33	Add 38" (465 G) water to V-302						
	34	Add & stir 2 min for S 64			Assume 50%	296	7-D	148
PT 9	35	During strike pump into PT				482	169-A	482
	36	Pump In				54	155-A	54
	37	Pump In				54	160-A	54
	38	Stir 10 min with lightning mixer for S 42						
356 10	39	During strike, Run 22" (268 G) water into V-356						
	40	Turn on steam						
	41	Adj to 30" (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						
	45	Stir 30 min at 178-182°F for S 55 82°C						
	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						

DUP050095506

EQUIPMENT	PAGE 3 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>3.8</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 <u>6.2</u> Assume 78% (Dilute 10 parts water to 1 part N-7-D) Assume 50%	50	27-D 7-D	25
	Siphon N-7-D into SV			
	66 Do Not Stop Agitator			
	START 3:00 PM	FIN 11:00 PM	OPTR 409-438	
	7:00 AM	10:15 AM	320-144	



V-244



