S.V. 246, 247 (245) C.V. PUNCHED & CHECKED D.V.

MAKING INSTRUCTIONS: BATCH UNIT

CO 04 CODE KO-909-D PKG. ____

→ JAN 11 33740

EST. WGT. 862 ~~1674~~ LBS.

STD. HRS. ____ TIME ____ M 11PM

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

OK

Homog #2

01 YC-16-B 93 4 Lot 29684 , 100 #
01 YC-16-B 93 4 Lot ~~32373~~ 32435 , 700 #
01 YC-16-B 93 4 Lot 33474 , 1000 #

TOTAL WGT ~~5274~~ 2662# (Req. 0536)

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run ~~30" (488 G)~~ 60" (990G) water into V-211			
	2	Pour in	~~480~~ 240	32-D	~~480~~ 240
	3	Dump in Lot 36	~~72~~ x 50	YC-16-B	~~3600~~ 1800
		Record: Start: 11:30 PM 29684	2		
		Fin: 12:30 PM 32435	14		
		~~80" (1300G)~~ 33474	20		
75" (1275G)	4	Adj to ~~63" (1065 G)~~ 2800-3200			
	5	Pump V-211 thru Homog #2 at ~~1800-2200~~ psi into V-208	30		
	6	When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
	7	Record: V-208 Vol 48" and adj to 54" (1981 G)			
	8	Inspect homog strainer & clean if necessary			
208 & SV 2	9	Run 10" (514 G) water into V-245 Install Temp chart & start agitator			
	10	Pump V-208 thru Homog at 4800-5200 psi into SV 245			
		Record: Time Start 10 AM Total Min 145			
		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 & 384 3	12	While Homog, run 6" (284 G) water into V-349			
	13	Run *1000# water into V-384 and heat to 110-120°F	1387		1387
	14	Weigh into V-384 and pump to V-349	~~2775~~	32-D	~~2775~~
	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 14" (662G)			
	17	Record: ~~Be~~ 1.072 ~~(14.3 ± 0.2)~~ ~~(1.106-1.109)~~ (1.071-1.072) g/mL			
SV 4	18	When S 10 Homog complete, adjust SV to 60" (3084 G)			
	19	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			
	20	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 & 386 5	21	While heating SV, run ~~49" (1348 G)~~ 37" (1018G) water into V-343			
	22	Meter in from V-386 M 2 9.70 #/Gal 21.3 Gal		27-D	~~414~~ 207
	23	Stir 15 min or longer			
	24	Record: ~~°Be~~ 1.013 ~~(3.4 ± 0.1)~~ ~~(1.021-1.023)~~ (1.013-1.015) g/mL			

K 13629 REV.

U-245

EQUIPMENT		PAGE 2 CG 04 CODE KO-909-D (C) EST. WGT. 5274 LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete, Record: pH 10.2 (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			

Record: Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
at 20 min 4:05 PM	(46) 44	(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

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%		27-D	
	30	Sift in 1 bag	50	128-A	50
357 7	31	Run 30" (216 G) water into V-357 and heat to 135-140°F			238
	32	Pump in and stir to dissolve for S 61	~~477~~ 238	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~~ 148	7-D	~~296~~ 148
PT 9	35	During strike pump into PT	~~482~~ 241	169-A	~~482~~ 241
	36	Pump In	~~27 54~~ 27	155-A	~~27 54~~ 27
	37	Pump In	~~27 54~~ 27	160-A	~~27 54~~ 27
	38	Stir 10 min with lightning mixer for S 42			
356 10	39	During strike, Run ~~22"~~ 15" (268 G) water into V-356			
	40	Turn on steam			
	41	Adj to ~~30"~~ 28" (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			

K-13880 REV.

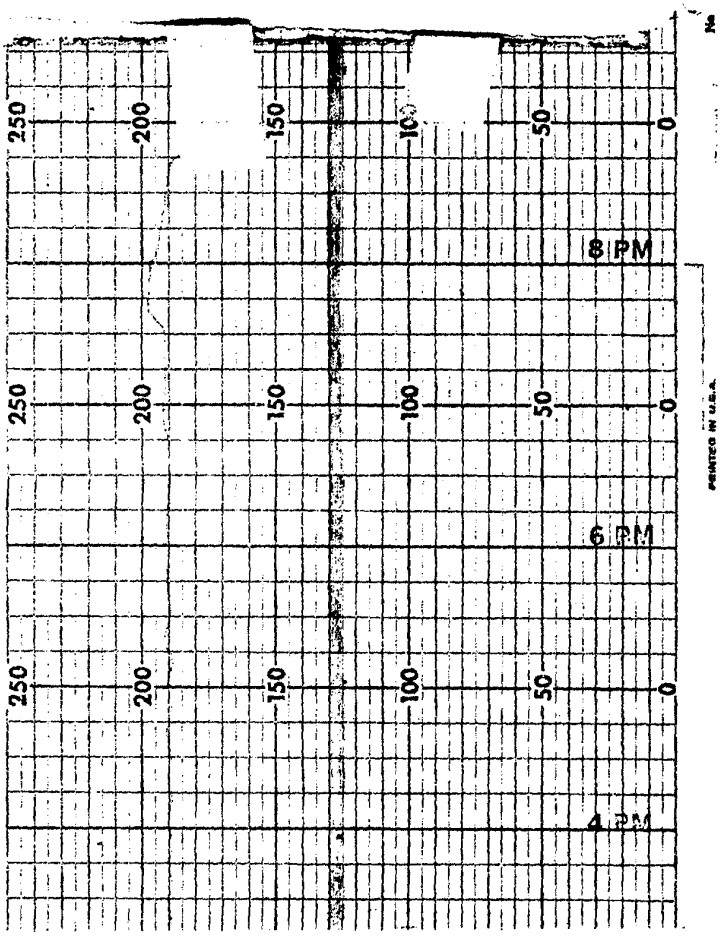
DUP050095238

EQUIPMENT		PAGE 3 CG 04 CODE KO-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 3.1 (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 3.8 (6.2-6.4) and if necessary, adj to pH 6.2-6.4 and Record: pH 6.2 Assume 78%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	30	7-D	15
		Siphon N-7-D into SV			
	66	Do Not Stop Agitator			

START	FIN	OPTR
12:30 AM	9:00 AM	235-323
1 PM	3 PM	282-387
Steady	10:45 PM	237-320

K 13880 REV.

DUP050095239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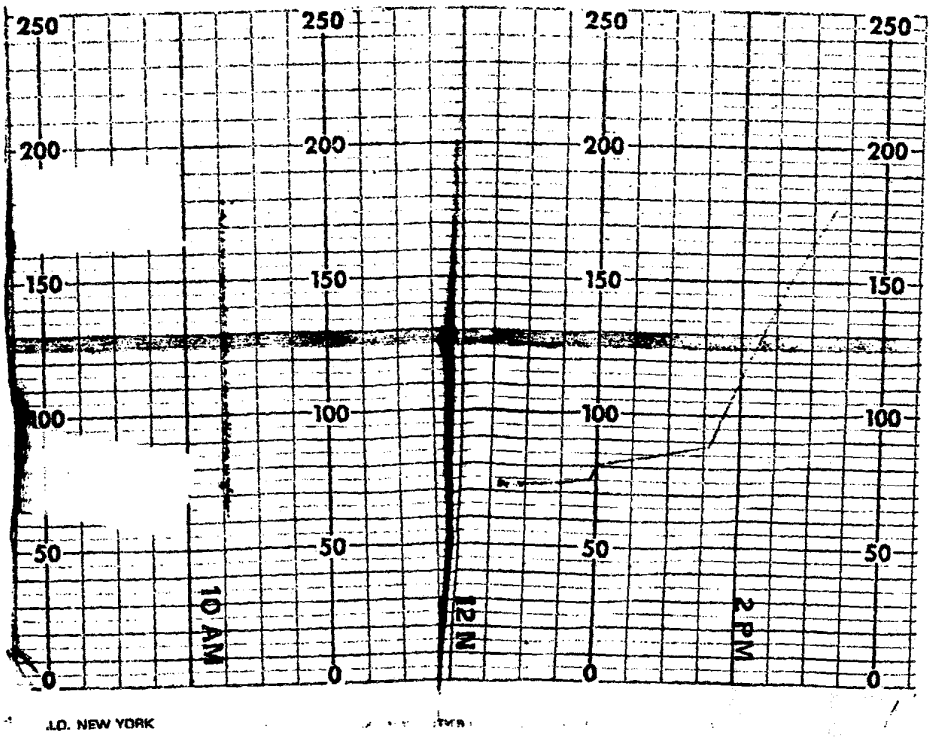
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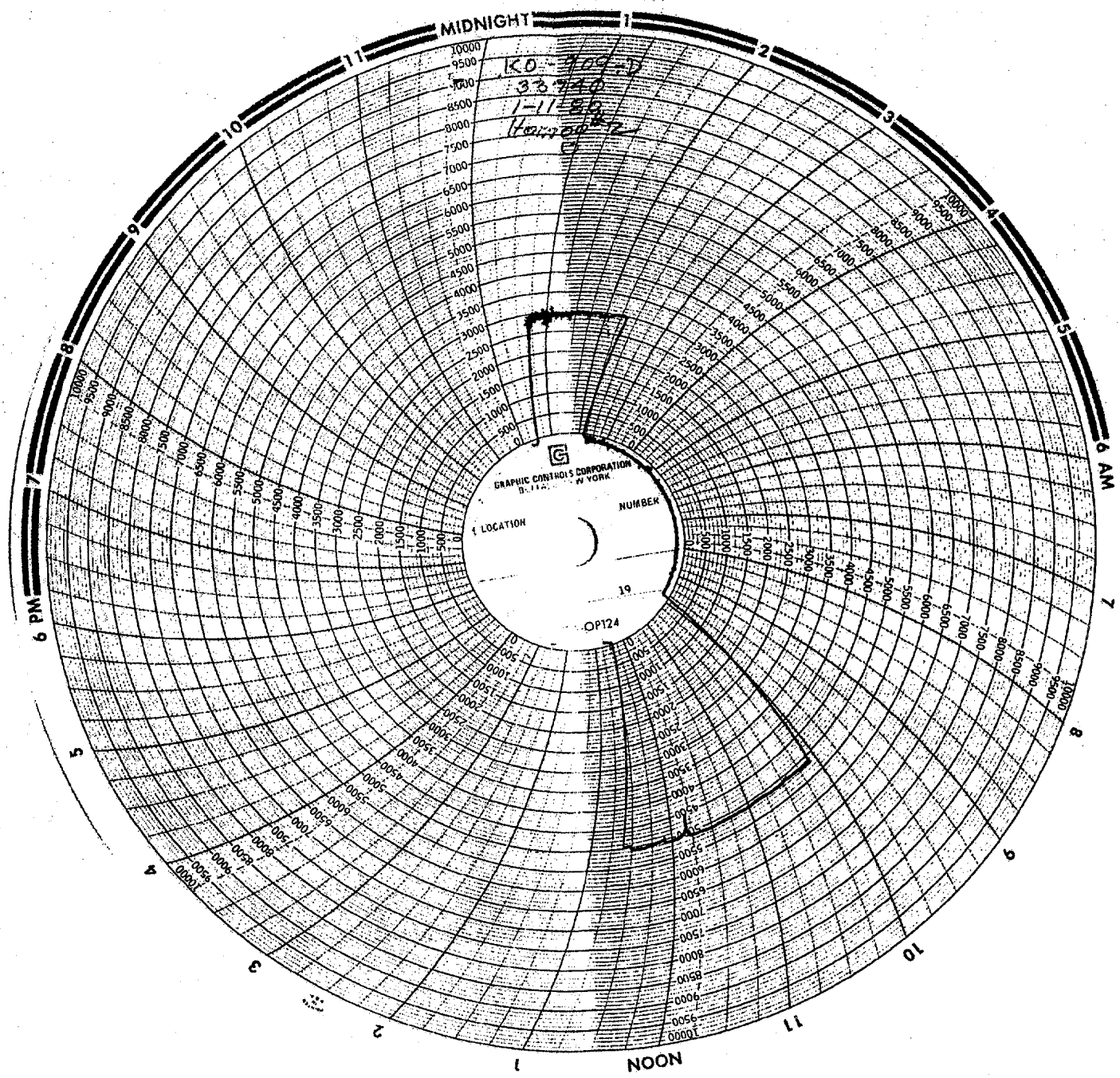

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