

CO 04 CODE KO-909-D PKO.

JAN 14 33802

EST. WGT. 812 1574 LBS.

STD. HRS. TIME 7 A M

01 YC-16-B 93 4 Lot 30094 100 #

01 YC-16-B 93 4 Lot 32435 500 #

01 YC-16-B 93 4 Lot 33475 1200 #

TOTAL WGT 5274# (Req. 544)

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			

EQUIPMENT		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211 & 208		60" (990 G)			
1		Run 30" (489 G) water into V-211			
		Pour in	489 240	32-D	489 240
		Dump in	36		
		Record: Start: 8:32 P.M. Lot 30094	78 x 50	YC-16-B	3600
		Ein: 9:35 P.M. 32435	100		1700
		75" (1275 G) 33475	580		
		Adj to 63" (1065 G) 2801-3300	1200		
		Pump V-211 thru Homog #2 at 1800-2200 psi into V-208			
		When V-211 MTY, wash color thru Homog at 1800-2200 psi using minimum water			
		Record: V-208 Vol 46" and adj to 54" (1981 G)			
		Inspect homog strainer & clean if necessary			
208 & SV		Run 10" (514 G) water into V-245. Install Temp chart			
2		Start agitator			
		Pump V-208 thru Homog at 4800-5200 psi into SV			
		Record: Time Start 3:25 P Total Min 205			
		NOTE: If homog pressure falls below 4800 psi, 3-way valve will recirculate slurry to V-208			
		When V-208 MTY, run in 5" (240 G) water and pump thru Homog at 4800-5200 psi			
349 & 384		While Homog, run 6" (284 G) water into V-349			
3		Run 1000# water into V-384 and heat to 110-120°F	1388		1388
		Weigh into V-384 and pump to V-349	2775	32-D	2775
		Run 1000# water into V-384 and pump to V-349			
		Adj V-349 to 19" (899 G) and stir 15 min or longer			
		Record: Be 1.057 (14.5 ± 0.2) (1.057 - 1.061) g/ml			
SV 4		When S 10 Homog complete, adjust SV to 60" (3084 G)			
		Record: pH 10.4 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	5
		Siphon N-7-D into SV & Record: pH 11.1			
		Heat to 190-194°F in 55-65 min and Record: HT 177°F and Rec 177°F			
		NOTE: Strike must be started immediately on completion of heating			
343 & 386		While heating SV, run 49" (1348 G) water into V-343			
5		Water in from V-386 M 4 9 ml #/Gal 217 Gal		27-D	414
		Stir 15 min or longer			207
		Record: Be 1.010 (3.4 ± 0.1) (1.009 - 1.011) g/ml			

V-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 <u>10.0</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	11:00/PM	3:00 AM	240			
		V-349	11:00/PM	2:10A	190			
		Record: Time	V-343	V-349	SV pH	Normal pH		
		11:00	Inches	Inches				
		at 20 min 11:20	(46)	(17)	9.8	9.3-10.0		
		40 min 11:40	(41)	(15)	9.8	9.3-10.0		
		1 hr 12:00	(37) 32	(13) +	9.7	9.3-10.0		
		2 hrs 1:00	(23) 2.5	(6) 7-	9.8	9.3-10.0		
		3 hrs 2:00	(10)	(0) 1	9.7	9.3-10.0		
		Finish 3:00	(0)		8.0	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 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% 148 296	7-D 148	
PT 9	35	During strike pump into PT				482 241	169-A 241 482	
	36	Dump In				54 27	155-A 27 54	
	37	Dump In				54 27	160-A 27 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	Add 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 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 50 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						

4100/AM

K 13330 2V

V-245

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 Ste 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>5.0</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>4.2</u> (6.2-6.4) and if necessary, adj to pH 6.2-6.4 and Record: pH <u>6.4</u> Assume 78% Assume 50%	20	27-D 7-D	70
	66 Siphon N-7-D into SV			
	66 Do Not Stop Agitator			
	START	FIN	OPTR	
	<u>11:00 PM</u>	<u>7:00 AM</u>	<u>235-342</u>	
	<u>7:00 AM</u>	<u>3:00 PM</u>	<u>438-405</u>	
	<u>3 P</u>	<u>11 P</u>	<u>101-120</u>	
	<u>11:00 P</u>	<u>5:00 AM</u>	<u>235-301</u>	





