

S.V.

246, 247

TO SV AT END OF STRIKE

C.V.

MARINE INSTRUCTIONS: BATCH UNIT

D.V.

CO 04 CODE KO-909-D PKG.

JAN 25 34014

EST. WGT. 1530 1674 LBS.

STD. HRS. TIME 11 P M

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			

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 #

04 K0909D 98 32769 570

TOTAL WGT 5274# (Req. 581)

NON-BLEEDING

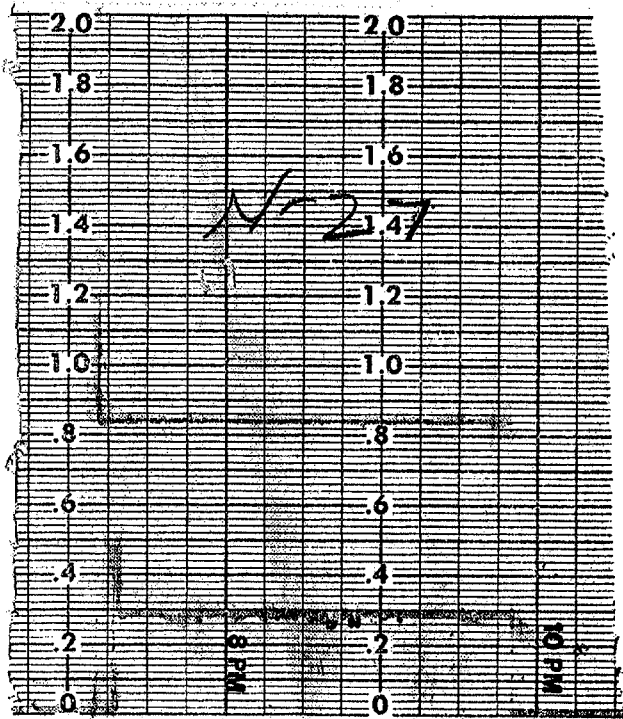
EQUIPMENT		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	1	Run 30" (488 G) water into V-211			
&	2	Pour in	488 430	32-D	488 430
208	3	Dump in	72 x 50	YC-16-B	3600
1		Record: Start: 9:00 PM Lot 33654 1550 #			
		Fin: 10:30 PM 33755 900 #			
		25" (12756) 33750 1150 #			
	4	Adj to 63" (1065 G) 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 & start agitator			
SV	10	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			
	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			
&	13	Run 1000# water into V-384 and heat to 110-120°F	2500		2500
384	14	When 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: Be 1.094 (14.3 ± 0.2) (1.091-1.094)			
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%	10	7-D	1
		Siphon N-7-D into SV & Record: pH 11.7			
	20	Heat to 190-194°F in 55-65 min and Record: HT 194°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			
&	22	Water in from V-384 M 23 9.433 #/Gal 39.5 Gal		27-D	414
386	23	Stir 15 min or longer			373
5	24	Record: Be 1.020 (3.4 ± 0.1) (1.018-1.020)			

V-247

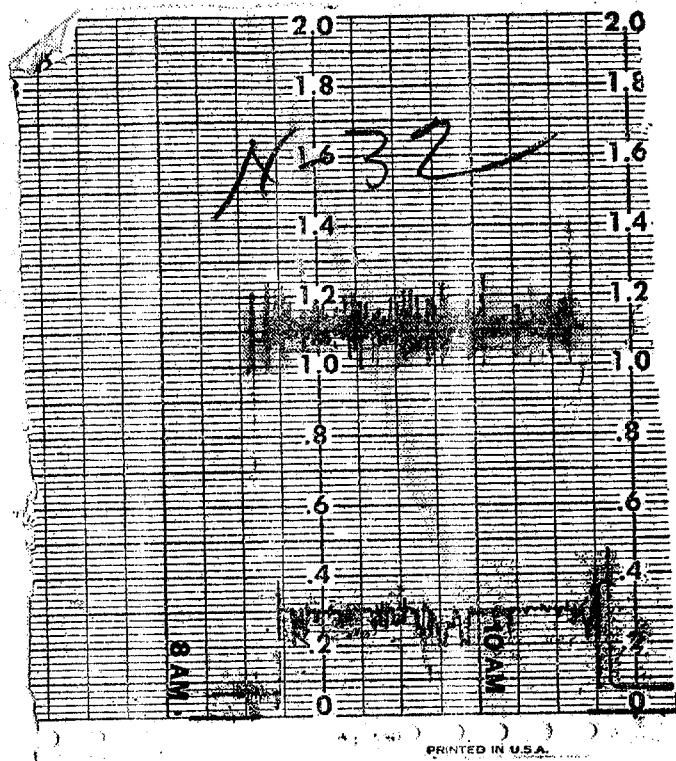
IPMENT	PAGE 2	CG 04	CODE KO-909-D (C)	EST. WGT. 5274	LBS.	USE LBS.	N CODE	ACCT. LBS.
SV 6	25 When S 20 heating complete, Record: pH <u>10.1</u> (9.6-10.2)							
	26 Set V-343 acid pump at <u>(69)</u> setting (± 225 min)							
	27 Set V-349 silicate pump at <u>(54)</u> setting (± 180 min)							
	28 Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike							
	Record:	Start	Finish	Min				
		V-343	<u>6:20A</u>	<u>260</u>				
		V-349	<u>5:00AM</u>	<u>200</u>				
	Record:	Time	V-343	V-349	SV pH	Normal pH		
			Inches	Inches				
	at 20 min	<u>2 1/2</u>	(46) <u>46</u>	(17) <u>17</u>	<u>9.9</u>	9.3-10.0		
	40 min	<u>3 1/2</u>	(41) <u>41</u>	(15) <u>15</u>	<u>9.9</u>	9.3-10.0		
	1 hr	<u>4 1/2</u>	(37) <u>37</u>	(13) <u>13</u>	<u>9.9</u>	9.3-10.0		
	2 hrs	<u>5 1/2</u>	(23) <u>24</u>	(6) <u>6</u>	<u>9.9</u>	9.3-10.0		
	3 hrs	<u>6 1/2</u>	(10) <u>10</u>	(0) <u>1</u>	<u>9.9</u>	9.3-10.0		
	Finish	<u>7</u>	(0)		<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	32 Run 30" (216 G) water into V-357 and heat to 135-140°F					477	15-A	477
	33 Pump in and stir to dissolve for S 61							
302 8	34 Add 38" (465 G) water to V-302							
	35 Add & stir 2 min for S 64				Assume 50%	296	7-D	148
PT 9	36 During strike pump into PT					482	169-A	482
	37 Pump In					54	155-A	54
	38 Pump In					54	160-A	54
	39 Stir 10 min with lightning mixer for S 42							
356 10	40 During strike, Run ¹⁵ 22" (268 G) water into V-356							
	41 Turn on steam							
	42 Adj to 200°/(366 G) at 178-182°F 80°C							
	43 Pump PT, mixture from S 38 thru undersurface distributor AFAP							
	44 Rinse PT with HOT water from hot water mixer & pump in							
	45 Shut off pump							
	46 Stir 30 min at 178-182°F for S 55 80°C							
	47 Do Not Shut Off Agitator							
SV 11	48 When V-349 MTY, rinse in with minimum water then set pump to zero setting							
	49 When V-343 MTY, rinse in with minimum water then turn off pump motor							
	50 Stir 60 min at 190-194°F							
	51 Heat to 198-200°F in 5-10 min							
	52 Close water line & discharge valves at stearate pump							
	53 Open V-356 discharge valves to stearate pump inlet							
	54 Open water valve at stearate pump & run water thru Homog at 2900-3100 PSI to sewer							
	55 While Homog water at 2900-3100 PSI, open Homog discharge valve to SV & close valve to sewer							
	56 Immediately open stearate pump discharge valve, turn on pump & Homog V-356 to SV at 2800-3100 PSI maintain SV at 198-200°F							
	57 While Homog V-356 to SV, Shut off water valve at stearate pump ASAP							

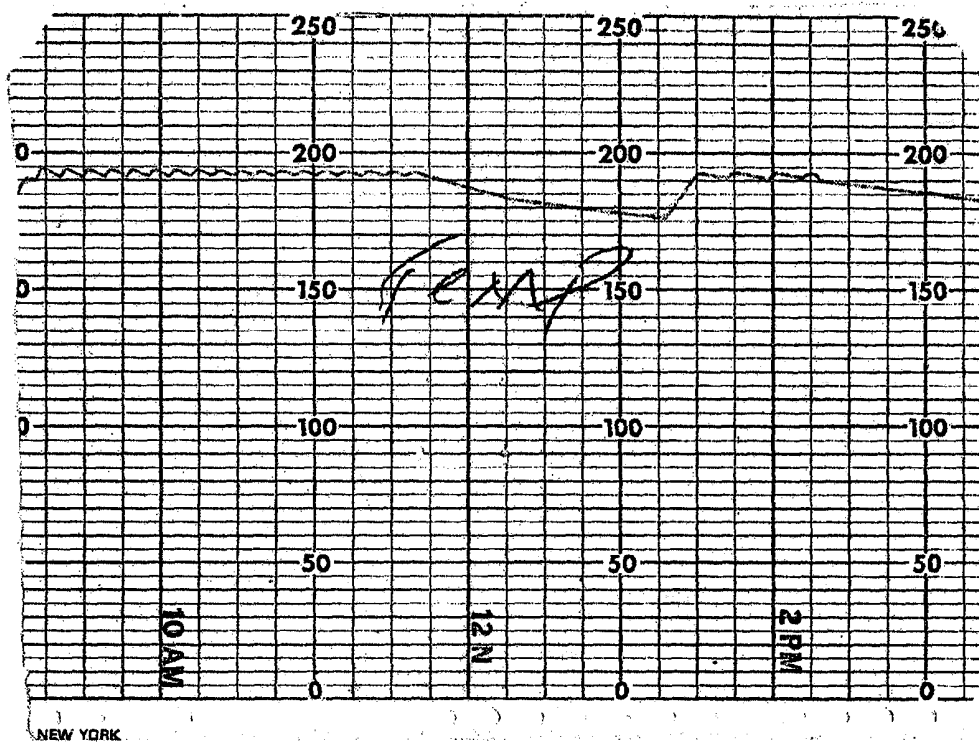
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V-244



BUFFALO, NEW YORK





NEW YORK

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