S.V. ~~246~~ 247 C.V. D.V. MAKING INSTRUCTIONS: BATCH UNIT

CG 04 CODE K0-909-D PKG.

→ [redacted] [redacted] JAN ~~27~~ 28 34065 OK'

EST. WGT. 1530 ~~1674~~ LBS.

STD. HRS. TIME 11P 9A M (1)

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		

01 YC-16-B 93 4 Lot 31747, 200#
01 YC-16-B 93 4 Lot 33910, 200# JN
01 YC-16-B 93 4 Lot 33953, 1950# Homog #2
5130

01 YC-16-B 93 33755 1250#

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

NON-BLEEDING

EQUIPMENT		NAME: KROLOR® ORANGE Y (Lot# (9906))	USE LBS.	N CODE	ACCT. LBS.
211 & 208 1	1	Run ~~30" (488 G)~~ water into V-211			
	2	Pour in	~~480~~ 450	32-D	~~480~~ 450
	3	Dump in Lot	72 x 50	YC-16-B	3600
		Record: Start: 7:30 A.M. 31747	200		
		Fin: 9:30 A.M. 33910	200		
		75" (1275G) 33953	1950		
	4	Adj to 63" ~~(1065 G)~~ 2800-3200 33755	1250		
	~~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 41 " and adj to 54" (1981 G)~~			
	~~8~~	~~Inspect homog strainer & clean if necessary~~			
208 & SV 2	~~9~~	~~Run 10" (514 G) water into V-247 Install Temp chart & start agitator~~			
	~~10~~	~~Pump V-208 thru Homog at 4800-5200 psi into SV~~			
		~~Record: Time Start 9:40 P Total Min 150~~			
		~~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~~	~~2500~~		~~2500~~
	~~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~~			
	~~17~~	~~Record: Be' 1.094 (14.3 ± 0.2) (1.091-1.094) g/mL~~			
SV 4	~~18~~	~~When S 10 Homog complete, adjust SV to 60" (3084 G)~~			
	~~19~~	~~Record: pH 10.7 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 11.2			
	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) water into V-343~~			
	~~22~~	~~Meter in from V-386 M 14 9.3 #/Gal 39.8 Gal~~		27-D	~~414~~ 373
	~~23~~	~~Stir 15 min or longer~~			
	~~24~~	~~Record: °Be' 1.020 (3.4 ± 0.1) (1.018-1.020) g/mL~~			
				JN	

(13829 REV.

V-247

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EQUIPMENT			USE LBS.	N CODE	ACCT. LBS.
SV 6	25	When S 20 heating complete, Record: pH 10.1 (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 6:15 Am / 10:30 AM / 245			
		V-349 6:15 Am / 9:18 AM / 183			

Record: Time	V-343 Inches	V-349 Inches	SV pH	Normal pH
at 20 min 6:35 Am	(46) 47	(17) 17	10.0	9.3-10.0
40 min 6:55 Am	(41) 42	(15) 15	10.0	9.3-10.0
1 hr 7:15 Am	(37) 38	(13) 13	10.0	9.3-10.0
2 hrs 8:15 Am	(23) 25	(6) 6	9.9	9.3-10.0
3 hrs 9:15 Am	(10) 12	(0) 0	9.9	9.3-10.0
Finish 10:00 Am	(0) 0	0	7.3	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			
	32	Dump 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" (15") (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 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			

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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 557 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 5.1 (6.2-6.4) and if necessary, adj to pH 6.2-6.4 and Record: pH 6.3 Assume 78%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	40	7-D	20
		Siphon N-7-D into SV			
	66	Do Not Stop Agitator			

START	FIN	OPTR
3:00 PM	11:00 PM	235
7 Am	2:00 pm	37/320

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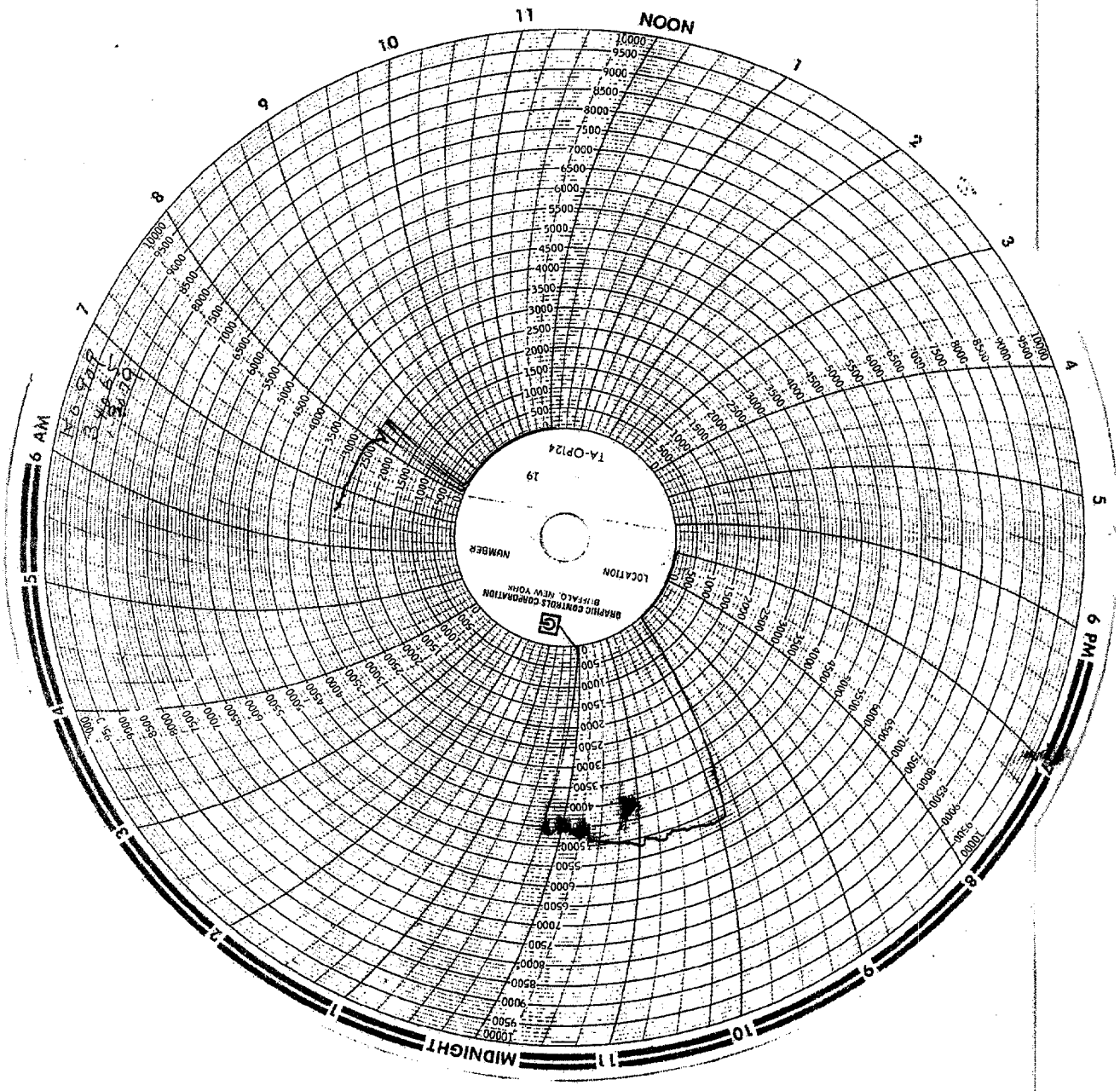

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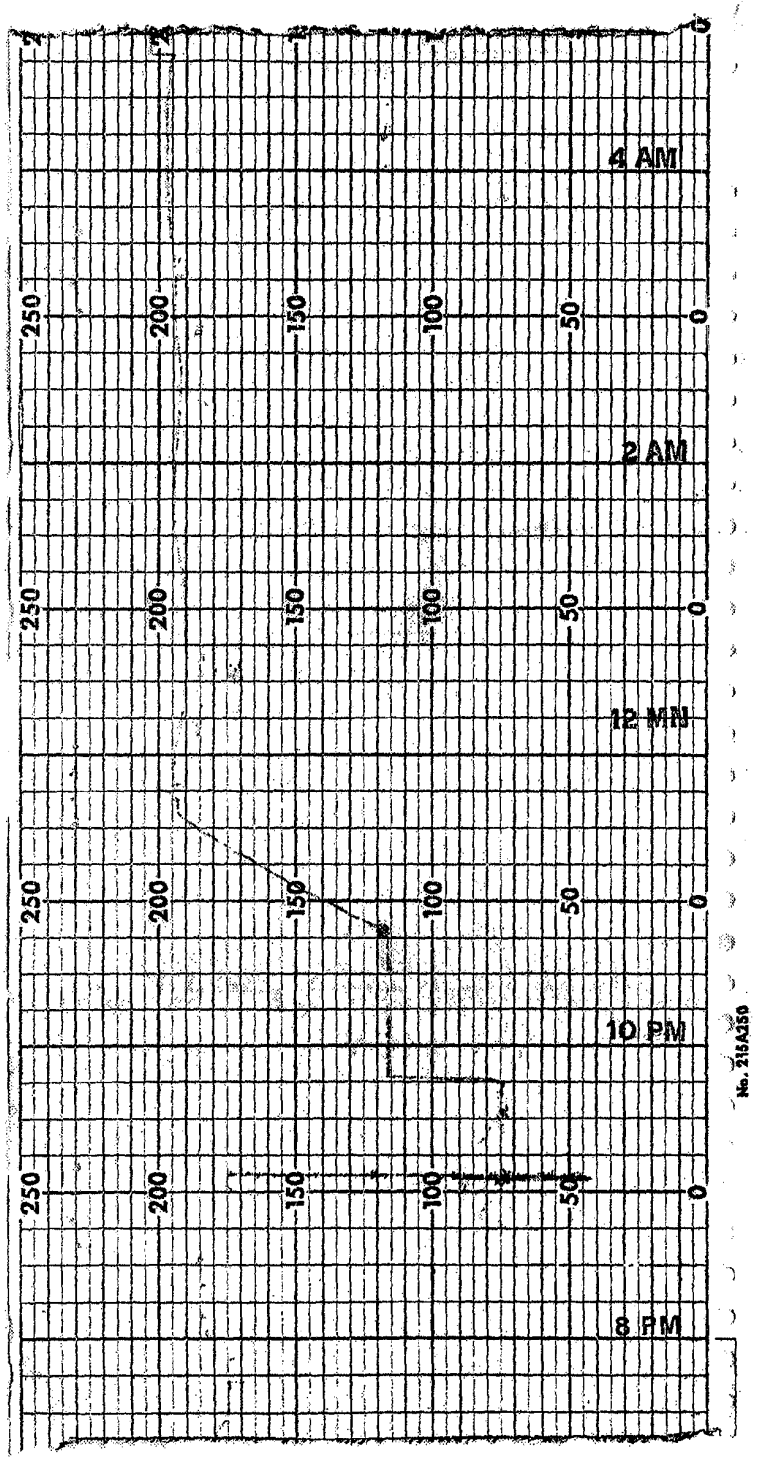

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