

CG 04 CODE K0-909-D PKG. _____

JAN 10 33725
EST. WGT. 862 1674 LBS.

STD. HRS. _____ TIME 70A M

01 YC-16-B 93 4 Lot 3487 33477 400 #

01 YC-16-B 93 4 Lot 32435 550 #

01 YC-16-B 93 4 Lot 33476 850 #

2662

TOTAL WGT 5274# (Req. 0533)

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			

EQUIPMENT	NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	1 Run 30" (489 G) water into V-211			240
8	2 Pour in	480 240	32-D	480
208	3 Dump in	36 32 x 50	YC-16-B	3600 1800
1	Record: Start: 8:55 A.M. 33477 400			
	Fin: 10:50 A.M. 32435 550			
	801 (13608) 33476 850			
75" (12756)	4 Adj to 63" (1065 G) 2800-3200			
	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 42" and adj to 54" (1981 G)			
	8 Inspect homog strainer & clean if necessary			
208	9 Run 10" (514 G) water into V-247 Install Temp chart			
SV	10 Pump V-208 thru Homog at 4800/5200 psi into SV			
2	Record: Time Start 2:30 Total Min 160			
	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			
8	13 Run 1000# water into V-384 and heat to 110-120°F	1387		1387
384	14 Weigh 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 1.057 (14.3 ± 0.2) 1.057-1.061 (1.057-1.061)			
	8/ml			
SV	18 When S 10 Homog complete, adjust SV to 60" (3084 G)			
4	19 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%	24	7-D	12
	Siphon N-7-D into SV & Record: pH 11.1			
	20 Heat to 190-194°F in 55-65 min and Record: HT 192°F and Rec 1220F			
	NOTE: Strike must be started immediately on completion of heating			
343	21 While heating SV, run 49" (1348 G) water into V-343			
8	22 Meter in from V-386 M 2 9.20 #/Gal 21.3 Gal		27-D	444
386	23 Stir 15 min or longer			207
5	24 Record: Be 1.010 (13.4 ± 0.1) (1.009-1.011)			
	g/ml			

V-247

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>9.9</u> (9.6-10.2)			
	26 Set V-343 acid pump at 69 setting (± 25 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 <u>9:05 P</u> <u>1:05 A</u> <u>240</u>			
	V-349 <u>7:05 P</u> <u>12:15 AM</u> <u>190</u>			
	Record: Time V-343 V-349 SV pH Normal pH			
	Inches Inches			
	at 20 min <u>9:25 P</u> (46) <u>46</u> (17) <u>17</u> <u>9.7</u> 9.3-10.0			
	40 min <u>9:45 P</u> (41) <u>41</u> (15) <u>15</u> <u>9.7</u> 9.3-10.0			
	1 hr <u>10:05 P</u> (37) <u>37</u> (13) <u>13</u> <u>9.7</u> 9.3-10.0			
	2 hrs <u>11:05 P</u> (23) <u>24+</u> (6) <u>7-</u> <u>9.8</u> 9.3-10.0			
	3 hrs <u>12:05 A</u> (10) <u>12</u> (0) <u>1</u> <u>9.8</u> 9.3-10.0			
	Finish <u>1:05</u> (0) <u>—</u> <u>8.9</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 <u>8.25</u> Assume 78%			
	30 Sift in 1 bag	50	27-D 128-A	9 50
357 7	31 Run 30" (216 G) water into V-357 and heat to 135-140°F			238 2
	32 Dump in and stir to dissolve for S 61	477 238	15-A	477 2
302 8	33 Add 38" (465 G) water to V-302	148		
	34 Add & stir 2 min for S 64 Assume 50%	296 2	7-D	74 148
PT 9	35 During strike pump into PT	482 241	169-A	441 482
	36 Pump In	54 27	155-A	27 54
	37 Pump In	54 27	160-A	27 54
	38 Stir 10 min with lightning mixer for S 42			
356 10	39 During strike, Run ^{15"} 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			
UP 2:15 AM	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 13850 REV.

DUP050095217

0533

DATE 11/18/60

FOR CODE 1601010 LOT 22/20

WRITTEN BY C. V. G. P.
Production Control

Production Control

[illegible]

***Each Supervisor must explain weight differences on reverse side.**

PRODUCTION CONTROL COPY
- WHITE
OPERATING FILE COPY
- YELLOW
WAREHOUSE FILE COPY
- GREEN
RAW MATERIAL FILE COPY
- BLUE
PRODUCTION CONTROL FILE COPY - PINK

[illegible]

PLACED IN LOCATION BY: OPER. # _____ DATE _____ SUPVR. _____



