MAKING INSTRUCTIONS: BATCH UI

246, 247 245 C.V. D.V.

CO 04 CODE KO-909-D PKG:

APR 29 35530

EST. WGT. 1674 LBS.

STD. HRS. TIME 3 PM

OK / HP

PROCESSES		APPROVED
( ) KO-909-D	(C)	LWK 1-27-7
( )	( )	DCG 1-30-7
( )	( )	MTW 2-27-7
( )	( )	
TYPED BY		
NSA 3-13-78		

01 YC-16-B 93 4 Lot 34711 , 50#
01 YC-16-B 93 4 Lot 33915 , 250#
01 YC-16-B 93 4 Lot 34782 , 900#

01 YC-16-B 93 34374 2400#
01 YC-16-B 98 72335 40#

5374

TOTAL WGT 5274# (Req.)

APR 30 1980

NON-BLEEDING

IPMENT		NAME: KROLORD ORANGE Y	USE LBS.	N CODE	ACC LBS
	60"	(9906)			
211 & 208 1	1	Run 30" (480 G) water into V-211 RUN AGITATOR ON HIGH SPEED			
	2	Pour in	480	32-D	480
	3	Dump in Lot	72 x 50	YC-16-B	3600
		Record: Start: 11:30 PM 34782 - 900	1 x 40	YC-16-B	40
		Fin: 1 PM 34374	2400		
		254 (2756) 34711	50		
	4	Adj to 63" (1065 G) 2800-3200 33915	250		
	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 49 " and adj to 54" (1981 G)			
	8	Inspect homog strainer & clean if necessary			
		DURING HOMOG, RUN V-211 AGITATOR ON LOW SPEED			
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			
		Record: Time Start 3:30P Total Min 180			
		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			
	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 1.106 (14.3 ± 0.2) (1.106-1.108)			
SV 4	18	When S 10 Homog complete, adjust SV to 60" (3084 G)			
	19	Record: pH 10.9 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%	8	7-D	4
		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 192 °F			
		NOTE: Strike must be started immediately on completion of heating			
343 & 386	21	While heating SV, run 49" (1348 G) water into V-343			
	22	Meter in from V-386 M 30 #/Gal 9.5 Gal 43.6		27-D	414
	23	Stir 15 min or longer			
	24	Record: Be 1.023 (3.4 ± 0.1) (1.021-1.023)			

N32368

V-245

Ref: Process Revisions per Pur Prod 030179 #'s 39, 41, 45 (Cont)

IPMENT		PAGE 2 CO 04 CODE KO-909-D (C) EST. WGT. 5274 LBS.	USE LBS.	N CODE	A L
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 / Minutes			
		V-343 7:50 / 11:45 PM / 235			
		V-349 7:50 / 10:55 PM / 185			
		Record: Time / V-343 in / V-349 in / SV pH / Normal pH			
		at 20 min 8:10 (46) (17) 10.0 9.3-10.0			
		40 min 8:30 (41) (15) 10.0 9.3-10.0			
		1 hr 8:50 (37) (13) 10.0 9.3-10.0			
		2 hrs 9:50 (24) (6) ? 9.9 9.3-10.0			
		3 hrs 10:50 (10) (0) + 9.9 9.3-10.0			
		Finish 11:45 (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, adj to 7.5-8.5 & Record: pH .			
	30	Sift in 1 bag Assume 78%	50	37-D 128-A	50
357 7	31	Run 30" (216 G) water into V-357 & heat to 135-140°F			
	32	Dump in & stir to dissolve for S 61	477	15-A	477
302 8	33	Add 38" (435 G) water to V-302			148
	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 15" (268 G) water into V-356			
	40	Turn on steam			
	41	Adj to 21" (366 G) at 82-83°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			
	45	Stir 30 min at 82-83°C 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			

REV.

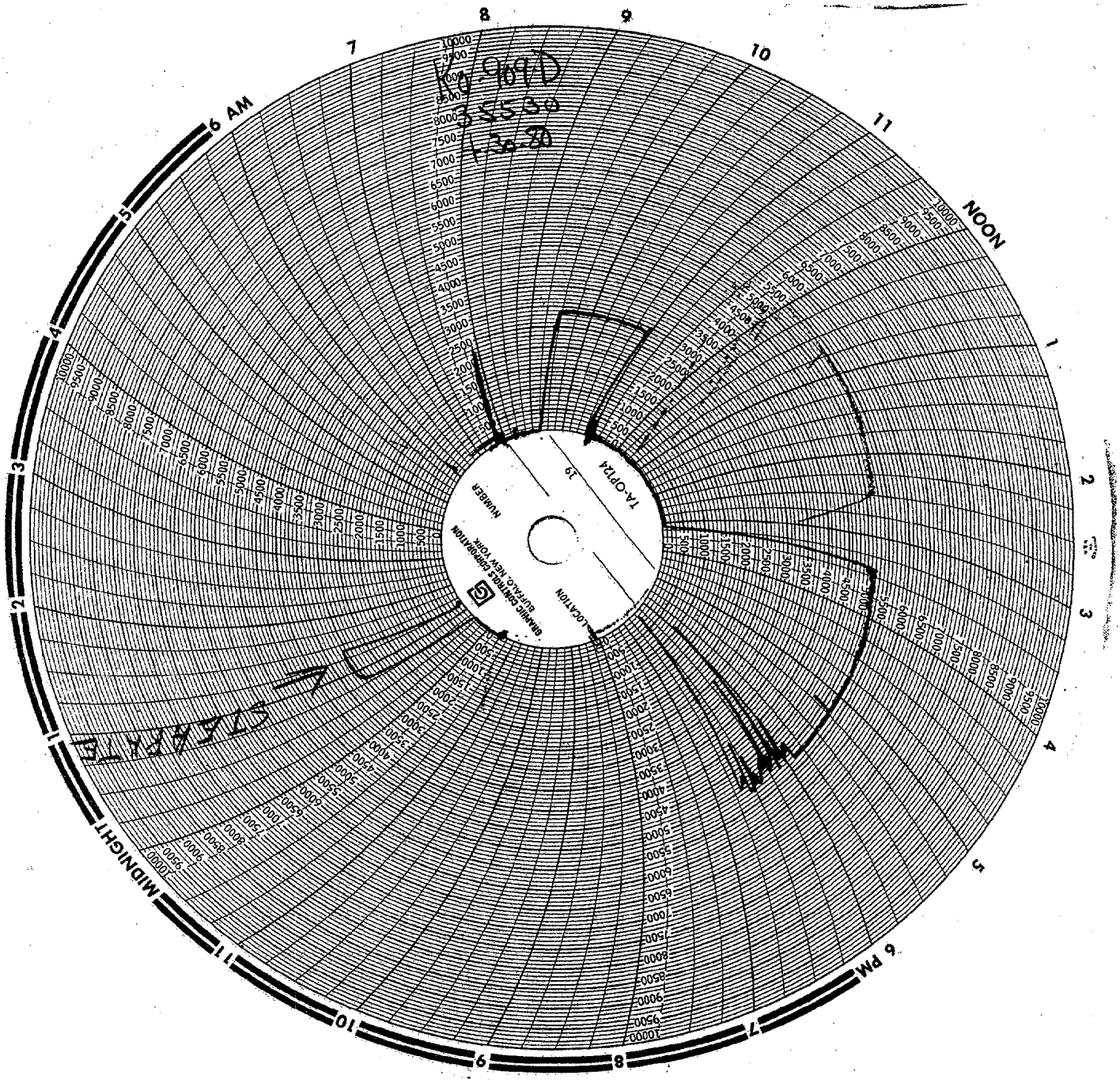
DUP050457728

V-245

...MENT		PAGE 3 CG 04 CODE KO-909-D (C) EST. WGT. 5274 LBS.	USE LBS.	N CODE	AC LB
	57	When Homog complete, rinse in V-356 with hot water from hot water mixer			
...t)	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 2.9 (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 5.8 (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%	16	7-D	8
		Siphon N-7-D into SV			
	66	Do Not Stop Agitator			

START	FIN	OPTR
3:00 P	11:00 P	320-126
11:00 P	2:15 AM	235

DUP050457729



N32368.01

DUP050457730

V-245



DUP050457731

N32368.02

DUP050457732