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

04 CODE KO-789-D PKG.

JAN 14 33601

509 ~~1132~~ LBS.

10.8 TIME 11 P

PROCESSES		APPROVED BY
( ) KO-789-D	(I)	EWK 09-21-76
( )	( )	DCG 09-21-76
( )	( )	MTW 10-02-76
( )	( )	FWP 02-05-79
TYPED BY emw020579		

OK / AP

01 YC-16-B 93 4 Lot ~~[illegible]~~ , 350 # — 32516

01 YC-16-B 93 4 Lot ~~31796~~ , 500 # — 33476

01 YC-16-B 93 4 Lot 32520 , 1250 # (P)

Total Weight ~~5332~~ 2609 # (Req 0543)

NON-BLEEDING

PT		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	1	Run 60" (990 G) water into V-211			265
&	2	Weigh in drum & pour in	265 ~~530~~	32-D	~~530~~
208	3	Dump in & stir 5 min Lot 42	~~84~~ x 50	YC-16-B	~~4200~~
1		Record: Start 9:30 Pm 32520	1250		2100
		Fin 10:30 Pm 33476	500		
		32516	350		
	4	Adj to 70" (1200 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. Use Hot Water			
	7	Record: V-208 Vol 56 " & adj to 54" (1890 G)			
	8	Inspect Homog strainer & clean if necessary			
208	9	Run 10" (514 G) water into V-245 & start agitator & install temperature chart			
&	10	Pump V-208 thru Homog at 4800-5200 psi into SV-			
SV		Record: Time Start 4:00 P , Total Min 180			
2		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 & pump thru Homog at 4800-5200 psi. Rinse in using Hot Water			
349	12	While Homog, run 6" (284 G) water into V-349			
&	13	Run ± 1000 # water into V-384 & heat to 110-120°F	1272		1272
384	14	Weigh into V-384 & pump to V-349	~~2930~~	32-D	~~2930~~
3	15	Run ± 1000 # water into V-384 & pump to V-349			
	16	Adj V-349 to ~~30" (1400 G)~~ & stir 15 min or longer 22" (1040 G)			
	17	Record: °Be 1.042 ~~(10.0 ± 0.2)~~ 1.040-1.044 g/mL			
SV	18	When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19	Record: pH 10.6 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	14	7-D	7
		Siphon N-7-D into SV & Record: pH 11.2			
	20	Heat to 190-194°F in 55-65 min & Recrod: HT 194 °F & Rec 187 °F			
		NOTE: Strike must be started immediately on completion of heating 52" (1430 G)			
343	21	While heating SV, run ~~70" (1920 G)~~ water into V-343			
&	22	Meter in from V-386 M 4 , 9.55 #/Gal 20.4 Gal		27-D	~~440~~
386	23	Stir 15 min or longer			195
5	24	Record: °Be 1.009 ~~(2.5 ± 0.1)~~ (1.008-1.009) g/mL			

EG

V-245

PMENT		PAGE 2 CG 04 CODE KO-789-D (I) EST. WGT. 5332 LBS.	USE LBS.	N CODE	ACC LBS
SV 6	25	When S 20 heating complete, Record: pH 10.1 (9.6-10.2)			
	26	Set V-343 acid pump at 8~~6~~ setting (± 255 minutes) 65			
	27	Set V-349 silicate pump at ~~72~~ setting (± 210 minutes) 53			
	28	Immediately meter in V-343 & V-349. Maintain SV at 190-194°F during strike			
	29	Record: Start / Fin / Min V-343 11:30/P 4:00AM 220 V-349 310A 220			

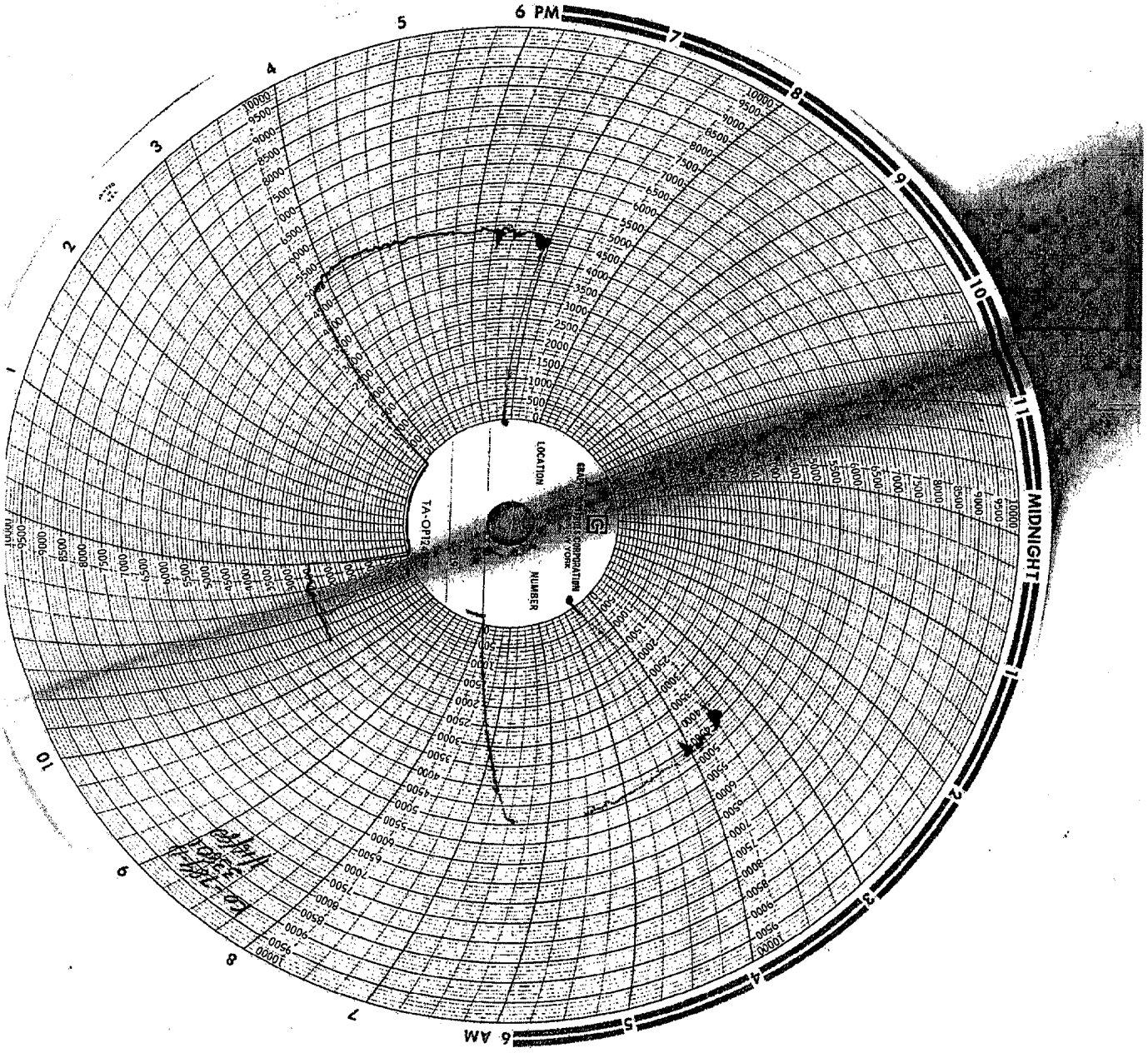
Record:	Time	V-343 in	V-349 in	SV pH	Normal pH
	11:30				
at 20 min	11:50	(~~66~~) 49	(~~27~~) 20	9.9	9.3-10.0
40 min	12:10	(~~60~~) 45+	(~~24~~) 18	9.9	9.3-10.0
1 hr	12:30	(~~55~~) 41 42	(~~21~~) 16	9.9	9.3-10.0
2¼ hrs	1:45	(~~34~~) 25 27+	(~~11~~) 8 9	9.9	9.3-10.0
3½ hrs	3:00	(~~13~~) 9 11+	(0) +	9.8	9.3-10.0
Finish	4:00	(0)		7.0	7.5- 8.5

NOTE: If pH drops below 9.3 in 1st hr, stop pumps & see Supervisor. If final pH is above 8.5, adj to 7.5-8.5 & Record: pH Assume 77% — 27-D

357 7	30	Run 33" (238 G) water into V-357 & heat to 135-140°F			265
	31	Dump in & stir to dissolve	265 ~~530~~	15-A	~~530~~
314 ~~302~~ 8	32	Add 42" (514 G) water to V-~~302~~ 314			82
	33	Add & stir 2 min Assume 50%	164 ~~330~~	7-D	~~165~~
SV 9	34	When V-349 MTY, rinse in with minimum water then set pump at zero setting			
	35	When V-343 MTY, rinse in with minimum water then turn off pump motor			
	36	Stir 30 min at 190-194°F then turn off steam Record: Start 4:00AM			
	37	Run in V-357 from S 31 & stir 5 min			
	38	Record: pH 3.3 (3.4-3.8) & if necessary, adj (DOWN ONLY) to 3.4-3.8 & Record: pH		15-A	
		NOTE: Dissolve extra N-15-A in water at 135-140°F in drum, use ±30 G water to 50# N-15-A. Stir SV 5 min after each addition			
	39	Run in N-7-D from S 33 in 10-12 min & stir 5 min			
	40	Record: pH 4.5 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.2 Assume 77%		27-D	
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
		Siphon N-7-D into SV			
	41	Pour in & stir 15 min	12 ~~25~~	978-A	12 ~~25~~
	42	Stop agitator			

START	FIN	OPTR
10 30 P	11 Pp	120-101
7 Am	3 pm	223-282
4 00 P	11 00 P	101-126
11 00 P	530 A	235-259

DUP050095270



DUP050095271

DUP050095272

0
50
100
150
200
250
4 AM
6 AM
8 AM
10 AM
12 N
GRAPHIC CONTROLS CORPORATION BUFFALO, NEW YORK