246 (247) (241) C.V. D.V.

04 CODE KO-789-D PKG.
JAN 11 33139

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		

7 Am OK HP

WT. WGT 89 ~~1132~~ LBS.

TO HRS. 10.8 TIME M 32436

01 YC-16-B 93 4 Lot ~~32518~~, 500#
01 YC-16-B 93 4 Lot ~~32435~~ 32435, 250#
01 YC-16-B 93 4 Lot 33477, 1350#

Total Weight ~~5332#~~ 2609 (Req 0535)

NON-BLEEDING

ENT		NAME: KROLOR® ORANGE Y	USE LBS.	N CODE	ACCT. LBS.
211	1	Run 60" (990 G) water into V-211			
&	2	Weigh in drum & pour in	265 ~~530~~	32-D	~~530~~ 265
208	3	Dump in & stir 5 min Lot 42	~~84~~ x 50	YC-16-B	~~4200~~ 2100
1		Record: Start 9:10-A.M.			
		Fin 9:35-A.M.			
	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-247 & start agitator & install temperature chart			
&	10	Pump V-208 thru Homog at 4800-5200 psi into SV-247			
SV		Record: Time Start 7:00 PM Total Min 150			
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			
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	1272		1272
	16	Adj V-349 to ~~30" (1400 G)~~ & stir 15 min or longer 22" (1041 G)			
	17	Record: °Be 1.045 ~~(10.0 ± 0.2)~~ (1.042-1.045) g/mL			
SV	18	When S 10 Homog complete, adj SV to 45" (2300 G)			
4	19	Record: pH 10.4 & adj to 11.1-11.3 using N-7-D diluted to 5% (10 parts water to 1 part N-7-D) Assume 50%	20	7-D	10
		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			
343	21	While heating SV, run ~~70" (1920 G)~~ 53" (1447 G) water into V-343			
&	22	Meter in from V-386 M 2, 9.70#/Gal 201 Gal		27-D	~~440~~ 195
386	23	Stir 15 min or longer			
5	24	Record: °Be 1.007 ~~(2.5 ± 0.1)~~ (1.007-1.009) g/mL			

V-247

PMENT		PAGE 2 CG 04 CODE KO-789-D (I) EST. WGT. 5332 LBS.	USE LBS.	N CODE	ACC LBS
SV	25	When S 20 heating complete, Record: pH 10.0 (9.6-10.2)			
6	26	Set V-343 acid pump at ~~X~~ setting (± 255 minutes) 65			
	27	Set V-349 silicate pump at ~~X~~ 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 11:10 / 3:40 A 270			
		V-349 11 / PM 2:45A 220			
		Record: Time / V-343 in / V-349 in / SV pH / Normal pH			
		11:10			
		at 20 min 11:30 (~~66~~)(49) (~~27~~)(20) 9.8 9.3-10.0			
		40 min 11:50 (~~60~~)(45) (~~24~~)(18) 9.8 9.3-10.0			
		1 hr 12:10 (~~56~~)(41) 42 (~~21~~)(16) 9.8 9.3-10.0			
		2¼ hrs 1:25 (~~34~~)(25) 27+ (~~11~~)(8) + 9.7 9.3-10.0			
		3½ hrs 2:35 (~~18~~)(9) 11+ (0) 1 9.7 9.3-10.0			
		Finish 3:40 (0) 8.5 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	30	Run 33" (238 G) water into V-357 & heat to 135-140°F			265
7	31	Dump in & stir to dissolve	265 ~~530~~	15-A	~~530~~
302	32	Add 42" (514 G) water to V-302			82
8	33	Add & stir 2 min Assume 50%	164 ~~330~~	7-D	~~165~~
SV	34	When V-349 MTY, rinse in with minimum water then set pump at zero setting			
9	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 3:45A			
	37	Run in V-357 from S 31 & stir 5 min			
	38	Record: pH 2.9 (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 3.2 (6.2-6.4) & if necessary, adj to pH 6.2-6.4 & Record: pH 6.4 Assume 77%	1	27-D	1
		(Dilute 10 parts water to 1 part N-7-D) Assume 50%		7-D	
		Siphon N-7-D into SV			
	41	Pour in & stir 15 min	12 ~~25~~	978-A	12 ~~25~~
	42	Stop agitator			

START	FIN	OPTR
7:Am	3:Pm OP	223-282
3:00 PM	11:00 PM	37-237
11:00P	530/Am	235-323

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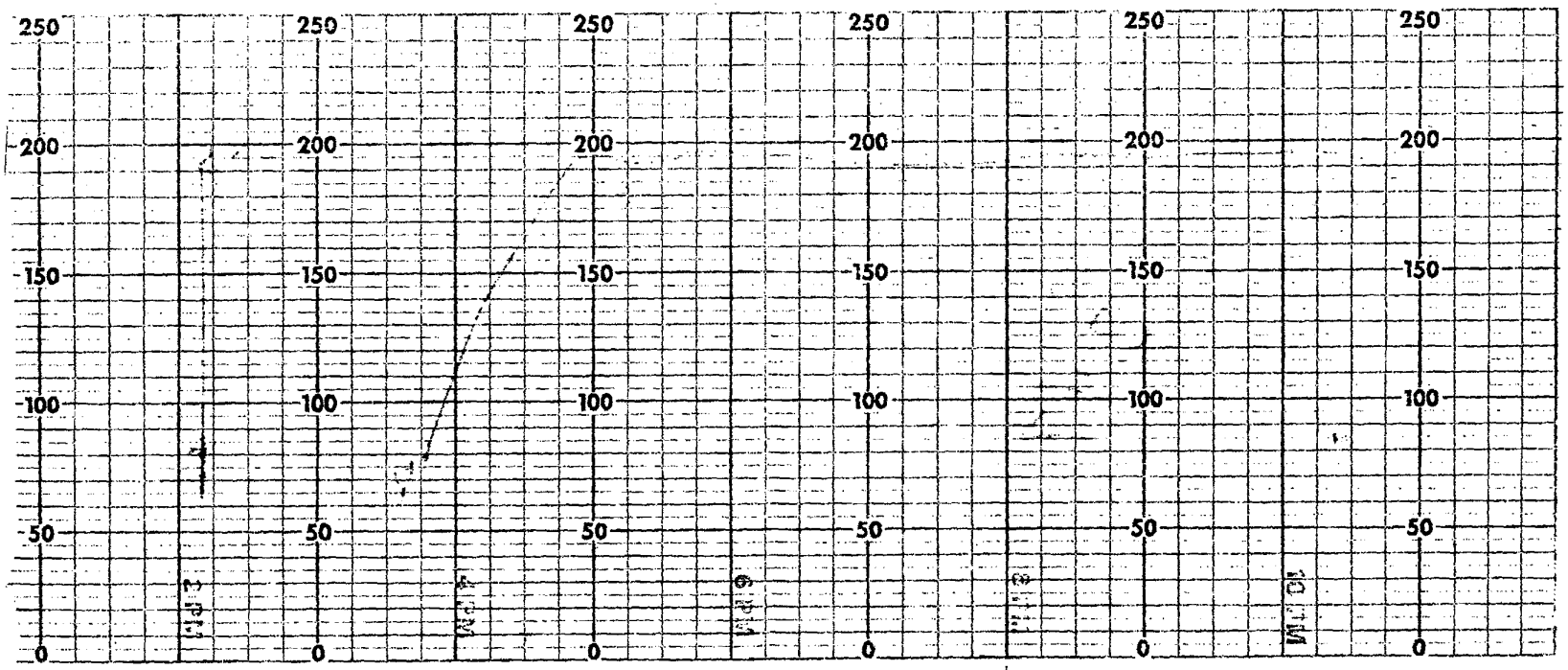

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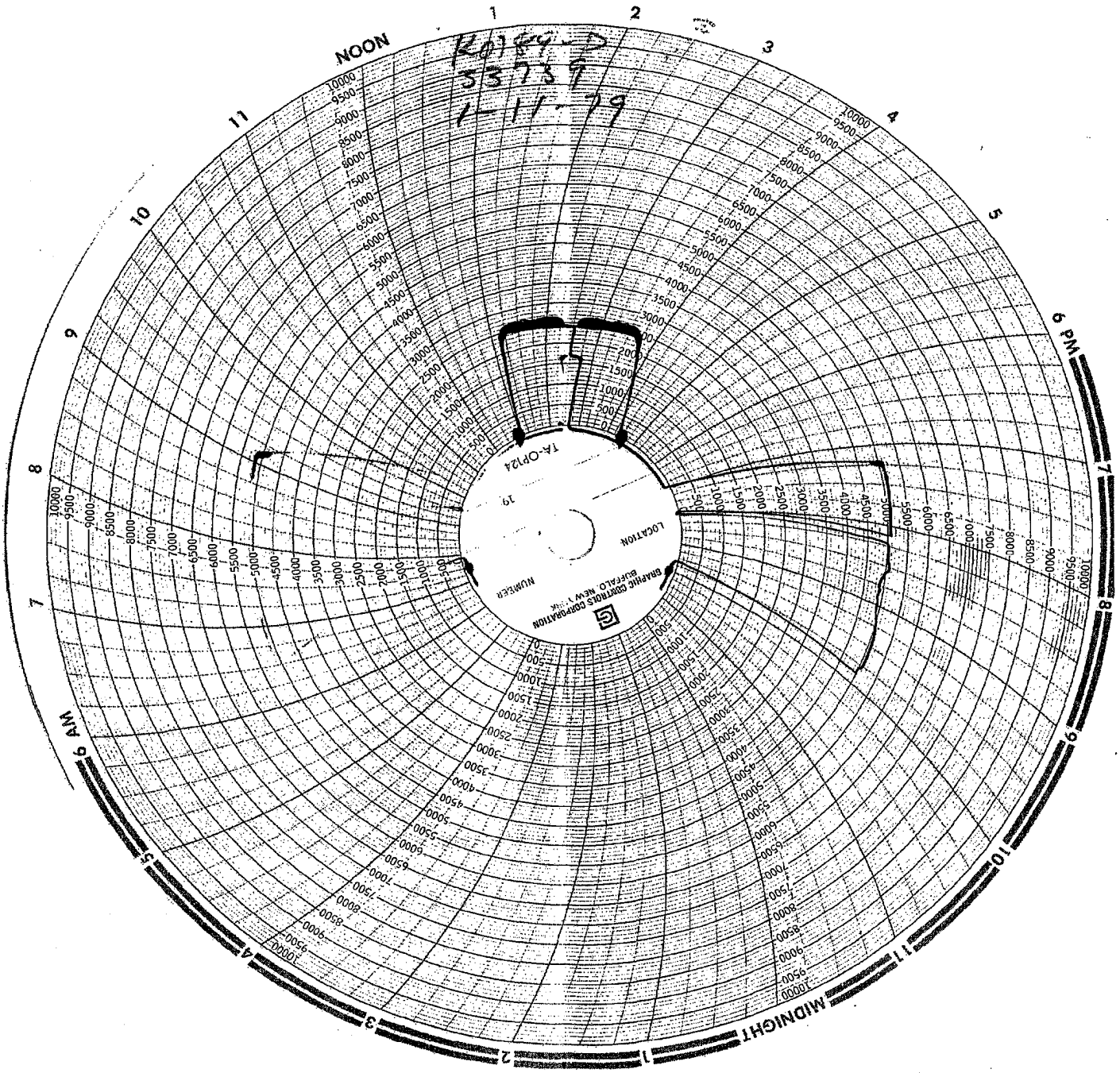

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