TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT. (DO NOT PUNCH) 5561 LBS
(REQ. # _____)
TAB PUNCH FOLLOWING CONSUMPTIONS:

TYPED BY

CG	CODE	LOT	PQ	DISP	LBS	TAB: %	DO NOT PUNCH PULP WGT.
46	YC-11-A						
46	YC-11-A						
46	YC-11-A						
46	YW-811-P						
46	YW-811-P						

TOTAL WGT. 7961

NON-BLEEDING

EQUIPMENT	NAME: DALAMAR® YELLOW	USE LBS	N CODE	ACC LBS
Misc. 1	NOTE: MAKING SUPV - 1 hour before taking S33 sample, advise CTL Supv of status			
	1 RUN IN ± 150# WATER INTO ALM & CHECK FOR LEAKS			
	RECORD: FINDINGS NONE			
	NOTE: (1) IF LEAKS FOUND, ADVISE SUPVR & DO NOT PROCEED WITH BATCH UNTIL CORRECTED			
	(2) IF NO LEAKS FOUND, DRAIN ALM & PROCEED WITH BATCH			
	2 Obtain as listed above		YC-11-A	12390
	3 Obtain & Mix to uniformity for S9 & S13		896-B	
	4 Calculate for S27			
	6881-6678# YC-11-A Pulp Wgt (S2) = 203# water 56			
	6825			
ALM 2"	5 CLOSE ALM # 2 outlet & run in 100# WATER			
	6 DO NOT START AGITATOR			
	7 POUR IN ASSUME 50%	8	7-D	4
	8 DUMP IN 2 DRUMS OF YC-11-A FROM S2			
	9 POUR IN	200	896-B	200
	10 START AGITATOR & STIR ONE MINUTE ONLY			
	RECORD: TEMP 86 °F			
	NOTE: (1) IF COLOR BRIDGING OCCURS, STOP AGITATOR ALLOW TO STOP & DISLODGE COLOR			
	(2) OVER STIRRING WILL GENERATE EXCESSIVE HEAT & FOAM			
	11 ADD REST OF YC-11 (S2) IN 2 DRUM INCREMENTS USING FOLLOWING PROCEDURE (SCRAPE DRUMS):			
	(1) AGITATOR OFF, DUMP IN 2 DRUMS YC-11			
	(2) START AGITATOR & STIR ONE MINUTE ONLY FOR EACH 2 DRUM INCREMENT			
	12 RECORD: TEMP 78 °F			
	13 START AGITATOR & POUR IN & STIR 5 MIN	420	896-B	420
	14 RINSE GRATING, SIDES & MIXER BASKET WITH 100# WATER			

N35208

MAKING INSTRUCTIONS: BATCH UNIT

V. ALM #2 C.V. 214,225,320 D.V.

CG 46 CODE YW-811-P PKG. 06 TIME 74 M

PROCESSES	APPROVED BY
( ) YW-811-P 6)	BBK 8-17-77
( ) ( )	DCG 8-29-76
( ) ( )	
( ) ( )	
TYPED BY	
NSA 8-29-77	

→ LOT SEP·10·80 37073-1 5742

TAB: PUNCH TOTAL WGT AS EST WGT 5378 *

EST WGT. (DO NOT PUNCH) 9561 LBS

(REQ. #)

TAB PUNCH FOLLOWING CONSUMPTIONS:

CG	CODE	LOT	PQ	DISP	LBS.	TAB: %	DO NOT PUNCH PULP WGT
46	YC-11-A	35546-1	99		617#		
46	YC-11-A	35928-1	98		560#		
46	YC-11-A	36967-1	93		1223#		
46	YW-811-P	29262-1	98		62#		
46	YW-811-P	31072-1	98		97#		
46	YW811-P	35936-1	99		33#		
46	YW811-P	35531-1	98		450#		
46	YW811-P	34870-1	98		450#		
46	YW811-P	36708-1	98		250#		
		TOTAL WGT.			9474	TOTAL WGT 9474#	

Add 42% WATER 364 LBS.

9340 x100 = 9474 98.5% YIELD

SEP 12 1980

NON-BLEEDING

EQUIPMENT		NAME: DALAMAR® YELLOW	USE LBS.	N CODE	AC LB
		NOTE: MAKING SUPV - 1 hour before taking S 29 sample, advise CTL Supv of status			
Misc 1	1	Obtain as listed above		YC-11-A	2400
	2	Obtain & homog mix to uniformity for S 7, 11		896-B	
	3	Calculate for Step 23 6921#- # YC-11-A pulp wgt (S 1) = # water			
ALM 2	4	Plug ALM # 2 outlet & run in 250 # water			
	5	Do not start agitator			
	6	Dump or shovel in 1 drum YC-11-A from S 1			
	7	Pour in	200	896-B	200
	8	Stir to fluidize. Use minimum agitation			
	9	Add balance of YC-11 (Step 1) in 2 drum increments fluidizing each 2 drums with minimum agitation. Scrape drums			
	10	Start agitator and pour in	8	7-D	4
	11	Pour in	420	896-B	420
	12	Stir 5 min			
	13	Rinse grating, sides & mixer basket with 150 # water			
	14	Stir 60 min Record: Time Start			
	15	Pour in & stir 5 min	2 oz.	816-A	
	16	Stop agitator			
	17	Record: pH (10.0-12.0)			
	18	Pour in & stir 5 min	40	195-B	40
	19	Stop agitator			
	20	When scheduled dump in Lot Note: If ALM is full, add as vol will permit during homog		YW-811	
CV 3	21	Run ALM thru homog at 4800-5200 psi into V- Note: Collect material homog below 4800 psi & return to ALM			

Emulsion Rev.

DUP050108144

EQUIPMENT		PAGE 2 CG 46 CODE YW-811-P (B) EST. WGT. _____ LBS.	USE LBS.	N CODE	ACCT LBS.
	22	While homogenizing at 5-10 min intervals, jog agitator on ALM to maintain color suspension			
	23	Rinse ALM with ___ # water calculated in S 3 thru homogenizer at 2000-5000 PSI			
	24	Drain lines from homog to CV into drum & pour into CV			
	25	Add & stir 30 min	4 ozs	816-A	1
	26	Record: pH ____ (10.0-12.0)			
	27	If necessary, adjust to pH 10.0-12.0 Assume 50%		7-D	
		Record: pH _____ Assume 75%		30-D	
	28	Discharge ±25 G thru packout line & pour into CV			
	29	Fill 1-16 ounce jar from packout line & deliver to CTL for color. Record in S 42			
	30	Fill 1-16 ounce jar from packout line & run 100 mesh screen test per SOP. Record: results S 42			
	31	If screen test is OK, close manhole cover, turn off light, & leave agitator on. Note: If screen test is not OK, notify supervisor			
Homog 6	32	Clean Homog per SOP	25	3-A	25
CV 7	33	Add ___ # water as required to CV			
		Note: If test is satisfactory, omit S's 33-36			
	34	Start agitator & stir 20 min or longer to uniformity			
	35	Fill 1-16 ounce jar from packout line & deliver to CTL for color. Record in S 42			
	36	Shut off agitator until test is available			
	37	When test is satisfactory, start agitator			
	38	Stir 5 min or longer			
	39	Check packout scale accuracy: 50# 500#			
	40	Discharge thru packout screen as follows:			
		PACKAGE N-CODE SCHEDULED PACK TOTAL NET PACK			
		GRAND TOTAL NET PACK			
		Note: After discharging ±25 G, fill 2-16 ounce jars from packout line, mark "FINAL." Deliver to CTL when packout is completed. Record in S 42			
	41	Stop agitator			
	42	Record: Results Time Supv			
		S30 Screen tested			
		S29 Color sample to CTL			
		S35 Resample to CTL			
		S40 Samples during packout			
		S40 Delivered to CTL			
		START FINISH OPERATOR			

EQUIPMENT		PAGE 2 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
ALM 2 CONT	15	STIR 60 MIN. RECORD: START 6:50 PM NOTE: (1) DO NOT EXCEED 95°F DURING STIR (2) IF NECESSARY, CUT STIR WHEN TEMP REACHES 95°F & PROCEED TO S17			
	16	RECORD S15 STIR TEMP EVERY 10 MINUTES TIME / INTERVAL, MIN / °F START 0 78 10 82 20 86 30 90 40 93 50 95 60			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 98 °F			
	19	Record: pH 11.6 (10.0-12.0)			
	20	If necessary, adj to pH 10.0-12.0 & Record: pH ____ ASSUME 50%		7-D	
	21	Pour in and stir 5 min	88	195-B	88
	22	Stop agitator			
	23	When scheduled dump in Lot 36708-1	450	YW-811-	1342
		NOTE: If ALM is full, add as vol permits during homog 34870-1	450		
		35531-1	450		
		35936-1	35		
CV 3	24	Run ALM thru homog at 4800-5200 psi into V- 214 NOTE: (1) Collect material homog below 4800 psi and return to ALM			
		(2) DO NOT ALLOW HOMOG TEMP TO EXCEED 120°F (3) IF HOMOG PRESSURE AT UPPER LIMIT (5200 PSI) & TEMP BORDERLINE, LOWER HOMOG PRESSURE ± 100 PSI. TEMP SHOULD DROP 3 to 4°F PER 100 PSI CUT IN PRESSURE. DO NOT GO LOWER THAN 4800 PSI (LOWER LIMIT) (4) IF TEMP BECOMES EXCESSIVE, STOP HOMOG & ADVISE SUPVR. THIS CONDITION INDICATES FOREIGN MATERIAL HUNG UP BETWEEN BALLS & SEATS CAUSING SLURRY TO RECIRCULATE WITHIN HOMOGR.			
	25	DURING S24 HOMOG, RECORD HOMOG. DISCHARGE TEMP EVERY 10 MIN			

TIME	INTERVAL, MIN	°F	TIME	INTERVAL, MIN	°F
START	0	98		70	108
12:00 NOON	10	105		80	108
	20	108		90	106
	30	110		100	106
	40	110		110	106
	50	108		120	105
	60	108			

26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
27	Rinse ALM with ~~2 gal~~ 6 G water calculated in S14 thru homogenizer at 2000-5000 PSI			
28	Drain lines from homog to CV into drum & pour into CV			
29	Add & stir 30 min	4 ozs.	816-A	1
30	Record: pH 11.3 (10.0-12.0)			
31	If necessary, adjust to pH 10.0-12.0 Assume 50%		7-D	
	& Record: pH Assume 75%		30-D	
32	Discharge ± 25 G thru packout line & pour into CV			
33	Fill 1-16 ounce jar from packout line & deliver to CTL for color. Record in S46			

DUP050108146

EQUIPMENT		PAGE 2 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
ALM 2 CON'T	15	STIR 60 MIN. RECORD: START 6:50 AM			
		NOTE (1) DO NOT EXCEED 95°F DURING STIR			
		(2) IF NECESSARY, CUT STIR WHEN TEMP REACHES 95°F & PROCEED TO S17			
	16	RECORD S15 STIR TEMP EVERY 10 MINUTES			
		TIME INTERVAL, MIN °F			
		START 0 78			
		10 82			
		20 86			
		30 90			
		40 93			
		50 95			
		60			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 98 °F			
	19	Record: pH 11.6 (10.0-12.0)			
	20	If necessary, adj to pH 10.0-12.0 & Record: pH ____ ASSUME 50%		7-D	
	21	Pour in and stir 5 min	88	195-B	88
	22	Stop agitator			
	23	When scheduled dump in Lot 36708-1	450	YW-811-	1342
		NOTE: If ALM is full, add as vol 34870-1	450		
		permits during homog 35531-1	450		
		35936-1	35		
CY 3	24	Run ALM thru homog at 4800-5200 psi into V- 214			
		NOTE: (1) Collect material homog below 4800 psi and return to ALM			
		(2) DO NOT ALLOW HOMOG TEMP TO EXCEED 120°F			
		(3) IF HOMOG PRESSURE AT UPPER LIMIT (5200 PSI) & TEMP BORDERLINE, LOWER HOMOG PRESSURE ± 100 PSI. TEMP SHOULD DROP 3 to 4°F PER 100 PSI CUT IN PRESSURE. DO NOT GO LOWER THAN 4800 PSI (LOWER LIMIT)			
		(4) IF TEMP BECOMES EXCESSIVE, STOP HOMOG & ADVISE SUPVIR. THIS CONDITION INDICATES FOREIGN MATERIAL HUNG UP BETWEEN BALLS & SEATS CAUSING SLURRY TO RECIRCULATE WITHIN HOMOGIR.			
	25	DURING S24 HOMOG, RECORD HOMOG. DISCHARGE TEMP EVERY 10 MIN			

TIME	INTERVAL, MIN	°F	TIME	INTERVAL, MIN	°F
START	0	98		70	108
12:00 NOON	10	105		80	108
	20	108		90	106
	30	110		100	106
	40	110		110	106
	50	108		120	105
	60	108			

	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
	27	Rinse ALM with ~~2 ozs~~ 5 G water calculated in S4 thru homogenizer at 2000-5000 PSI			
	28	Drain lines from homog to CV into drum & pour into CV			
	29	Add & stir 30 min	4 ozs.	816-A	1
	30	Record: pH 11.3 (10.0-12.0)			
	31	If necessary, adjust to pH 10.0-12.0 Assume 50%		7-D	
		& Record: pH ____ Assume 75%		30-D	
	32	Discharge ± 25 G thru packout line & pour into CV			
	33	Fill 1-16 ounce jar from packout line & deliver to CTL for color. Record in S46			

UIPMENT		PAGE 3 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 3 CONIT	34	Fill 1-16 ounce jar from packout line & run 100 mesh screen test per SOP. Record: results S 46			
	35	If screen test is OK, close manhole cover, turn off light, & leave agitator on. NOTE: If screen test is not OK, notify supervisor.			
HOMOG 4	36	Clean Homog per SOP	25	3-A	25
CV 5	37	Add 364 # water as required to CV NOTE: If test is satisfactory, omit S's 37-40			
	38	Start agitator & stir 20 min or longer to uniformity			
	39	Fill 1-16 ounce jar from packout line & deliver to CTL for color. Record in S 46			
	40	Shut off agitator until test is available			
	41	When test is satisfactory, start agitator			
	42	Stir 5 min or longer			
	43	Check packout scale accuracy: 50# _____ 500# ✓			
	44	Discharge thru packout screen as follows:			

PACKAGE N-CODE	SCHEDULED PACK	TOTAL NET PACK
N-1775	± 20	4000
	1 Stump	340
	GRAND TOTAL NET PACK	9340

✓ NOTE: After discharging ± 25G, fill 2-16 ounce jars from packout line, mark "FINAL." Deliver to CTL when packout is completed. Record in S46

45 Stop agitator

46 Record:

	Results	Time	Supv
✓ S34 Screen tested	OK	11:30 PM	WW
✓ S33 Color sample to CTL	✓		
✓ S39 Resample to CTL	✓		
✓ S44 Samples during packout	OK	2:00 A.M	WW
✓ S44 Delivered to CTL	Yes	3:30 A.M	WW

START	FINISH	OPERATOR
10:30 Pm.	8:45 AM.	101
11 Pm	7 AM	114-211

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