.V ALM #2 C.V. 214,215 (320) ONLY D.V.

CG 46 CODE YW-811-P PKG. 55 TIME N

→ LOT JAN 21 81 38698-2

TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT. (DO NOT PUNCH) 8561 LBS
(REQ. #)
TAB PUNCH FOLLOWING CONSUMPTIONS:

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

CG	CODE	LOT	PQ	DISP	LBS.	TAB: %	DO NOT PUNCH PULP WGT
46	YC-11-A	37985	93		1195		
46	YC-11-A	38040	93		656		
46	YC-11-A	37999	93		549		
46	YW-811-P						
46	YW-811-P						
			TOTAL WGT.		8561		

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		YW-811	
		Note: If ALM is full, add as vol will permit during homog			
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.

EQUIPMENT		PAGE 2 CG 46 CODE YW-811-P (B) EST. WGT. _____ LBS.	USE LBS.	N CODE	ACC 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			

JIPMENT		PAGE 2 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
4LM 2 CON'T	15	STIR 60 MIN. RECORD: START 1:30 PM.			
		NOTE: (1) DO NOT EXCEED 95°F DURING STIR			
		(2) IF NECESSARY, CUT STIR WHEN TEMP REACHES 95°F			
	16	RECORD S15 STIR TEMP EVERY 10 MINUTES			
		TIME / INTERVAL, MIN / °F: START 0 76; 1:40 PM 10 78; 1:50 20 82; 2 PM 30 84; 2:10 40 86; 2:20 50 89; 2:30 60 92			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 94 °F			
	19	Record: pH 11.9 (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	80	195-B	80
	22	Stop agitator			
	23	When scheduled dump in Lot		YW-811-	
		NOTE: If ALM is full, add as vol permits during homog			
CV 13	24	Run ALM thru homog at 4800-5200 psi into V- 320			
		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		3:10 PM	70	105
3:10 PM	10	104	3:20	80	105
3:20	20	105	3:30	90	105
3:30	30	105	3:40 PM	100	105
3:40	40	105		110	
3:50	50	105		120	
4 PM	60	105			

2	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
	27	Rinse ALM with 989 # water calculated in S 4 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 10.7 (10.0-12.0)			
	31	If necessary, adjust to pH 10.0-12.0 Assume 50% & Record: pH Assume 75%		7-D 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 S 46			

DUP050292021

UIPMENT		PAGE 3 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 3 CONT	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 ____ # 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-1826 5 Gal — 38~~			
		N-1701 ± 104			
		GRAND TOTAL NET PACK			
		NOTE: After discharging ± 25G, fill 2-16 ounce jars from packout line, mark "FINAL." Deliver to CTL when packout is completed. Record in S 46			
	45	Stop agitator			
	46	Record: Results Time Supv			
		S 34 Screen tested			
		S 33 Color sample to CTL			
		S 39 Resample to CTL			
		S 44 Samples during packout			
		S 44 Delivered to CTL			
		START 12:45 PM FINISH 3:PM. OPERATOR BB			

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CG 46 CODE YW-811-P PKG ____ TIME ____ M

PROCESSES	APPROVED BY
( ) YW-811-P	
( )	
( )	
( )	
TYPED BY	

LOT # →

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

TAB PUNCH FOLLOWING CONSUMPTIONS:

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	ACT LBS
Misc. 1		NOTE: MAKING SUPV - 1 hour before taking S33 sample, advise CTL Supv of status			
		RUN IN ± 150# WATER INTO ALM & CHECK FOR LEAKS			
		RECORD: FINDINGS 0			
		NOTE: (1) IF LEAKS FOUND, ADVISE SUPVIR & DO NOT PROCEED WITH BATCH UNTIL CORRECTED			
		(2) IF NO LEAKS FOUND, DRAIN ALM & PROCEED WITH BATCH			
	2	Obtain as listed above	5088	YC-11-A	2400
	3	Obtain & Mix to uniformity for S9 & S13		896-B	
	4	Calculate for S27			
		~~6561#~~ 5088 # YC-11-A Pulp Wgt (S2) = 1493 # water			
		6581			
ALM 2	5	Close ALM # 2 outlet & run in 250# 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	20
	10	START AGITATOR & STIR ONE MINUTE ONLY PUNCHED & CHECKED			
		RECORD: TEMP 65 °F			
		NOTE: (1) IF COLOR BRIDGING OCCURS, STOP AGITATOR ALLOW TO STOP & DISLODGE COLOR AS REQ'D			
		(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 66 °F			
→	13	START AGITATOR & POUR IN & STIR 5 MIN	420	896-B	42
	14	RINSE GRATING, SIDES & MIXER BASKET WITH 150# WATER			

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