

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% Record: pH _____ Assume 75%		7-D 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 CO 46 CODE YW-811-P	EST. WGT. 7961	LBS.	USE LBS.	N CODE	ACCT. LBS.	
ALM 2 CONT	15	STIR 60 MIN. RECORD: START 2:30 PM						
	NOTE: 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	78				
		2:40 PM	10	80				
		2:50	20	84				
		3:00	30	86				
		3:10	40	88				
		3:20	50	92				
		3:30	60	95				
	17	Pour in and stir 5 min				2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 95 °F						
	19	Record: pH 11.7 (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						
CY 3	24	Run ALM thru homog at 4800-5200 psi into V-215						
	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 SUPERV. THIS CONDITION INDICATES FOREIGN MATERIAL HUNG UP BETWEEN BALLS & SEATS CAUSING SENTRY TO RECIRCULATE WITHIN HOMOGIF.						
	25	DURING S24 HOMOG, RECORD HOMOG DISCHARGE TEMP EVERY 10 MIN						
		TIME	INTERVAL, MIN	°F	TIME	INTERVAL, MIN	°F	
		START	0		5:20 PM	70	114	
		4:10 PM	10	96	5:30	80	114	
		4:20	20	114	5:40	90	114	
		4:30	30	114	5:50	100		
		4:40	40	116	6:00	110		
		4:50	50	114	6:10	120		
		5:00	60	114				
	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension						
	27	Rinse ALM with 400 # 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 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 S 46						

DIPLANT	PAGE 3 CG 46 CODE YW-811-P	EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 3	34	Fill 1-16 ounce jar from packout line & run 100 mesh screen test per SOP. Record: results S 46			
CONIT	35	If screen test is OK, close manhole cover, turn off light, & leave agitator on. NOTE: If screen test is not OK, notify supervisor. OK. EC.			
HOMOG 4	36	Clean Homog per SOP	25	3-A	25
CV 5	37	Add 116 # 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			
		1775 10 4500			
		1914 1610			
		1700 1760			
		GRAND TOTAL NET PACK 2820#			
		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			
		S39 Screen tested			
		S33 Color sample to CTL			
		S39 Resample to CTL am 4% water 1.0m 24.1			
		S44 Samples during packout			
		S44 Delivered to CTL			
		START FINISH OPERATOR			
		2:Am 3:Am 105			
		3:Am 11Am 88			
		3:00PM 11:00PM 409			
		11 Am 1:30Am 114			

CG CODE RT-841-D PKG. _____

EST. WGT. _____ LBS.

PROCESSING INSTRUCTIONS: BATCH UNIT

PROCESSES

APPROVED BY

TYPED BY

MAKING NOTES

REMARKS

NAME:

NON-BLEEDING

INSTRUCTIONS

- PRESSING -

RECORD

VAT						PRESSLOAD	1ST	2ND	3RD	4TH	5TH
DATE						STARTED					
TIME						CAKES USED					
RELEASED BY						WATER ON					
PRESS						HRS. WASHED					
NO. OF CAKES						OHMS					
PRESS						HRS. WASHED					
WASH TO						OHMS					
TEST AFTER						HRS. WASHED					
LOAD						OHMS					
						CAKE CONDITION					
						NO. CARS LOADED					
						EXPLAIN LOSSES					

SAMPLES

DELIVER TO

SAMPLED BY

RELEASED BY

- DRYING -

HOURS	L.V.	H.V.	LUMP: - OK - WET - SALTS - CONTAMINATED
TEMP.	° F	° F	

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES

DELIVER TO

NO. CARS PULLED

SAMPLED BY

LUMP WGT.

RELEASED BY

- GRINDING -

MILL	SCREEN	RPM	SCREEN	RPM
MAX. TEMP.	° F		MAX. TEMP.	° F

EXPLAIN LOSSES

SAMPLE AFTER / WITHOUT MIXING

DATE MIXED

SAMPLES

DELIVER TO

CTL

SAMPLED BY

RELEASED BY

WAREHOUSE REQUEST FORM

REQUEST NO. 3606
11/10/80

DELIVER TO MAKING AREA BY 11/11/80 7 AM/PM

FOR: CG 46 CODE YW811P LOT 378121 SCHEDULED 11/07/80

WHSE LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT	ACTUAL WEIGHT
35WALL	46	YC011A	93	37217	575	44.27	✓ 4	325	1299	<u>1300</u>
35WALL	46	YC011A	98	37217	80	44.27	✓ 1	180	181	<u>180</u>
P-4	46	YC011A	98	37234	66	51.41	✓ 1	128	128	<u>128</u>
35WALL	46	YC011A	98	37257	75	44.36	✓ 1	170	169	<u>170</u>
35TEMP	46	YC011A	98	37301	132	47.50	✓ 1	278	278	<u>278</u>
P-4	46	YC011A	93	37234	334 272	51.41	✓ 2	325	529	<u>650</u>
P-7	46	YC011A	93	37606	1233 1200	54.18	✓ 7	325	2215	<u>2275</u>

4981

PICK UP AND RETURN TO STORAGE:

LOCATN	CG	CODE	PQ	LOT	DRY WEIGHT	DRY CONT	NO. PKG	PKG WGT	TOTAL WEIGHT
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EXPLANATION FOR SHORTAGE/OVERAGE:

SIGNED _____ DATE ____/____/____

COPY-1 PROD. CONTROL
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL



