MAKING INSTRUCTIONS: BATCH UNIT

V AL 2 JAN 27 1981 C.V. 214 (215) 320 D.V.

CG 46 CODE YW-822-P PKG 05 TIME 74 M

LOT # → 1/29 34101-1

TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT. (DO NOT PUNCH)
(REQ. # 593)
TAB PUNCH FOLLOWING CONSUMPTIONS:

PROCESSES	APPROVED BY
( ) YW-822-P (B)	BBK 4-28-78
( )	DCG 5-5-78
( )	
( )	
TYPED BY	
NSA 5-8-78	

CG	CODE	LOT	PQ	DISP	LBS	TAB: DO NOT PUNCH %	PULP WGT.	
46	YC-13-A	31385	93		799			
46	YC-13-A	31385	98		86			Hose Out #2 Arm
46	YC-13-A	33835	93		1631			
46	YW-822-P	31591-1	93		14			Hose Out V-215
~~46~~	~~YW-822-P~~	~~65-418~~	~~93~~		~~450~~		do not punch	
46	YW-822	30770			900			

Add 2 Drs YW-822 900 lbs. TOTAL WGT. ~~7879~~ 7427 8327

8430 / 8327 X 100 101%

Delayed 3 hrs waiting on material

NON-BLEEDING

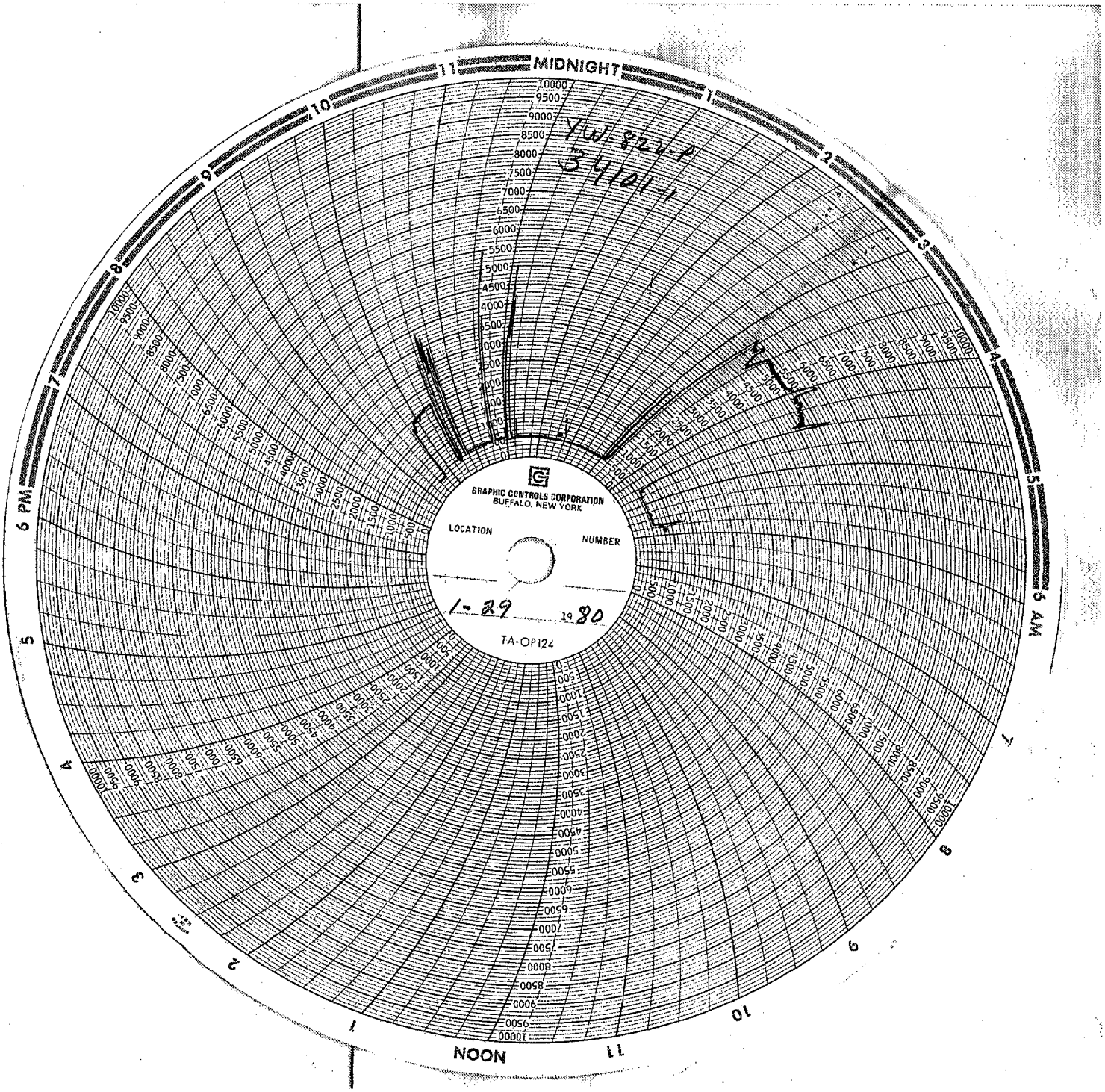
SHIPMENT		NAME: DALAMAR® YELLOW R	USE LBS	N CODE	ACCT LBS
Misc. 1		NOTE: MAKING SUPV - 1 hour before taking S 29 sample, advise CTL Supv of status			2516
	1	Obtain as listed above	5760	YC-13-A	~~2516~~
	2	Calc for S 23			
	3	~~6000~~ # -5760 # YC-13 pulp wgt (S 5) = 240 # water			
		6000 #			
ALM 2	3	Plug ALM # V outlet & run in 350# water			
	4	Do not start agitator			
	5	Pour in Assume 50%	8	7-D	4
	6	Dump in one drum of YC-13-A from S 1			
	7	Pour in	180	979-A	180
	8	Start agitator & stir minimum time to fluidize. Note: Over-stirring will cause excessive foam			
	9	Dump in rest of YC-13 (S 1) in 2 drum increments. Stir minimum time to fluidize between each increment. Scrape drums			
	10	Start agitator			
	11	Pour in	670	979-A	670
	12	Rinse grating, sides & mixer basket with 150# water			
	13	Stir 60 min Record: Start			
	14	Pour in and stir 5 min	2 oz.	816-A	0
	15	Stop agitator			
	16	Record: pH 11.8 (10.0-12.0)			
	17	If necessary, adj to pH 10.0-12.0 & Record: pH		3-A	
	18	Pour in and stir 5 min	84	195-B	84
	19	Stop agitator			
	20	When scheduled dump in Lot		YW-822-	~~14~~
		NOTE: If ALM is full, add as vol 31591-1 - permits during homog	14	YW-822	14
CV 3	21	Run ALM thru homog at 4800-5200 psi into V- 215			
		NOTE: Collect material homog below 4800 psi and return to ALM			

NW 30577

QUIPMENT		PAGE 2 CG 46 CODE YW-822-P (B) EST. WGT. _____ LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 3	22	While homogenizing, at 5-10 min intervals, jog agitator on ALM to maintain color suspension			
	23	Rinse ALM with 240 # water calculated in S 2 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 10.7 (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 4	32	Clean Homog per SOP	25	3-A	25
		Add 2 Drs. 900 Lbs. YW-822 #30770	900	YW-822	900
CV 5	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			
		1700 ± 196 210 840			
		1 4			
		GRAND TOTAL NET PACK 840			
		NOTE: After discharging ± 25G, 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			
		12:00 pm 8:00 pm SG			

13830 REV

DUP050293161



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