

CG 46 CODE YW-731-F PKG 36 TIME

PROCESSES

APPROVED BY

() YW-734-P (J)

EWK 10/27/91

(DATE)

(LOT NUMBER)

JOB NAME: 46YW731FMJ

TYPED BY: JMH

EST. WT. ~~75.49~~ LBS.

STANDARD HRS.

TIME 11:00 A.M.

COMPONENT / CONSTITUENT CONSUMPTIONS:

CG	CODE	LOT	PQ	DISP	ACCOUNT* POUNDS	PERCENT SOLIDS	PHYSICAL USE POUNDS
46	YC-5-A	D2H03	93		1076	33.10	3250
46	YC-5-A	D2H03	93		1076	33.10	3250
46	YK-889-P	38260	98		537	41.47	1295
46	YK-889-P	38339	98		359	36.80	970
46	YW-731-P	D2K83-2	93		100		100
46	YW-731-P	D2K83-2	98		11		11

* INPUT INTO BIPREV PROGRAM

(Ref. No. 10823)

-3 1348 BLEEDING

EQUIP MENT	NAME: "DALAMAR" YELLOW	04 PAGES	USE LBS	N-CODE	ACCT LBS
MISC 1	NOTE: MAKING SUPV. - 1 HOUR BEFORE TAKING S34 SAMPLE, ADVISE CTL SUPV OF STATUS RUN IN + OR - 150 # WATER INTO ALM & CHECK FOR LEAKS RECORD: FINDINGS <u>None</u> NOTE: (1) IF LEAKS FOUND, ADVISE SUPV'R & DO NOT PROCEED WITH BATCH UNTIL CORRECTED. (2) IF NO LEAKS FOUND, DRAIN ALM & PROCEED WITH BATCH OBTAIN DALAMAR YELLOW PRESSCAKE AS LISTED ABOVE OBTAIN RENEX 20 & MIX TO UNIFORMITY FOR S9 & S16 CALCULATE FOR S28 $521 \times YC5A \text{ PULP WGT}(S2) = 150 \text{ # WATER}$ $521 \times$			JUN 7 1982 71-889-P YC-5-A 896-B	896 107
ALM 2	5 CLOSE ALM #2 OUTLET & RUN IN <u>350</u> # WATER ADD SODIUM CARBONATE & STIR 5 MIN TO DISSOLVE. STOP AGITATOR DUMP IN 2 DRUMS YC5A FROM S2 & SCRAPE DRUMS POUR IN RENEX 20 START AGITATOR & STIR ONE MINUTE ONLY RECORD: TEMP <u>72</u> DEG F NOTE: (1) IF COLOR BRIDGING OCCURS, STOP AGITATOR ALLOW TO STOP & DIS- LODGE COLOR (2) OVER STIRRING WILL GENERATE EX- CESSIVE HEAT & FOAM		20 200	3-A 896-B	20 200

Ch

EQUIP MENT		PAGE 02 OF 04 CG 46 CODE YW-731-P (J)	USE LBS	N-CODE	ACCT LBS
ALM 2 CONT.	11	ADD 6 MORE DRUMS YC-5-A (S2) IN 2 DRUM INCREMENTS USING FOLLOWING PROCEDURE (SCRAPE DRUMS) (1) AGITATOR OFF, DUMP IN 2 DRUMS YC-5-A (2) START AGITATOR & STIR ONE MINUTE ONLY FOR EACH 2 DRUM INCREMENT			
	12	RECORD: TEMP 76 DEG F			
	13	TURN ON AGITATOR & SIFT IN SODIUM CARBOXY METHYL CELLULOSE USING SIFTER IN 2-4 MINS.	8	925-A	8
	14	ADD REST OF YC-5-A IN 2 DRUM INCREMENTS USING FOLLOWING PROCEDURE (SCRAPE DRUMS): (1) AGITATOR OFF, DUMP IN 2 DRUMS YC-5-A (2) START AGITATOR & STIR ONE MINUTE ONLY FOR EACH 2 DRUM INCREMENT			
	15	RECORD: TEMP 78 DEG F	491		491
	16	POUR IN RENEX 20 & STIR 5 MIN.		896-3	
	17	RINSE GRATING SIDES & MIXER BASKET WITH 50# WATER			
	18	STIR 60 MIN RECORD: START 8:30 AM NOTE: (1) DO NOT EXCEED 95 DEG F DURING STIR (2) IF NECESSARY, CUT STIR WHEN TEMP REACHES 95 DEG F			
	19	RECORD S18 STIR TEMP EVERY 10 MINUTES			
		TIME INTERVAL, MIN DEG F			
		8:30 0 80			
		8:40 10 82			
		8:50 20 84			
		9:00 30 86			
		9:10 40 88			
		9:20 50 88			
		9:30 60 94			
	20	POUR IN AF-60 ANTIFOAM & STIR 5 MIN.	2 OZ.	816-A	0
	21	STOP AGITATOR RECORD: TEMP 94 DEG F			
	22	RECORD: PH 10.2 (10.0-12.0)			
	23	IF NECESSARY, ADJUST TO PH. 10.0-12.0. NOTE: DISSOLVE 1# N-3-A (SODIUM CARBONATE) IN 5# WATER RECORD PH. ACETIC ACID ASSUME 70%		3-A 30-D	
	24	POUR IN NUOSEPT 95 & STIR 5 MIN.	140	195-B, D	140
	25	WHEN SCHEDULE, POUR IN LOT NOTE: ADD AS VOLUME PERMITS DURING HOMOG	11 50	YW-731	111
	26	STOP AGITATOR			

EQUIP MENT	PAGE 03 OF 04 CG 46 CODE YW-731-P (J)	USE LBS	N-CODE	ACCT LBS																																						
CV 3	21 RUN ALM THRU HOMOG AT 4800-5200 PSI INTO V-115 NOTE: (1) COLLECT MATERIAL HOMOG BELOW 4800 PSI AND RETURN TO ALM (2) DO NOT ALLOW HOMOG TEMP TO EXCEED 120 DEG F (3) IF HOMOG PRESSURE AT UPPER LIMIT (5200 PSI) & TEMP BORDERLINE, LOWER HOMOG PRESSURE + OR - 100 PSI. TEMPER SHOULD DROP 3 TO 4 DEG F PER 100 PSI CUT IN PRESSURE. DO NOT GO LOWER THAN 4800 PSI (LOWER LIMIT) (4) IF TEMP BECOMES EXCESSIVE, STOP HOMOG & ADVISE SUPV'R. THIS CONDITION INDICATES FOREIGN MATERIAL HUNG UP BETWEEN BALLS & SEATS CAUSING SLURRY TO RECIRCULATE WITHIN HOMOGR. 25 DURING S27 HOMOG, RECORD HOMOG DISCHARGE TEMP EVERY 10 MIN <table border="1"> <thead> <tr> <th>TIME</th> <th>INTERVAL MIN</th> <th>DEG F</th> </tr> </thead> <tbody> <tr> <td>START</td> <td>0</td> <td>110</td> </tr> <tr> <td>1:30</td> <td>10</td> <td>112</td> </tr> <tr> <td>1:40</td> <td>20</td> <td>114</td> </tr> <tr> <td>1:50</td> <td>30</td> <td>114</td> </tr> <tr> <td>2:00</td> <td>40</td> <td>114</td> </tr> <tr> <td>2:10</td> <td>50</td> <td>114</td> </tr> <tr> <td>2:20</td> <td>70</td> <td>114</td> </tr> <tr> <td>2:30</td> <td>80</td> <td>114</td> </tr> <tr> <td>2:40</td> <td>90</td> <td>114</td> </tr> <tr> <td>2:50</td> <td>100</td> <td>114</td> </tr> <tr> <td>3:00</td> <td>110</td> <td></td> </tr> <tr> <td>3:10</td> <td>120</td> <td></td> </tr> </tbody> </table> 29 RINSE ALM WITH <u>150</u> # WATER CALCULATED IN S4 THRU HOMOGENIZER AT 2000-5000 PSI 30 DRAIN LINES FROM HOMOG TO CV INTO DRUM AND POUR INTO CV 31 ADD AF-60 ANTIFOAM & STIR 30 MIN. 32 RECORD: PH <u>10.2</u> (10.0-12.0) 33 IF NECESSARY, ADJUST TO PH 10.0-12.0 NOTE: DISSOLVE 1# N-3-A SODIUM CARBONATE IN 5# WATER. RECORD PH <u>10.2</u> ACETIC ACID ASSUME 70% 34 DISCHARGE + OR - 25 G THRU PACKOUT LINE & POUR INTO CV 35 FILL 1-16 OUNCE JAR FROM PACKOUT LINE & DELIVER TO CTL FOR COLOR RECORD S47 36 FILL 1-16 OUNCE JAR FROM PACKOUT LINE & RUN 100 MESH SCREEN TEST PER SOP RECORD: RESULTS S47 37 IF SCREEN TEST IS OK, CLOSE MANHOLE COVER, TURN OFF LIGHT, & LEAVE AGITATOR ON. NOTE: IF SCREEN TEST IS NOT OK, NOTIFY SUPERVISOR.	TIME	INTERVAL MIN	DEG F	START	0	110	1:30	10	112	1:40	20	114	1:50	30	114	2:00	40	114	2:10	50	114	2:20	70	114	2:30	80	114	2:40	90	114	2:50	100	114	3:00	110		3:10	120		4 OZS 816-A 3-A 30-D	1
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EQUIP MENT		PAGE 04 OF 04 CG 46 CODE YW-731-P (J)	USE LBS	N-CODE	ADDT LBS
HOMOG 4	38	CLEAN HOMOGINIZER PER STANDARD PRACTICE SODIUM CARBONATE	25	3-A	25
CV 5	39	ADD _____ # WATER AS REQUIRED TO CV NOTE: IF TEST IS SATISFACTORY, OMIT S! 38-41			
	40	START AGITATOR & STIR 20 MIN. OR LONGER TO UNIFORMITY			
	41	FILL 1-16 OUNCE JAR FROM PACKOUT LINE & DELIVER TO CTL FOR COLOR RECORD: S47			
	42	SHUT OFF AGITATOR UNTIL TEST IS AVAILABLE			
	43	WHEN TEST IS SATISFACTORY, START AGITATOR			
	44	STIR 5 MIN OR LONGER			
	45	CHECK PACKOUT SCALE ACCURACY: 50# <u>50</u> 500# <u>500</u>			
	46	DISCHARGE THRU PACKOUT SCREEN AS FOLLOWS: PKG. N-CODE SCHEDULED PK TOTAL NET PK <u>DO 36 ADDIS PACK</u> <u>2</u> <u>5000</u> <u>N-1775</u> <u>2</u> <u>900</u> <u>N-1924</u> <u>4</u> <u>3600</u> GRAND TOTAL NET PACK <u>6920</u>			
		NOTE: AFTER DISCHARGING + OR - 25 G, FILL 2-16 OUNCE JARS FROM PACKOUT LINE, + 1 qt preship MARK "FINAL". DELIVER TO CTL WHEN PACKOUT IS COMPLETED. RECORD S47			
	47	STOP AGITATOR			
	48	RECORD: RESULTS TIME SUPV			
		S34 CLOR SAMPLE TO CTL _____			
		S35 SCREEN TEST _____			
		S40 RESAMPLE TO CTL _____			
		S45 SAMPLE DURING PKOUT _____			
		S45 DELIVER TO CTL _____			
		START <u>11:00 AM</u> FINISH <u>1:00 PM</u> OPIR <u>322</u> <u>9:30 AM</u> <u>3:00 PM</u> <u>101</u>			

Need n-896
CK Top on strainer going
into Hom.