CO 46 CODE YW-811-P PKG. 55

→ JAN 21 81 38698-2

EST. WGT. ~~5501~~ LBS.

Total Wgt ~~7954~~# (Req_____)

PROCESSES	APPROVED BY
YW-811-P (B)	BBK 8-17-77
	BCG 8-29-76
TYPED BY	
NSA 8-30-77	

MAKING NOTES

REMARKS

NAME: DALAMAR® YELLOW

BLENDING

INSTRUCTIONS —PRESSING— RECORD

VAT						
DATE						
TIME						
RELEASED BY						
PRESS						
NO. OF CAKES						

PRESS ABITATION
WASH TO OHMS
TEST AFTER HOURS
LOAD

SAMPLES
DELIVER TO

PRESSLOAD	1ST	2ND	3RD	4TH	5TH
STARTED					
CAKES USED					
WATER ON					
HRS. WASHED					
OHMS					
HRS. WASHED					
OHMS					
HRS. WASHED					
OHMS					
CAKE CONDITION					
NO. CARS LOADED					

EXPLAIN LOSSES

SAMPLED BY RELEASED BY

—DRYING—

HOURS L.V. H.V.
TEMP. °F °F

LUMP: — OK — WET — SALTS — CONTAMINATE

ADDITIONAL DRYING HOURS REQUIRED

SAMPLES
DELIVER TO

NO. CARS PULLED LUMP WGT.
SAMPLED BY RELEASED BY

—GRINDING—

MILL SCREEN RPM
MAX. TEMP. °F

SCREEN RPM
MAX. TEMP. °F

EXPLAIN LOSSES

SAMPLE AFTER / WITHOUT MIXING
SAMPLES
DELIVER TO C T L

DATE MIXED

SAMPLED BY RELEASED BY

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

LOT # → ____

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

PROCESSES	APPROVED BY
( ) YW-811-P	
( )	
( )	
( )	
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 (Before pumping to CTL)	USE LBS	N CODE	ACC LB
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			
		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	2400
	3	Obtain & Mix to uniformity for S9 & S13		896-B	
	4	Calculate for S27			
		6600 # YC-11-A Pulp Wgt (S2) = 1989 # Water			
		6500			
ALM 2	5	CLOSE ALM # 2 outlet & run in 250# WATER			
	16	DO NOT START AGITATOR			
	17	POUR IN ASSUME 50%	8	7-D	4
	18	DUMP IN 2 DRUMS OF YC-11-A FROM S2			
	6	POUR IN	200	896-B	200
	10	START AGITATOR & STIR ONE MINUTE ONLY			
		RECORD: TEMP 61 °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 64 °F			
60# YC-11-A IN	13	START AGITATOR & POUR IN & STIR 5 MIN	420	896-B	420
	14	RINSE GRATING, SIDES & MIXER BASKET WITH 150# WATER			

PUNCHED & CHECKED

DUP050292013

MAKING INSTRUCTIONS: BATCH UNI

V. ALM #2 C.V. 214,215 320 only D.V.

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

LOT JAN 20 81 38698-1,2+3

TAB: PUNCH TOTAL WGT AS EST WGT 15383 17867
EST WGT. (DO NOT PUNCH) ~~6561~~ LBS
(REQ. # _____)

TAB PUNCH FOLLOWING CONSUMPTIONS:

PROCESSES		APPROVED BY
( ) YW-811-P	(8)	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. ~~7061~~ 27,799 22983

12,600# To Lot 38698-1
5200# To Lot 38698-2
±5183# To Lot 38698-3

Make 2nd Batch into 320

YW811P Lot 37973-1 - Do Not add until told so by CTL
JJS

NON-BLEEDING

QUIPMENT		NAME: DALAMAR® YELLOW	USE LBS.	N CODE	ACC LBS.
		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			

Emulsogen Rev.

DUP050292014

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			

UIPMENT		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 11:45 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 START / INTERVAL, MIN 0 / °F 72			
		10 / 76			
		20 / 78			
		30 / 80			
		40 / 82			
		50 / 86			
		60 / 90			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 93 °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			
CY 3	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 START	INTERVAL MIN	°F	TIME	INTERVAL MIN	°F
	0	98	3:40	70	116
2:30 AM	10	92	3:50	80	116
2:40	20	94	4:00	90	116
3:00	30	98	4:10	100	116
3:10	40	108	4:20	110	116
3:20	50	108	4:30	120	116
3:30	60	112			

26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
27	Rinse ALM with 125# 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 11.1 (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			

DUP050292016

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.			
OMOG 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 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 S46			
	45	Stop agitator			
	46	Record: Results Time Supv S34 Screen tested S33 Color sample to CTL S39 Resample to CTL S44 Samples during packout S44 Delivered to CTL START FINISH OPERATOR 11 AM 3 PM 114 NOTE: 3½ HRS. SPENT CLEANING EQUIPMENT 1/21/81 ½ AT HOSPITAL (BLOOD SAMPLE). [illegible]			

DUP050292017

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

LOT # → ____

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

PROCESSES	APPROVED BY
( ) YW-811-P	
( )	
( )	
( )	
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 LB
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 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	2400
	3	Obtain & Mix to uniformity for S9 & S13		896-B	
	4	Calculate for S27			
		6881-4592# YC-11-A Pulp Wgt (S2) = 1989 # water			
		65R1			
ALM 2	5	CLOSE ALM # 2 outlet & run in 250# WATER PUNCHED & CHECKED			
	6	DO NOT START AGITATOR			
	7	POUR IN ASSUME 8%	8	7-D	4
	8	PUMP IN 2 DRUMS OF YC-11-A FROM S2 +/- 30 lbs.			
	9	POUR IN	200	896-B	200
	10	START AGITATOR & STIR ONE MINUTE ONLY			
		RECORD: TEMP 63 °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 63 °F			
	13	START AGITATOR & POUR IN & STIR 5 MIN	420	896-B	420
	14	RINSE GRATING, SIDES & MIXER BASKET WITH 150# WATER			

DUP050292018