LOT # →

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

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 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			
		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		YC-11-A	2407
	3	Obtain & Mix to uniformity for S9 & S13		896-B	
	4	Calculate for S27			
		~~6681~~ 6845 # YC-11-A Pulp Wgt (S2) = # water			
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	200
	10	START AGITATOR & STIR ONE MINUTE ONLY			
		RECORD: TEMP 77 °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 79 °F			
→	13	START AGITATOR & POUR IN & STIR 5 MIN	420	896-B	420
	14	RINSE GRATING, SIDES & MIXER BASKET WITH 150# WATER			

EC

MAKING INSTRUCTIONS: BATCH UNIT

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

CG 46 CODE YW-811-P PKG. 06 TIME 7 AM

→ LOT SEP 18 80 37133-1

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

TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT. (DO NOT PUNCH) ~~5561~~ 5840 LBS
(REQ. # _____)

TAB PUNCH FOLLOWING CONSUMPTIONS:

CG	CODE	LOT	PQ	DISP	LBS.	TAB: %	DO NOT PUNCH PULP WGT
46	YC-11-A	30645	93		7	35.30	20
46	YC-11-A	36988	93		2000	36.40	5250
46	YC-11-A	36997			~~[illegible]~~ 454	34.90	1300
46	YW-811-P						
46	YW-811-P						

5% WATER ADDED = 377#

TOTAL WGT. ~~7061~~ ~~7561~~ 7541 8301 # 8301

8210 / 8301 X 100 = 98.9%

SEP 19 1980

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			
		~~[illegible]~~ #- _____ # YC-11-A pulp wgt (S 1) = _____ # water			
		6521			
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			

DUP050108051

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			

DUP050108052

EQUIPMENT		PAGE 2 OF 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
ALM 2 CONT	15	STIR 60 MIN. RECORD: START 12:25PM			
		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			
		12:35P 10 84			
		12:45 20 90			
		12:55 30 92			
		1:05 40 92			
		1:15 50 94			
		1:25 60 95			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 95 °F			
	19	Record: pH 11.5 (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 3	24	Run ALM thru homog at 4800-5200 psi into V-			
		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 SUPV/F. THIS CONDITION INDICATES FOREIGN MATERIAL HUNG UP BETWEEN BALLS & SEATS CAUSING SCURRY 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			70	
	10			80	
	20			90	
	30			100	
	40			110	
	50			120	
	60				

	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
	27	Rinse ALM with 150# water calculated in S14 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 11.2 (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 S46			

DUP050108053

EQUIPMENT		PAGE 3 OF 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 397 # 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			
		[redacted] [redacted] [redacted]			
		1775 [redacted] 1776 lb			
		[redacted] [redacted]			
		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 FINISH OPERATOR			
		12:30 AM 7 AM 438			
		3:00 PM 5:30 PM 101 165			

DUP050108054

MAKING INSTRUCTIONS: BATCH UNIT

S.V. C.V. D.V.

CG _____ CODE _____ PKG. _____

→

EST. WGT. _____ LBS.

STD. HRS. _____ TIME _____ M

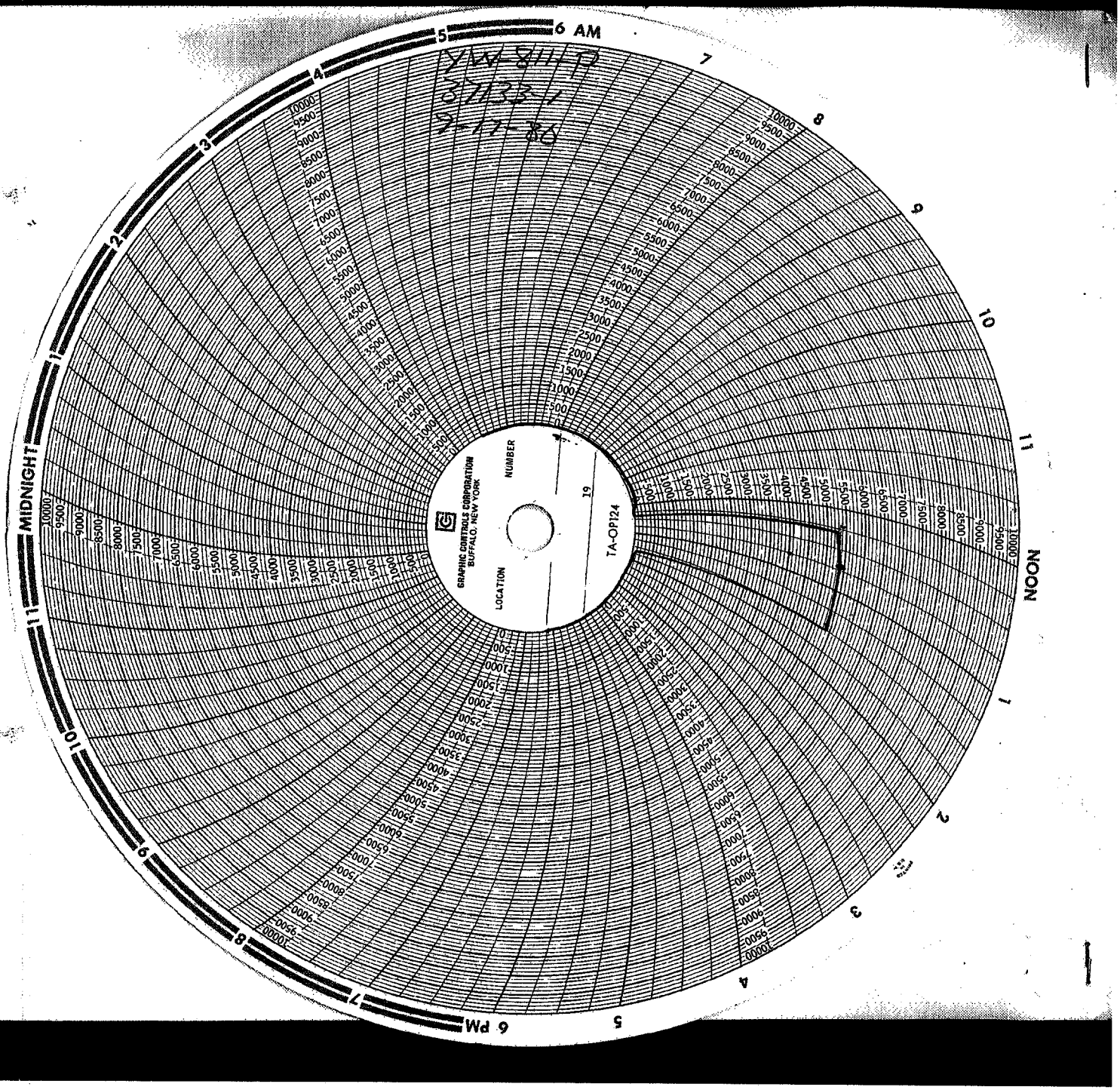
PROCESSES		APPROVED BY
( )	( )	
( )	( )	
( )	( )	
( )	( )	
TYPED BY		

NON-BLEEDING

EQUIPMENT		NAME:	USE LBS.	N CODE	ACCT. LBS.

K 13929 REV.

DUP050108055



YW-811-P
3733-1
7-17-80

DUP050108056