V. ALM #2 C.V. 214,[illegible],320 D.Y.

CG 46 CODE YW-811-P PKG. 61 TIME 7A M

→ LOT OCT--6[illegible]30 37358 -1 ~~5071~~ 5708 #

TAB: PUNCH TOTAL WGT AS EST WGT ~~4400~~ ~~5501~~ LBS 99%

EST WGT. (DO NOT PUNCH)

(REQ. #)

TAB PUNCH FOLLOWING CONSUMPTIONS:

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

DONE

CG	CODE	LOT	PQ	DISP	LBS.	TAB: %	DO NOT PUNCH PULP WGT
46	YW-811-P	37113-1	93		39		
46	YW-811-P	37123-1	93		110		
46	YW-811-P	37124-2	93		250		
46	YW-811-P	37073-1	93		340		
46	YW-811-P	36708-1	93		~~250~~ 450		
46	YC-11-A	37016-1	93		243		
46	YC-11-A	37242	93		741		
			TOTAL WGT.		~~7911~~ 8819 ~~7565~~ 8393		

46 YC-11-A 36997 93 ~~680~~ 680 #

46 YC-11-A 36988 93 937 #

46 YC-11-A 37217 93 ~~375~~ #432 #

8885 / 9030 × 98.4%

NON-BLEEDING

EQUIPMENT		NAME: DALAMAR® YELLOW	USE LBS.	N CODE	ACT 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			
		~~6944~~ 6372 # YC-11-A pulp wgt (S 1) = 200 # 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			

N35225

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			
		_____ _____ _____			
		_____ _____ _____			

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QUIPMENT		PAGE 2 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
ALM 2 CONT	15	STIR 60 MIN. RECORD: START 2:35			
		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			
		2:45 10, 74			
		2:55 20 79			
		3:05 30 81			
→		3:15 40 81			
		3:25 50 82			
		3:35 60 84			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 86 °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	340		
	23	When scheduled dump in Lot 37073-1 ✓ 782092	80	2 YW-811-	
		NOTE: If ALM is full, add as vol 37133-1 ✓	110		
		permits during homog 37113-1 ✓	38		
		37124-2 ✓	250		
CV 3	24	Run ALM thru homog at 4800-5200 psi into V-320 36708-1 ✓	250		
		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	INTERVAL, MIN	°F	TIME	INTERVAL, MIN	°F
START	0	92	5:20	70	100
4:20	10	94	5:30	80	100
4:30	20	94	5:40	90	100
4:40	30	98	5:50	100	100
4:50	40	100	6:00	110	100
5:00	50	100	6:10	120	100
5:10	60	100	6:20		

	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
	27	Rinse ALM with 200# 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 11.5 (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			

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UIPMENT	#	PAGE 3 CG 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 587 # 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
1924	7	1610
1700	± 180	7240 35
	GRAND TOTAL NET PACK	8885

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	o.k.	3rd Shift	EC 409
	S 33 Color sample to CTL			
	S 39 Resample to CTL			
	S 45 Samples during packout			
	S 44 Delivered to CTL			

START	FINISH	OPERATOR
9:30 AM	3:00 PM	101
3:00 PM	7:00 PM	105
6:00 AM	7:00 AM	409
11:00 PM	1:15 AM	409

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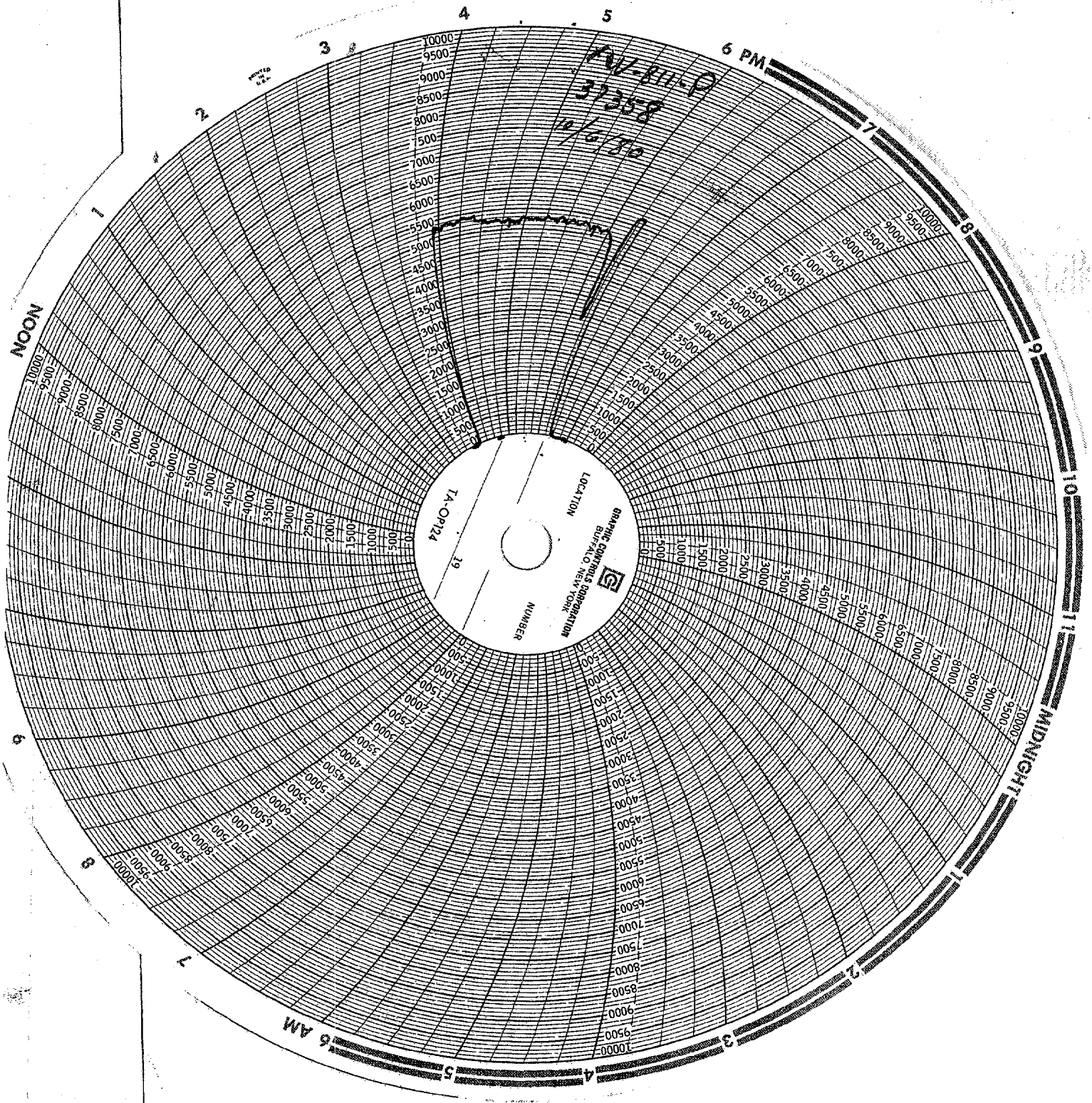

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