ALM #2 C.V. 214,215 (320) ONLY D.V.

CG 46 CODE YW-811-P PKG. 55 TIME M

→ LOT JDN 21 81 38777 ~~38698~~

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	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	~~38~~ 37999	93		549		
46	YW-811-P						
46	YW-811-P						
				TOTAL WGT.	~~7961~~ 7460		

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			
	1	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			
		1650 RI			
ALM 2	5	CLOSE ALM # 2 outlet & run in 2150# 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	20
	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	42
	14	RINSE GRATING, SIDES & MIXER BASKET WITH 150# WATER			

IPMENT		PAGE 2 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. Cas.
LM 2 ONT	15	STIR 60 MIN. RECORD: START 1:30 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 / INTERVAL, MIN / °F			
		START 0 76			
		1:40 Pm 10 78			
		1:50 20 82			
		2:Pm 30 87			
		2:10 40 86			
		2:20 50 89			
		2:30 60 92			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 94 °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			
Y 13	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	INTERVAL MIN	°F	TIME	INTERVAL MIN	°F
START	0		4.10 Pm	70	105
3.10 Pm	10	104	4.20	80	105
3.20	20	105	4.30	90	105
3.30	30	105	4.40 Pm	100	105
3.40	40	105		110	
3.50	50	105		120	
4 Pm	60	105			

	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
2	27	Rinse ALM with 1989 # 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 10.7 (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 S 46			

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JIPMENT		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.			
HOMOG 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
~~N-1775 55gal~~	~~28~~	
N-1701	± 104	
N-1775	28	
	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
12:45 PM	3:PM.	BB

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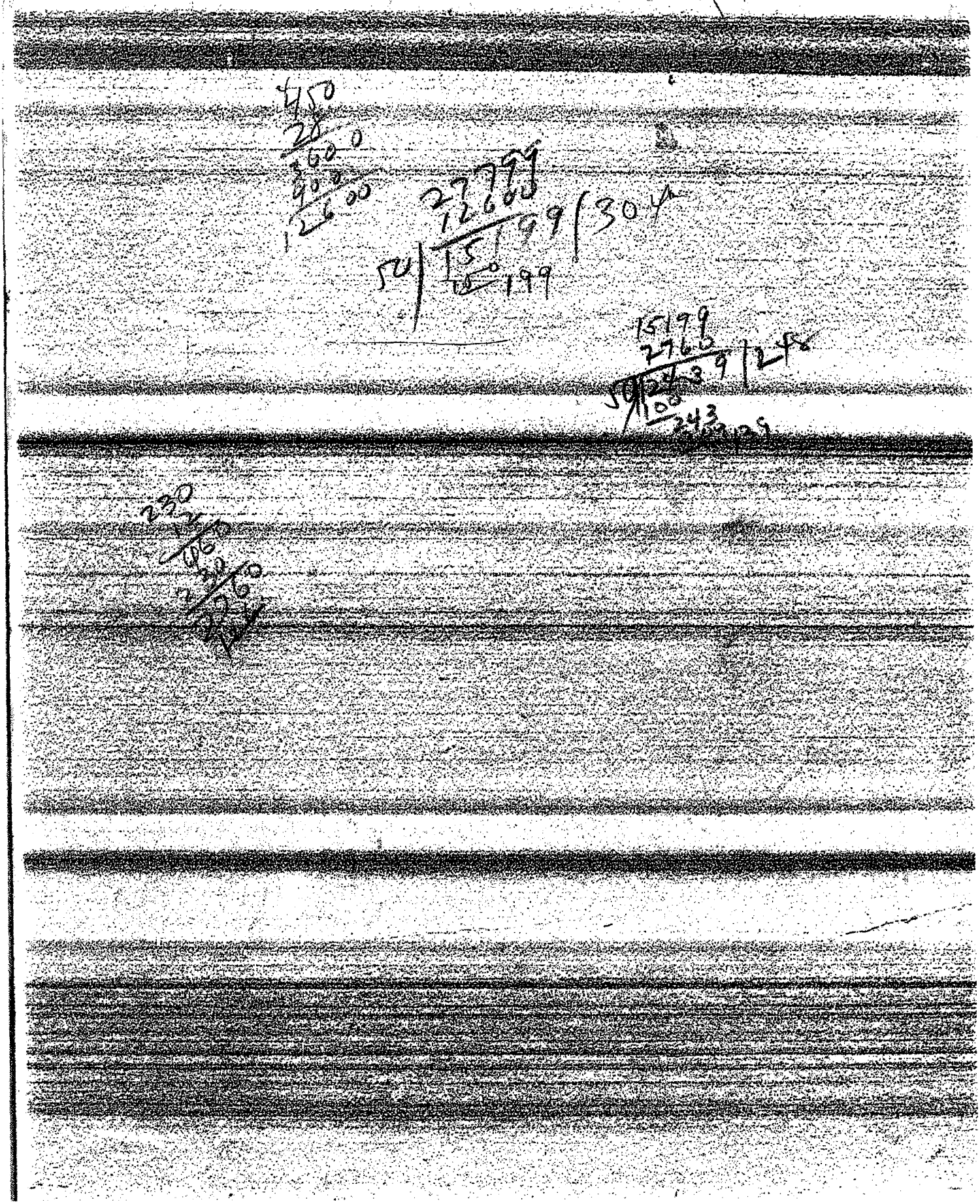

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