

MAKING INSTRUCTIONS: DATA UNIT

ALM #2

C.V. 214.215/320

D.V.

CG 16 CODE RW-768-P PKG. 06 TIME 1400

LOT MAY -0-81-Σ1259-1

TAB: PUNCH TOTAL WGT AS EST WGT 6386  
EST WGT (DO NOT PUNCH) ~~200~~ LBS  
(REQ # )

TAB: PUNCH FOLLOWING CONSUMPTIONS

**TAB: DO NOT PUNCH**

| PROCESSES    |     | APPROVED BY |
|--------------|-----|-------------|
| ( ) RW-768-P | (K) | BBK 8-29-77 |
| ( )          | ( ) | DCG 8-30-77 |
| ( )          | ( ) |             |
| ( )          | ( ) |             |
| TYPED BY     |     |             |
| NSA 9-2-77   |     |             |

| <u>CG</u> | <u>CODE</u>     | <u>LOT</u>   | <u>PQ</u> | <u>DISP</u> | <u>LBS</u>  | <u>%</u> | <u>PULP WGT</u> |
|-----------|-----------------|--------------|-----------|-------------|-------------|----------|-----------------|
| <u>16</u> | <u>RC-3-A</u>   | <u>D1121</u> | <u>—</u>  | <u>—</u>    | <u>780</u>  | <u>—</u> | <u>—</u>        |
| <u>16</u> | <u>RC-3-A</u>   | <u>D1197</u> | <u>—</u>  | <u>—</u>    | <u>495</u>  | <u>—</u> | <u>—</u>        |
| <u>16</u> | <u>RC-3-A</u>   | <u>—</u>     | <u>—</u>  | <u>—</u>    | <u>—</u>    | <u>—</u> | <u>—</u>        |
| <u>16</u> | <u>RW-768-P</u> | <u>—</u>     | <u>—</u>  | <u>—</u>    | <u>—</u>    | <u>—</u> | <u>—</u>        |
| <u>16</u> | <u>RW-768-P</u> | <u>—</u>     | <u>—</u>  | <u>—</u>    | <u>—</u>    | <u>—</u> | <u>—</u>        |
| <u>—</u>  | <u>—</u>        | <u>—</u>     | <u>—</u>  | <u>—</u>    | <u>—</u>    | <u>—</u> | <u>—</u>        |
| <u>—</u>  | <u>—</u>        | <u>—</u>     | <u>—</u>  | <u>—</u>    | <u>—</u>    | <u>—</u> | <u>—</u>        |
| <u>—</u>  | <u>TOTAL</u>    | <u>WGT</u>   | <u>—</u>  | <u>—</u>    | <u>1275</u> | <u>—</u> | <u>76</u>       |

$$\frac{7661}{7661} \times 100 = 100\%$$

(Reg # 10811)

|      |                                                            | NON-BLEEDING     |             |             |               |
|------|------------------------------------------------------------|------------------|-------------|-------------|---------------|
| MENT | NAME:                                                      | MONASTRAL® RED B | USE<br>LBS. | N -<br>CODE | ACCT.<br>LBS. |
| ISC  | Note: Making Supv - 1 hr before taking S 24 sample, advise |                  |             |             |               |
| 1    | CTL of status                                              |                  |             |             |               |
|      | Obtain as listed above                                     |                  |             |             |               |
|      | Calc for S 18                                              |                  |             |             |               |
|      | RC-3-A Pulp Wgt (S 1) = 1768 # water                       |                  |             |             |               |
| CM   | Pump ALM # 2 outlet                                        |                  |             |             |               |
| 2    | Do not start agitator                                      |                  |             |             |               |
|      | Dump in RC-3-A from S 1 (Must be 18% Min)                  |                  |             |             |               |
|      | Start Agitator                                             |                  |             |             |               |
|      | Add in 3-5 min                                             |                  |             |             |               |
|      | Stir 5 min & add Assume 50%                                |                  |             |             |               |
|      | Rinse grating, sides & mixer basket with 200# water        |                  |             |             |               |
|      | Stir 20 min                                                |                  |             |             |               |
|      | Stop agitator                                              |                  |             |             |               |
|      | Record: pH 11.1 (10.0-12.0)                                |                  |             |             |               |
|      | If necessary, adj to pH (10.0-12.0) Assume 50%             |                  |             |             |               |
|      | Record: pH Assume 75%                                      |                  |             |             |               |
|      | Pour in                                                    |                  |             |             |               |
|      | Stir 5 min                                                 |                  |             |             |               |
|      | When scheduled, pour in Lot                                |                  |             |             |               |
|      | Note: Add as vol will permit                               |                  |             |             |               |
|      | During Homog                                               |                  |             |             |               |
| V    | Run ALM thru Homog at 4800-5200 psi into V-37              |                  |             |             |               |
| 3    | Note: Return material homogenized below 4800 psi to ALM    |                  |             |             |               |

COMPONENT

USE  
1164  
(cont)  
WATER  
to wash  
in

PAGE 2 CG 16 CODE RW-768-P (K) EST WGT. LBS. USE LBS. N CODE

- 18 Rinse ALM with 1164 # water calculated in S 2 thru homog at 2000-5000 PSI
- 19 Drain lines from homog to CV into drum & pour into CV
- 20 Stir 20 min
- 21 Record: pH 10.6 (10.0-12.0)
- 22 If necessary, adjust to pH 10.0-12.0 Assume 50%  
Record: pH Assume 75%
- 23 Discharge ±25 G thru packout line & pour into CV
- 24 Fill 1-16 ounce jar from packout line & deliver to CTL for color. Record in S 37
- 25 Fill 1-16 ounce jar from packout line & run 100 mesh screen test per SOP. Record results S 37
- 26 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

- 27 Clean Homog per SOP

CV 5

- 28 Add # water as required to CV  
Note: If test is satisfactory, omit S's 28-31
- 29 Start agitator & stir 20 min or longer to uniformity
- 30 Fill 1-16 ounce jar from packout line & deliver to CTL for color. Record in S 37
- 31 Shut off agitator until test is available
- 32 When test is satisfactory, start agitator
- 33 Stir 5 min or longer
- 34 Check packout scale accuracy: 50# 500#
- 35 Discharge thru packout screen as follows:  

| PACKAGE N-CODE       | SCHEDULED PACK | TOTAL NET PACK |
|----------------------|----------------|----------------|
| N-1775               | 17             | 17             |
| N-1701               | 1              | 1              |
| GRAND TOTAL NET PACK |                | 18             |
- 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 37

- 36 Stop agitator
- 37 Record:

| Results                    | Time | Supv |
|----------------------------|------|------|
| S 25 Screen test           |      |      |
| S 24 Color Sample to CTL   |      |      |
| S 30 Resample to CTL       |      |      |
| S 35 Sample during packout |      |      |
| S 35 Deliver to CTL        |      |      |

| START   | FINISH   | OPTR  |
|---------|----------|-------|
| 5:00 PM | 10:30 PM | 10:30 |