PUNCHED & CHECKED

MAKING INSTRUCTIONS: BATCH UNIT

S.V. ALM #2 JUL - 8 1980 C.V. 214,215,320 only D.V.

CG 32 CODE RW-635-P PKG. 05 TIME 7 M

→ LOT 36234-1 JUNE 24

PROCESSES		APPROVED BY
( ) RW-635-P	(x)	JJG 7-12-77
( )	( )	DCG 7-12-77
( )	( )	MTW 7-15-77
( )	( )	
TYPED BY		
NSA 8-31-77		

TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT (DO NOT PUNCH)
(REQ # _____)

13229 ~~5206~~ ~~6342~~ LBS.

TAB: PUNCH FOLLOWING CONSUMPTIONS: TAB: DO NOT PUNCH

CG	CODE	LOT	PQ	DISP	LBS	%	PULP WGT
32	RC-14-A	36138	93		1927		
32	RC-14-A	33158	93		2391		
32	RC-14-A						
~~32~~	~~RW-635-P~~	~~34167-1~~	~~98~~		~~4500~~		
~~32~~	~~RW-635-P~~	~~34153-1~~	~~98~~		~~3600~~		
32	RW635-P	33596-2	98		120 x		
32	RW635-P	33646-1	98 93		2250 x		
32	RW635-P	33596-1	TOTAL WGT		450		

20367

MAKING SUPERVISOR PUT IN ONLY 4500# OF RW635 - LOT 34167, WILL PUT IN REMAINDER DEPENDING ON QUALITY OF 1ST SAMPLE. BATCH BUTTERED UP WITH 2ND SET-UP.

add 72% water

JUL 2 1980

$\frac{19560}{20367} \times 100 = 96.0\%$

NON-BLEEDING

EQUIPMENT		NAME: WATCHUNG® RED B	USE LBS.	N CODE	ACCT. LBS.
		Note: Making Supv. - 1 hr before taking S 24 sample, advise CTL Supv. of status	5760		1927
Misc 1	1	Obtain as listed above		RC-14-A	[illegible]
	2	Calculate for S 8 ②	7357		2391
		~~6525#~~ 6000# - 5760# RC-14-A Pulp Wgt (S1) = 240 # water			
ALM 2	3	Plug ALM #2 outlet & run in 120# water ← NO WATER 2ND SET UP			
	4	Do not start agitator			
	5	Dump in 1 drum RC-14-A from S 1			
	6	Sift in	100	741-B	100
	7	Start agitator & stir minimum time to fluidize ②	100	741 B	100
		Note: Over-stirring may cause excessive foam			
	8	Dump in rest of RC-14-A (S1) in 2 drum increments. Stir minimum time to fluidize between increments. Rinse drums with 240# water calculated in S 2. If no water is available from S 2, scrape drums			
	9	Start agitator & add in 2-3 min	463	741-B	46[illegible]
	10	Rinse grating, sides & mixer basket with 100# water	558	741 B	558
	11	Stir 60 min Record: Start			
	12	Stop agitator & Record: pH 9.6 (10.0-12.0)			
	13	If necessary, adj to pH 10.0-12.0 Assume 50%	1	7-D	1
		& Record: pH 10.6 Assume 75%		30-D	
	14	Pour in	80	195-B	80
	15	Stir 5 min ②	60	195-B	60
	16	When scheduled, pour in Lot ~~34167-1~~	~~4500~~	RW-635-P	
		Note: If ALM is full, add as vol will permit during homog ~~34153-1~~	~~3600~~		
		33596-2	120		
		33646-1	~~3150~~ 2250		
		33596-1	450		

No water 2nd set up

N37454

EQUIPMENT		PAGE 2 CG 32 CODE RW-635-P (K) EST. WGT. 6342 LBS.	USE LBS.	N CODE	AC LI
CV 3	17	Run ALM thru Homog at 4800-5200 psi into V-			
		Note: Return material Homog below 4800 psi to Alm 2nd SETUP			
	18	Rinse ALM with 300# water thru Homog at 2000-5200 psi - 300# Wate			
	19	Drain line from Homog to CV into drum & pour into CV			
	20	Stir 30 min			
	21	Record: pH 9.6 (10.0-12.0)			
	22	If necessary, adj to pH 10.0-12.0 Assume 50%	2	7-D	1
		& Record: pH 10.8 Assume 75%		30-D	
	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 result in 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 Homogenizer per Standard Practice	25	3-A	25
CV 5	28	Add 289 # water as required to CV			
		Note: If test is satisfactory, omit S's 28-31			
	29	Stir 20 minutes 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 minutes 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-1275 / 37 / 19560			
		N-1200 / 2-22 & 489			
		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 37			
	36	Stop agitator			
	37	Record: Results Time Supv			
		S 24 Color sample to CTL			
		S 25 Screen Test			
		S 30 Resample to CTL			
		S 35 Samples during packout			
		S 35 Delivered to CTL			
		START FIN OPTR			