LOT # →

TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT. (DO NOT PUNCH) 5561 Lbs
(REQ. #)

TAB PUNCH FOLLOWING CONSUMPTIONS;

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

( ) YW-811-P

TYPED BY

NON-BLEEDING

QUIPMENT		NAME: DALAMAR® YELLOW	USE LBS	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			
9		RECORD: FINDINGS O			
		NOTE: (1) IF LEAKS FOUND ADVISE SUPV'R & DO NOT PROCEED WITH BATCH UNTIL CORRECTED			
4		(2) IF NO LEAKS FOUND, DRAIN ALM & PROCEED WITH BATCH			
	2	Obtain as listed above	4394	YC-11-A	2400
	3	Obtain & Mix to uniformity for S9 & S13		896-B	
	4	Calculate for S27			
		~~6881~~ 5481 - 4394# YC-11-A Pulp Wgt (S2) = 1087# water			
ALM 2	5	Close ALM # 2 outlet & run in 7150# WATER			
	6	DO NOT START AGITATOR			
	7	POUR IN ASSUME 50%	8	7-D	4
3-P	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 60 °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 70 °F			
	13	START AGITATOR & POUR IN & STIR 5 MIN	420	896-B	420
	14	RINSE GRATING, SIDES & MIXER BASKET WITH 150# WATER			

PUNCHED & CHECKED

DUP050381996

11090 R 100 = 100%
11600

MAKING INSTRUCTIONS BATCH UNIT

E.V. ALM 42 · E.T. (214) 215 300 SCRub 6.V. 214 – 3 (320)

CA 46 CODE YW-811-P SEQ. 06 TIME ______ H

LOT 29 81 38828-1

TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT. (DO NOT PUNCH) 6470 ~~4659~~ LBS
(REQ. #)

PROCESSES		APPROVED BY
(1) YW-811-P	(1)	RBK 8-17-77
( )	( )	DCG 8-29-76
( )	( )	
( )	( )	
TYPED BY HSR 8-29-77		

TAB PUNCH FOLLOWING (CORRECTIONS):

TAB: DO NOT PUNCH

CA	CODE	LOT	PC	DISP	LBS	%	PULP WGT
46	~~YW811P~~ YW811	~~37...~~ 37... 71-1	93		410 / 900 / 1420		
		38039	93		508		
46	YC-11-A	38220	98		174		10161
46	YC-11-A	38053	98		101		1016# water
46	YC-11-A	37694	98		141		
46	YW-811-A	38039	98		103		
46	YW-811-A	37976	98		27		
46	YC-11-A	37702	98		180		~~[illegible]~~ #
46	YC-11-A	37701	98		135		11,600
			TOTAL WGT.		~~1107~~		
46	YC-11-A	37695	98		18		
46	YC-11-A	38053	93		1033		

~~9409#~~ 10,161#

TAKE ONE 5 gal KIT SAMPLE

NON-BLEEDING

EQUIPMENT		NAME: DALAWARO YELLOW	USE LBS.	M CODE	ACCT. 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 & homo mix to uniformity for S 7, 11		896-B	
	3	Calculate for Step 23			
		6V219- ____ # YC-11-A pulp wgt (S 1) = ____ # 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 fluidiz-			
		ing 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 homo			
CV 3	21	Run ALM thru homo at 4000-5000 psi into [illegible]			
		Note: Collect material homo below 4000 psi & return to ALM			

DUP050291997

N 31772.01

JIPMENT		PAGE 2 CG 46 CODE YW-811-P EST. WGT. 7961 LBS.	USE LBS.	N CODE	ACCT. LBS.
4LM' 2 CONT	15	STIR 60 MIN RECORD: START 4: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 4:Pm 0 80			
		4:10 10 81			
		4:20 20 81			
		4:30 30 83			
		4:40 40 85			
		4:50 50 88			
		5:Pm 60 91			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 92 °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 37973-1	900		900
		37291-1	1420		420
CV 3	24	Run ALM thru homog at 4800-5200 psi into V-214			
		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 SUPVIR. THIS CONDITION INDICATES FOREIGN MATERIAL HUNG UP BETWEEN BALLS & SEATS CAUSING SLURRY TO RECIRCULATE WITHIN HOMOGIR.			
	25	DURING S24 HOMOG, RECORD HOMOG DISCHARGE TEMP EVERY 10 MIN			

TIME	INTERVAL, MIN	°F	TIME	INTERVAL, MIN	°F
START 5:15 Pm	0	108	6:25	70	110
5:25	10	110	6:35	80	110
5:35	20	110	6:45	90	110
5:45	30	110	6:55	100	110
5:55	40	110	7:05	110	110
6:05	50	110	7:15	120	110
6:15	60	110	7:25		

	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
	27	Rinse ALM with 1087 # water calculated in S4 thru homogenizer @ 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 11.4 (10.0-12.0)			
	31	If necessary, adjust to pH 10.0-12.0 Assume 50%		7-D	
		& Record: pH Assume 75%		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			

DUP050291998

JIPMENT		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 1626 # 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	14	6300
N1701	105	5250
N-1701	± 38	40
	GRAND TOTAL NET PACK	11590

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:

Record	Results	Time	Supv
S 34 Screen tested			
S 33 Color sample to CTL			
S 39 Resample to CTL	ADDED - 1026 # WATER	11 AM	C.C.
S 44 Samples during packout			
S 44 Delivered to CTL			

START	FINISH	OPERATOR
1 PM.	8:30 PM.	BB

DUP050291999

5/4/

DATE: 1-27-81

TO: AREA SUPERVISOR

DISPERSED PASTE - 24 HOUR SHEET

1ST SHIFT

OPERATOR: #88

Batch Code	"N" Code	Lot Number	100% Weight	No. of Drums	Comments
YW-811-P	YC-11	38220	174	1	Good.
38828-1		38053	101	1	"
		37694	141	1	"
		38039	103	1	"
		37976	27	1	"
		37702	160	1	"
		37701	135	1	"
		37695	18	1	"
		38053	1033	6	"
		38039	508	4	"
Status at shift change		YW-811-P 37973-1	900	2	"

BATCH COMPLETED.

OPERATOR:

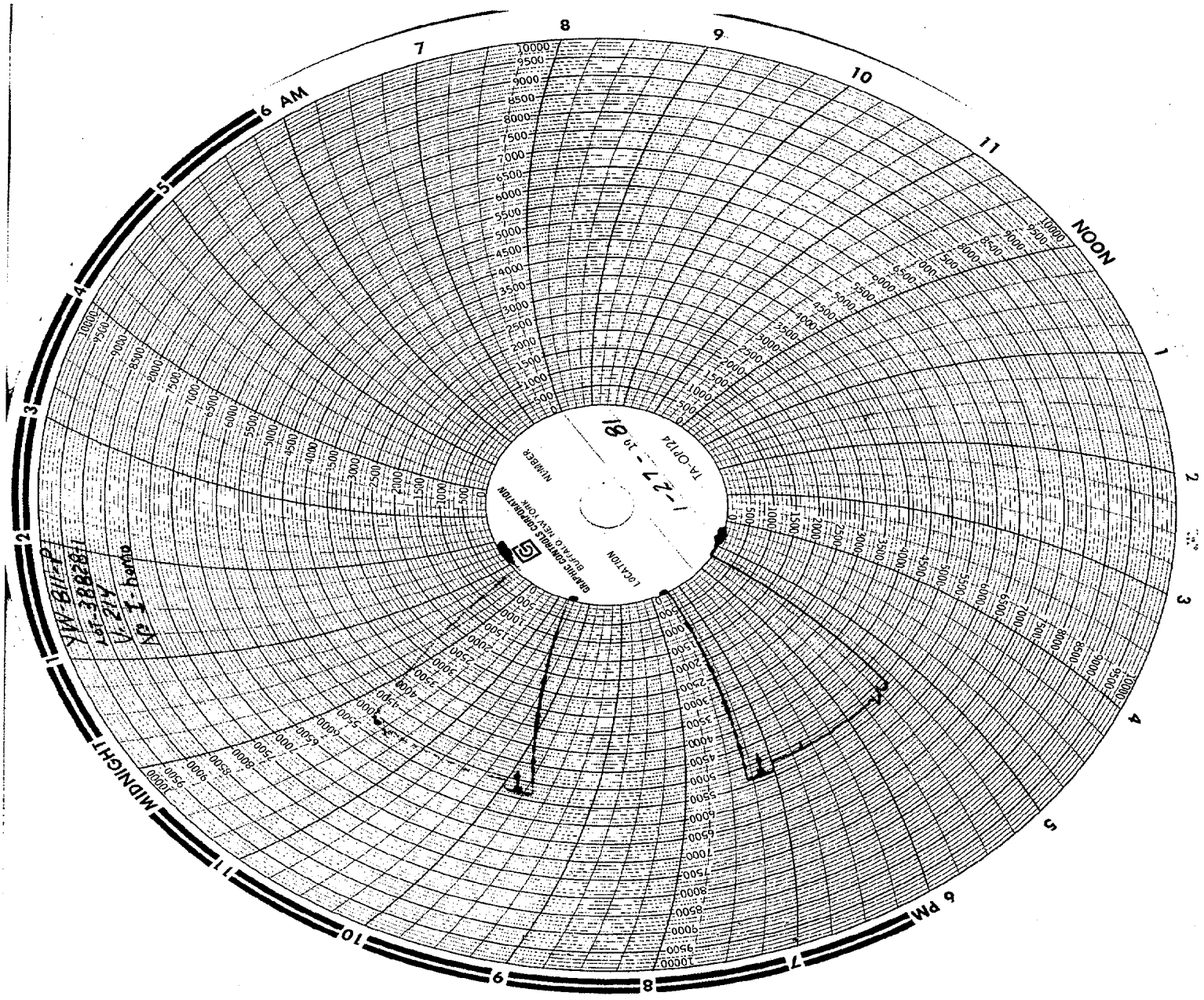
2ND SHIFT

Batch Code	"N" Code	Lot Number	100% Weight	No. of Drums	Comments

Status at shift change

DUP050292000

N 31772.02



DUP050292001

N 31772.03

CG 46 CODE YW-811-P PKG ____ TIME ____ M

LOT # → ____

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

TAB PUNCH FOLLOWING CONSUMPTIONS:

PROCESSES	APPROVED BY
( ) YW-811-P	
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			
	1 RUN IN ± 150# WATER INTO ALM & CHECK FOR LEAKS RECORD: FINDINGS NOTE: (1) IF LEAKS FOUND, ADVISE SUPVR & DO NOT PROCEED WITH BATCH UNTIL CORRECTED (2) IF NO LEAKS FOUND, DRAIN ALM & PROCEED WITH BATCH			
933	2 Obtain as listed above (SAMPLE)	4376	YC-11-A	2400
	3 Obtain & Mix to uniformity for S9 & S13		896-B	
	4 Calculate for S27 4376 # YC-11-A Pulp Wgt (S2) = 937 # water 5313 1000			
ALM 2	5 CLOSE ALM # 2 outlet & run in 1000# WATER			
	6 DO NOT START AGITATOR			
	7 POWER IN ASSUME 50%	8	7-D	4
	8 DUMP IN 2 DRUMS OF YC-11-A FROM S2			
	9 POWER IN	200	896-B	200
	10 START AGITATOR & STIR ONE MINUTE ONLY RECORD: TEMP 62 °F NOTE: (1) IF COLOR BRIDGING OCCURS, STOP AGITATOR ALLOW TO STOP & DISLODGE COLOR MANUALLY (2) OVER STIRRING WILL GENERATE EXCESSIVE HEAT & FOAM			
	11 ADD REST OF YC-11 (S2) IN 2 DRUM INCREMENTS & USING FOLLOWING PROCEDURE (SCRAPE DRUMS & CHECKED (1) AGITATOR OFF, DUMP IN 2 DRUMS YC-11, (2) START AGITATOR & STIR ONE MINUTE ONLY FOR EACH 2 DRUM INCREMENT			
	12 RECORD: TEMP 68 °F			
	13 START AGITATOR & POUR IN & STIR 5 MIN	420	896-B	420
	14 RINSE GRATING, SIDES & MIXER BASKET WITH 150# WATER			

DUP050292002

N 31772.04