.V. ALM #2 C.V. 214,215,320 D.V.

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

→ LOT [redacted] 81 [redacted] 38698-3 JAN 21

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	(B)	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		1026		
46	YC-11-A	37985	98		169		
46	YC-11-A	38040	93		521		
46	YC-11-A	38040	98		137		
46	YC-11-A	37999	93		1084		
46	YC-11-A	37999	98		28		
46	YC-11-A						
			TOTAL WGT.		~~7961~~		

6104
1025
5079

83208

NON-BLEEDING

EQUIPMENT		NAME: DALAMAR® YELLOW	USE LBS.	N CODE	ACC 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			
		6921#-____# 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 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			

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			
		_____ _____ _____			
		_____ _____ _____			

UIPMENT		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 11.35 P.M.			
		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 11.35 P.M. 0 78			
		11 45 10 80			
		11 55 20 80			
		12 5 30 82			
		12 15 40 84			
		12 25 50 86			
		12 35 60 88			
	17	Pour in and stir 5 min	2 oz.	816-A	0
	18	Stop agitator RECORD: TEMP 90 °F			
	19	Record: pH 11.0 (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			
CV 3	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 1.20 P.M.	0	105	2.40 P.M.	70	114
1.30 P.M.	10	111	2.50	80	114
1.40	20	112	3.00	90	114
1.50	30	112	3.10	100	114
2.00	40	114	3.20	110	114
2.10	50	114		120	
2.20 P.M.	60	114			

	26	While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension			
CV WIP	27	Rinse ALM with 1493# water calculated in S4 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 10.10 (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			

DUP050292026

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 ____ # 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-1701 10 #			
		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 S 46			
	45	Stop agitator			
	46	Record: Results Time Supv			
		S 34 Screen tested			
		S 33 Color sample to CTL			
		S 39 Resample to CTL			
		S 45 Samples during packout			
		S 44 Delivered to CTL			
		START 10:30 AM. FINISH 3:PM. OPERATOR BB			

DUP050292027

EQUIPMENT		PAGE 3 CG 32 CODE RT-428-D (Y) EST. WGT. 2434 LBS.	USE LBS.	N CODE	ACCT LBS.
CV 13	46	When S 43 is complete, stir 15 min			
	47	Record: pH (5.0-6.0), Temp °F (32-38°F)			
	48	Run in N-7-D from S 45 thru undersurface line			
	49	Stir 5 min & Record: pH (9.0-9.8)			
	50	If pH is below 9.0, adj to pH 9.0-9.8 Assume 50%		7-D	
	51	Record: pH , Diazo (-), Base (+)			
	52	Pour in N-246-E solution from S 19			
	53	Steam eject in V-921/931 solution from S 8			
	54	Heat to 180-182°F in 65-75 min & Record: HT °F & Rec °F			
	55	Stir 30 min at 180-182°F. Record: Start			
	56	Flood to 180-190" (±18,000 G)			
	57	Record: pH (8.8-9.3) & if necessary adj to pH 8.8-9.3 & Record: pH Assume 50%		7-D	
	58	Stop agitator			
		When instructed by Processing Area halfway thru pressing, dump in & stir 5 min. Stop agitator & resume pressing	10	588-A	10
		START FIN OPTR			

K 13830 REV.

DUP050292028