S.V. ALM #2 C.V. 214, 215, 320 D.V. DATE PRINTED: 6/10/82

CG 46 CODE YW-731-P PKG 36 TIME _____ PROCESSES ( )YW-731-P (J) APPROVED BY EWK 10/27/81 JJG 06/11/82

JUN 30 1982 G2H35-1-2-3-4
(DATE) (LOT NUMBER)

JOB NAME: 46YW731PMJ
TYPED BY: JMH

EST. WT. ~~7142~~ 7627 * LBS. 7586/7627 x100 = 99.5 STANDARD HRS. _____ TIME 7 A.M.

COMPONENT / CONSTITUENT CONSUMPTIONS:

CG	CODE	LOT	PQ	DISP	ACCOUNT* POUNDS	PERCENT SOLIDS	PHYSICAL USE POUNDS
46	YT-889-P	D1123-1	98		969		
46	YC-5-A	F2J61	93		181		
46	YC-5-A	F2J60	93		744		
46	YW-731-P						
46	YW-731-P						

Added 6% water (432#)

* INPUT INTO BIPREV PROGRAM (Reg. No. 10886) -36 2500 -01 2530 -06 1350 -55 1247 BLEEDING

EQUIPMENT		NAME: "DALAMAR" YELLOW 04 PAGES	USE LBS	N-CODE	ACCT LBS
MISC 1		NOTE: MAKING SUPV. - 1 HOUR BEFORE TAKING S44 & S46 SAMPLE, ADVISE CTL SUPV OF STATUS			
	1	RUN IN + OR - 150 # WATER INTO ALM & CHECK FOR LEAKS RECORD: FINDINGS _____ NOTE: (1) IF LEAKS FOUND, ADVISE SUPV'R & DO NOT PROCEED WITH BATCH UNTIL CORRECTED. (2) IF NO LEAKS FOUND, DRAIN ALM & PROCEED WITH BATCH			
	2	OBTAIN DALAMAR YELLOW PRESSCAKE AS LISTED ABOVE		YT-889 YC-5-A	1894
	3	OBTAIN RENEX 20 & MIX TO UNIFORMITY FOR S9 & S16		896-B	
	4	CALCULATE FOR S29 5809# (-) 5659 #YC5A + YT-889P PULP WGT(S2) = 150 #WATER			
ALM 2	5	CLOSE ALM #2 OUTLET & RUN IN 500# WATER			
	6	ADD SODIUM CARBONATE & STIR 5 MIN TO DISSOLVE.	20	3-A	20
	7	STOP AGITATOR			
	8	DUMP IN 2 DRUMS YC5A FROM S2 & SCRAPE DRUMS			
	9	POUR IN RENEX 20	200	896-B	200
	10	START AGITATOR & STIR ONE MINUTE ONLY RECORD: TEMP 86 DEG F NOTE: (1) IF COLOR BRIDGING OCCURS, STOP AGITATOR ALLOW TO STOP & DISLODGE COLOR (2) OVER STIRRING WILL GENERATE EXCESSIVE HEAT & FOAM			

JUL 6 1982

7/2

N32591

DUP050463705

EQUIPMENT		PAGE 02 OF 04 CG 46 CODE YW-731-P (J)	USE LBS	N-CODE	ACCT LBS
ALM 2 CONT.	11	ADD 6 MORE DRUMS YC-5-A (S2) IN 2 DRUM INCREMENTS USING FOLLOWING PROCEDURE (SCRAPE DRUMS)			
		(1) AGITATOR OFF, DUMP IN 2 DRUMS YC-5-A			
		(2) START AGITATOR & STIR ONE MINUTE ONLY FOR EACH 2 DRUM INCREMENT			
	12	RECORD: TEMP 80 DEG F			
	13	TURN ON AGITATOR & SIFT IN SODIUM CARBOXY METHYL CELLULOSE USING SIFTER IN 2-4 MINS.	8	925-A	8
	14	ADD REST OF YC-5 (S2) IN 2 DRUM INCREMENTS USING FOLLOWING PROCEDURE (SCRAPE DRUMS):			
		(1) ADITATOR OFF, DUMP IN 2 DRUMS YC-5			
		(2) START AGITATOR & STIR ONE MINUTE ONLY FOR EACH 2 DRUM INCREMENT			
	15	RECORD: TEMP 82 DEG F			
	16	POUR IN RENEX 20 & STIR 5 MIN.	466	896-B	466
	17	RINSE GRATING SIDES & MIXER BASKET WITH 50# WATER			
	18	STIR 60 MIN RECORD: START 10:50 AM			
		NOTE: (1) DO NOT EXCEED 95 DEG F DURING STIR			
		(2) IF NECESSARY, CUT STIR WHEN TEMP REACHES 95 DEG F			
	19	RECORD S18 STIR TEMP EVERY 10 MINUTES			

TIME	INTERVAL, MIN	DEG F
10:50 A	0	85
11:00 A	10	87
11:10 A	20	88
11:20 A	30	90
11:30 A	40	91
11:40 A	50	93
11:50 A	60	94

	20	POUR IN AF-60 ANTIFOAM & STIR 5 MIN.	2 OZ.	816-A	0
	21	STOP AGITATOR RECORD: TEMP 95 DEG F			
	22	RECORD: PH 9.8 (10.0-12.0)			
	23	IF NECESSARY, ADJUST TO PH 10.0-12.0. NOTE: DISSOLVE 1# N-3-A (SODIUM CARBONATE) IN 5# WATER RECORD PH 10.4 ACETIC ACID ASSUME 70%	15	3-A	15
				30-D	
	24	POUR IN NUOSEPT 95 & STIR 5 MIN.	160	195-B,D	160
	25	WHEN SCHEDULE, POUR IN LOT		YW-731	
		NOTE: ADD AS VOLUME PERMITS DURING HOMOG			
	26	STOP AGITATOR			

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COMTYP JOB NAME = 46YW731PMJ.PAGE.03 DATE PRINTED: 6/11/82

EQUIPMENT		PAGE 03 OF 04 CG 46 CODE YW-731-P (J)	USE LBS	N-CODE	ACCT LBS
CV 3	27	RUN ALM THRU HOMOG AT 4800-5200 PSI INTO V-215 NOTE: (1) COLLECT MATERIAL HOMOG BELOW 4800 PSI AND RETURN TO ALM (2) DO NOT ALLOW HOMOG TEMP TO EXCEED 120 DEG F (3) IF HMOG PRESSURE AT UPR LIMIT (5200 PSI) & TEMP BORDERLINE, LOWER HOMOG PRESSURE + OR - 100 PSI. TEMPER SHOULD DROP 3 TO 4 DEG F PER 100 PSI CUT IN PRESSURE. DO NOT GO LOWER THAN 4800 PSI (LOWER LIMIT) (4) IF TEMP BECOMES EXCESSIVE, STOP HOMOG & ADVISE SUPV'R. THIS CONDITION INDICATES FOREIGN MATERIAL HUNG UP BETWEEN BALLS & SEATS CAUSING SLURRY TO RECIRCULATE WITHIN HOMOGR.			
	28	DURING S27 HOMOG, RECORD HOMOG DISCHARGE TEMP EVERY 10 MIN TIME START 10:40 P.M. — INTERVAL MIN 0 — DEG F 94 10 — 96 20 — 98 30 — 99 40 — 99 50 — 99 70 — 99 80 — 99 2:05 P.M. SHUT DOWN HMG. — 90 100 110 120			
	29	RINSE ALM WITH 150 # WATER CALCULATED IN S4 THRU HOMOGENIZER AT 2000-5000 PSI			
	30	DRAIN LINES FROM HOMOG TO CV INTO DRUM AND POUR INTO CV			
	31	ADD AF-60 ANTIFOAM & STIR 30 MIN.	4 OZS	816-A	1
	32	RECORD: PH 10.1 (10.0-12.0)			
	33	IF NECESSARY, ADJUST TO PH 10.0-12.0 NOTE: DISSOLVE 1# N-3-A SODIUM CARBONATE IN 5# WATER. RCRD PH ___ ACETIC ACID ASSUME 70%	_____ _____	3-A 30-D	_____ _____
	34	REMOVE DISCHARGE LINE & SCREEN			
	35	WHILE DISCHARGING HALF OF A 6 GAL. KIT THRU THE BOTTOM OUTLET, SET FLOW TO ENABLE FILLING A JAR (REFER TO PROCEDURE M0012). FILL 1-16 OUNCE JAR. DELIVER TO CTL FOR COLOR. RECORD: S-48 & SHUT OFF AGITATOR, LIGHTS AND CLOSE MANHOLE COVER.			
HOMOG 4	36	CLEAN HOMOGENIZER PER STANDARD PRACTICE	25	3-A	25
CV 5	37	ADD 432 # WATER AS REQUIRED TO CV NOTE: IF TEST IS SATSFCTRY, OMIT S'S 37-40			
	38	START AGITATOR & STIR 20 MIN OR LONGER TO UNIFORMITY.			

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EQUIPMENT		PAGE 04 OF 04 CG 46 CODE YW-731-P (J)	USE LBS	N-CODE	ACCT LBS
	39	FILL 1-16 OUNCE JAR AS PER S-34 & DELIVER TO CTL FOR COLOR. RECORD: S-48.			
	40	SHUT OFF AGITATOR UNTIL TEST IS AVAILABLE			
	41	WHEN TEST SATISFACTORY, START AGITATOR, STIR 20 MIN OR LONGER			
	42	CHECK PAKOUT SCALE ACCURACY: 50# _____ 500#_____			
	43	INSTALL PACKOUT LINE & SCREEN (MAKE SURE IT'S CLEAN) AFTER DISCHARGING +/-25 GAL, FILL 2-16 OZ. JARS FROM PACKOUT LINE & RUN SCREEN TEST AS PER PROCEDURE M0026 WITH 1 JAR. IF NOT OK, NOTIFY SUPERVISOR.			
	44	IF SCREEN TEST OK, DELIVER 1-16 OZ JAR TO CTL FOR SCREEN TEST. RECORD TIME:_____ NOTE: OPERATOR SHOULD WAIT FOR RESULTS.			
	45	IF SCREEN TEST IS OK, IMMEDIATELY BEGIN DISCHARGING THRU PAKOUT SCREEN AS FOLLOWS: RECORD: S-48			
		PKG N-CODE / SCHEDULE PK / TOTAL NET PK			
		#036 (AquiStack) 2500 (1) 2500			
		#001 N-1924 11 (11) 2530			
		#06 N-1775 3 (3) 1350			
	46	#037 N-1701 25 (25) 1700 AFTER DISCHARGING +/- 80% OF BATCH, FILL COMPLETELY 2-16 OZ. JARS FROM PAKOUT LINE, MARK "FINAL", DELIVR TO CTL FOR COLOR TEST WHEN PAKOUT COMPLETE, RECORD: S48			
	47	STOP AGITATOR			
	48	RECORD: RESULTS TIME SUPV			
		S34 SMPL TO CTL-CLR _____ _____ _____			
		S38 RESMPL TO CTL-CLR _____ _____ _____			
		S43 AREA SCREEN TEST _____ _____ _____			
		S44 SMPL CTL SCRN TEST _____ _____ _____			
		S46 FNL SMP CTL-CLR _____ _____ _____			
		START 1000hr / FINISH 2100hr / OPTR 37			
		_____ / _____ / _____			

PAK'S 27 #'s.

Note: If batch o/c, take 1 qt greenhouse sample when packing out per above request

23 11 230 135 1 4 12 77 1350

24 52 1200 23 0 2530