MAKING INSTRUCTIONS: BATCH UNIT

S.V. 4 Rem 3/30 C.V. ~~2 H~~ 320 D.V.

CG 46 CODE YW-822-P PKG 05 TIME 7 AM

LOT # → ~~450~~ MA 85 ~~LC 82~~ 35067-1 PUNCHED & CHECKED

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

APR 1 1980

TAB PUNCH FOLLOWING CONSUMPTIONS:

PROCESSES	APPROVED BY
( ) YW-822-P (8)	BBK 4-28-78
	DCG 5-5-78
TYPED BY	
NSA 5-8-78	

CG	CODE	LOT	PQ	DISP	LBS	TAB: %	DO NOT PUNCH PULP WGT.
46	YC-13-A	~~33835~~	93		1448		
46	YC-13-A	33835	98		47		
46	YC-13-A	34749	93		1465		
46	YW-822-P	30770-1	93		450		
~~46~~	~~YW-822-P~~	~~34101-1~~	~~93~~		~~30~~		
~~46~~	~~Yw-822-P~~	79221-1	98		200/120		
~~46~~	~~YW-822-P~~	30220-1	93		2000		

TOTAL WGT. ~~8468~~ 8052

10,062 / 11,052 x100 = 91.0% yield. 11,052

NON-BLEEDING

EQUIPMENT		NAME: DALAMAR® YELLOW R	USE LBS	N CODE	ACCT LBS
Misc. 1		NOTE: MAKING SUPV - 1 hour before taking S 29 sample, advise CTL Supv of status			2980
	1	Obtain as listed above	6264	YC-13-A	[redacted]
	2	Calc for S 23			
		[redacted] # - 6264 # YC-13 pulp wgt (S 5) = 148 # water			
		6418			
ALM 2	3	Plug ALM # 2 outlet & Dump in ingredients LT 30770-1	450	YW-822-P	450
	4	Do not start agitator			
	5	Pour in Assume 50%	8	7-D	4
	6	Dump in one drum of YC-13-A from S 1			
	7	Pour in	180	979-A	180
	8	Start agitator & stir minimum time to fluidize. Note: Over-stirring will cause excessive foam			
	9	Dump in rest of YC-13 (S 1) in 2 drum increments. Stir minimum time to fluidize between each increment. Scrape drums			
	10	Start agitator			
	11	Pour in	815	979-A	815
	12	SCRAPE grating, [redacted]			
	13	Stir 60 min Record: Start 7:30 PM			
	14	Pour in and stir 5 min	2 oz.	816-A	0
	15	Stop agitator			
	16	Record: pH 11.1 (10.0-12.0)			
	17	If necessary, adj to pH 10.0-12.0 & Record: pH		3-A	
	18	Pour in and stir 5 min	90	195-B	90
	19	Stop agitator			
	20	When scheduled dump in Lot		YW-822-	236
		NOTE: If ALM is full, add as vol permits during homog 79221-1	120		
CV 3	21	Run ALM thru homog at 4800-5200 psi into V- 214			
		NOTE: Collect material homog below 4800 psi and return to ALM			

emw
080577

EQUIPMENT		PAGE 2 CG 46 CODE YW-822-P (B) EST. WGT. _____ LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 3	22	While homogenizing, at 5-10 min intervals, jog agitator on ALM to maintain color suspension			
	23	Rinse ALM with 149 # water calculated in S 2 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 11.6 (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 4	32	Clean Homog per SOP	25	3-A	25
	32-A	Add→YW-822-P-LOT- 30770-1 →	2000	YW-822	2000
CV 5	33	Add 1000 # 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
1700	± ~~204~~ 276	2.51
		1- Stump 22 #
	GRAND TOTAL NET PACK	10,062

NOTE: After discharging ± 25G, 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	OK	1:P.M.	2 J.M.
S40 Samples during packout			
S40 Delivered to CTL			

START	FINISH	OPERATOR
	3:00 PM	196
3:00 PM	11:00 PM	105
11:00 PM	1:00 AM	38

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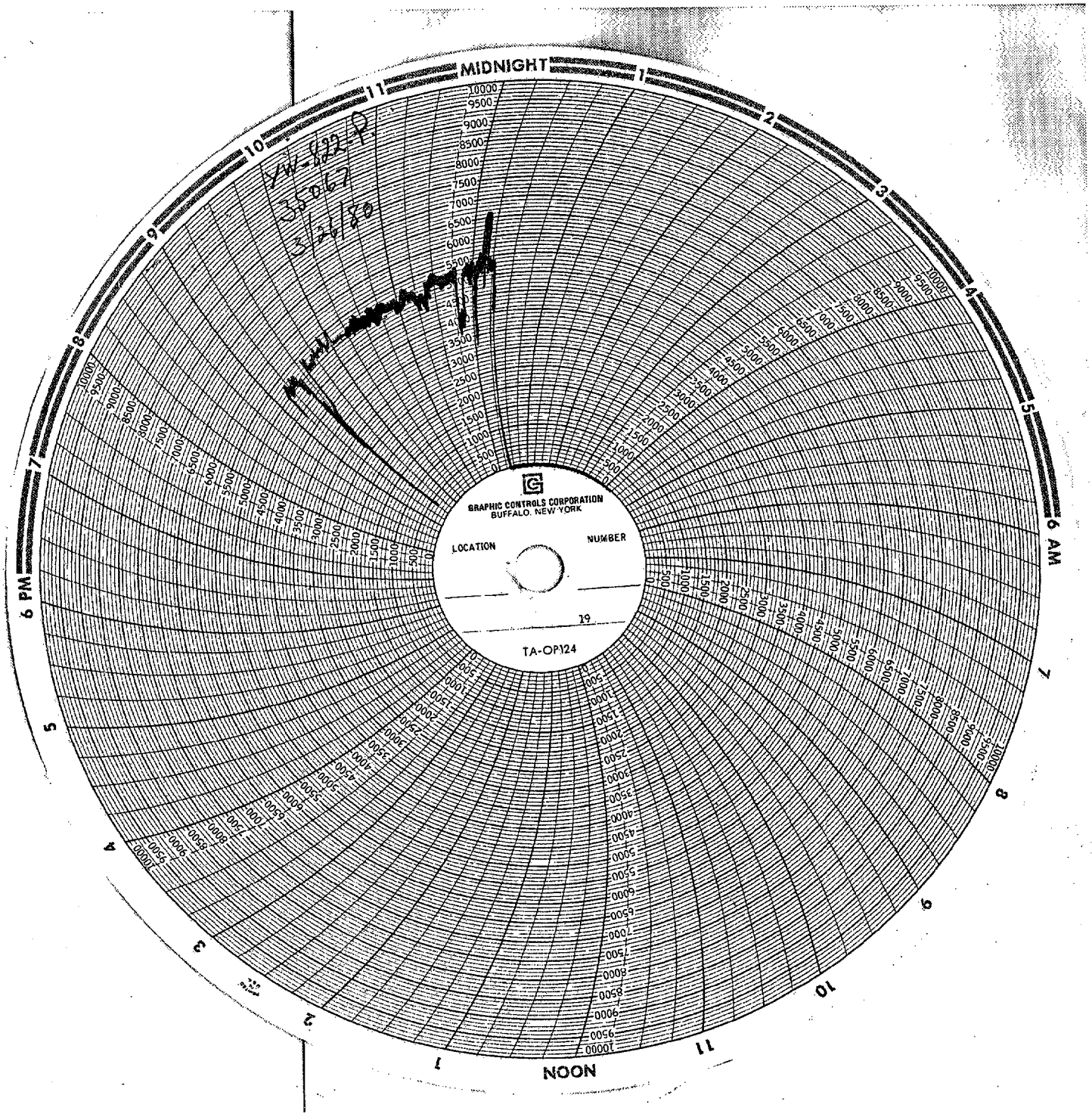

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