FEB 14 1980

MAKING INSTRUCTIONS: BATCH UNIT

V. C.V. (7/8) D.V.

PROCESSES	APPROVED BY
( ) YW-731-P ( )	BBK 8-17-77
( ) ( )	DCG 8-22-77
( ) ( )	
( ) ( )	
TYPED BY	
NSA 8-25-77	

CG 46 CODE YW-731-P PKG. 06 TIME 3 P M

→ LOT FEC15 34438-1

TAB: PUNCH TOTAL WGT AS EST WGT 5362 ~~5000~~ Lbs

EST WGT (DO NOT PUNCH)

(REQ.#

TAB: PUNCH FOLLOWING CONSUMPTIONS PUNCHED & CHECKED

TAB: DO NOT PUNCH

CG	CODE	LOT	PQ	DISP	LBS	FEB 26 1980	%	PULP WGT
46	YC-5-A	33861	93		428			
46	YC-5-A	33861	98		53			
46	YC-5-A	33960	93		1433			
46	YW-731-P	26888-1	98		450			
46	YW-731-P							
		TOTAL WGT			~~5000~~ 8726			

YW-231 26840-1 → 900 #

8626 #

776

9402

AND 7% WATER = 776

9362 / 9402 × 100 = 99.57% YIELD

BAD SPECIFIC GRAVITY

BLEEDING

EQUIPMENT		NAME: DALAMAR® YELLOW	USE LBS.	N CODE	ACCT. LBS.
Misc. 1		Note: Making Supv - 1 hour before taking S 28 sample, advise CTL Supv of status			1912
	1	Obtain as listed above		YC-5-A	~~1000~~
	2	Obtain & Mix to uniformity for S 8 & S 11		896-B	
	3	Calculate for S 22			
		~~6000#~~ 6376# YC-5-A Pulp Wgt (S 1) = 150 # water			
		~~6376#~~			
ALM 2	4	Plug ALM # 2 outlet & Add 1 dr @ 450 Lbs Lot 26888-1	450	YW-731-P	450
	5	Add & stir 5 minutes to dissolve	10	3-A	20
	6	Stop agitator			
	7	Dump in one drum YC-5-A from S 1	200	896-B	200
	8	Pour in			
	9	Start agitator & stir minimum time to fluidize. Note: Over-stirring will cause excessive foam			
	10	Dump in rest of YC-5 (S 1) in 2-drum increments. Stir minimum time to fluidize between each increment. Scrape drums			
	11	Pour in & stir 5 minutes	466	896-B	466
	12	Sift in using sifter in 2-4 minutes	8	925-A	8
	13	Scrape grating sid~~e~~s ~~3 times, brush~~ ~~50# water~~ Record: Start 9.20 pH			
	14	Stir 60 minutes.	2 ozs	816-A	0
	15	Add & stir 5 min		3-A	10
	16	Stop agitator & Record: pH 9.7 (10.0-12.0)		30-B	
	17	If necessary, adjust to pH 10.0-12.0 (note: dissolve 1# N-3-A (in 5# water) Record: pH 10.8 Assume 75%	85	195-B	85
→	18	Pour in & stir 5 min		YW-731	
	19	When scheduled, Pour in LOT Note: Add as volume permits during homog			
	20	Stop agitator			

EQUIPMENT		PAGE 2 CG 46 CODE YW-731-P (J) EST. WGT. 7626 LBS.	USE LBS.	N CODE	ACCT. LBS.
CV 3	21	Run ALM thru homogenizer at 4800-5200 psi into V-214			
		Note: Return material homogenized below 4800 psi to ALM			
	22	Rinse ALM with 150# water calculated in S 3 thru homogenizer at 2000-5000 PSI			
	23	Drain lines from homog to CV into drum & pour into CV			
	24	Add & stir 30 minutes	4 ozs	816-A	1
	25	Record: pH 10.0 (~~7.0-7.5~~)(10.0-12.0)			
	26	If necessary, adjust to pH 10.0-12.0 (Note: Dissolve 1# N-3-A in 5# water) Record: pH _____ Assume 75%	_____	3-A 30-D	_____
	27	Discharge ±25 G thru packout line & pour into CV			
	28	Fill 1-16 ounce jar from packout line & deliver to CTL for color Record S 41			
	29	Fill 1-16 ounce jar from packout line & run 100 mesh screen test per SOP. Record: Results S 41			
	30	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	31	Clean Homogenizer per standard practice	25	3-A	25
CV 7	32	Add 76 # water as required to CV			
		Note: If test is satisfactory, omit S's 32-35			
	33	Start agitator & stir 20 min. or longer to uniformity			
	34	Fill 1-16 ounce jar from packout line & deliver to CTL for color Record S 41			
	35	Shut off agitator until test is available			
	36	When test is satisfactory, start agitator			
	37	Stir 5 min or longer			
	38	Check packout scale accuracy: 50# _____ 500# _____			
	39	Discharge thru packout screen as follows:			

PACKAGE N-CODE	SCHEDULED PACK	TOTAL NET PACK
1775	10	4500
1924	~~+ 21~~ 10	4830 32
	GRAND TOTAL NET PACK	9362

Note: After discharging ±25 G, fill 2-16 ounce jars from packout line, mark "FINAL." Deliver to CTL when packout is completed. Record S 41

40 Stop agitator

41 Record:

	Results	Time	Supv
S 28 Color Sample to CTL	_____	6:45 A.M.	[illegible]
S 29 Screen Test	_____	_____	_____
S 34 Resample to CTL	_____	_____	_____
S 39 Sample during packout	_____	_____	_____
S 39 Deliver to CTL	_____	_____	[illegible]

START	FINISH	OPTR
11:00 P.M.	6:30 A.M.	[illegible]

DUP050293247

REQUEST FOR MATERIAL

REQUEST NO. 3246

DATE 2/14/80

DELIVER TO Making Area BLDG. 6 FLOOR 3RD BY 2/15/80, 3P M.

FOR CODE YW731P LOT 34438-1

WRITTEN BY C. Hill Production Control

Whse. Loc.	DELIVERY DATA							SUPERVISOR*		CONSUMPTION DATA						
	Code	Pkg./ Qual.	Lot	No. Pkg.	Net	Total Dry Weight	Lbs. Dry Received	Delivering Area	Receiving Area	Lbs. Pulp/Paste	Dry Content	Lbs. Dry	Consume Lbs./Hr.	Lbs. Consumed	Balance Remaining	Consuming Supv.
P-1	YC-5-A	93	33861	5	325					1625	26.34	428				
"	"	98	"	1	±201					201	26.34	53				
P1	YC-5-A	93	33960	14	325					4550	31.5	1433				
A-18	YW731P	93	26828-1	1	450					450						

PICK UP AND RETURN TO STORAGE THE FOLLOWING:

*Each Supervisor must explain weight differences on reverse side.

LOCATED IN _____ BLDG., _____ FLOOR.

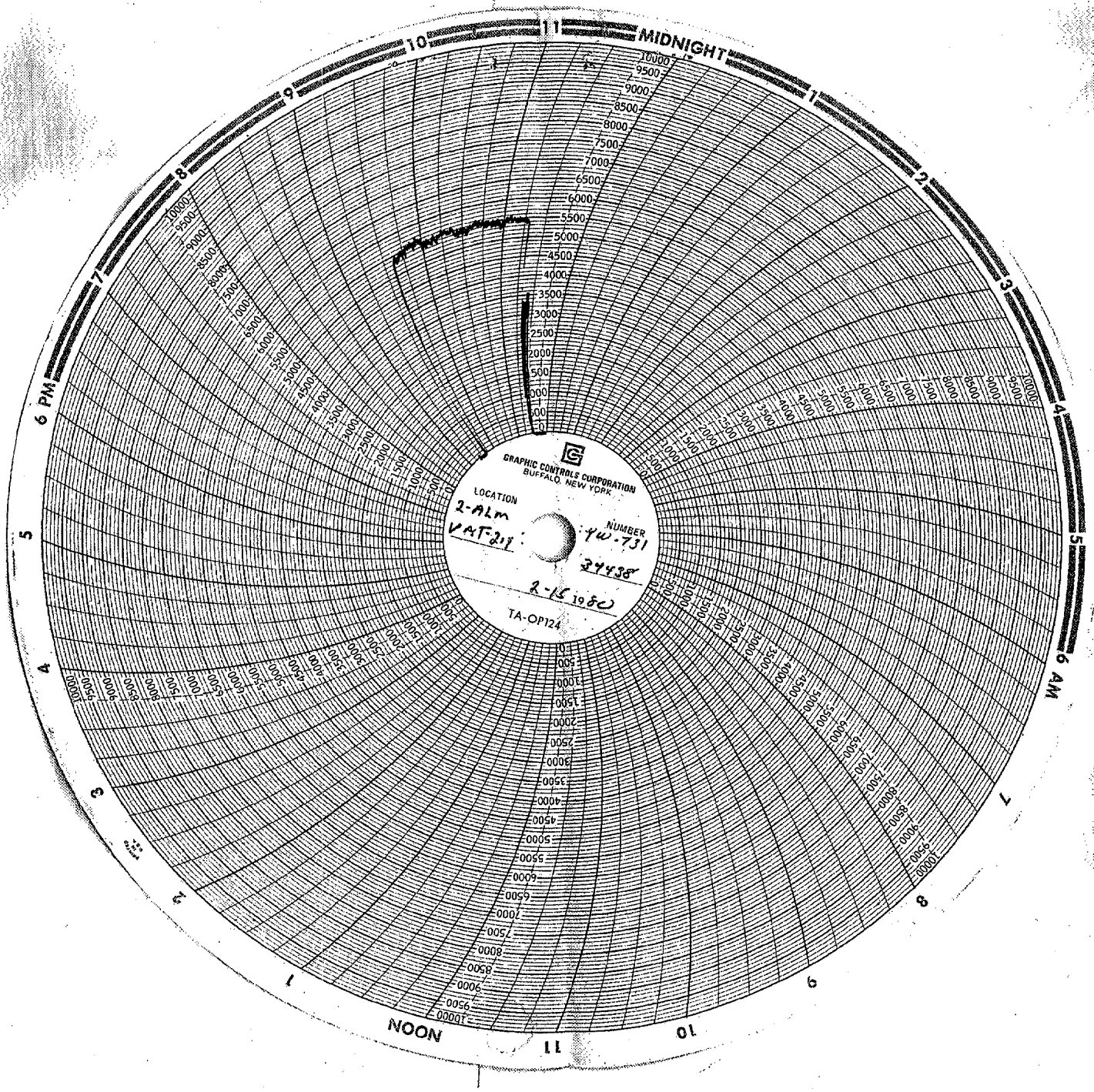
Code	Lot	Net	No. of Packages	Total Net Weight	Whse. Loc.

PRODUCTION CONTROL COPY – WHITE
OPERATING FILE COPY – YELLOW
WAREHOUSE FILE COPY – GREEN
RAW MATERIAL FILE COPY – BLUE
PRODUCTION CONTROL FILE COPY – PINK

PLACED IN LOCATION BY: OPER. # _____ DATE _____ SUPVR. _____

N33087.01

DUP05029248



DUP050293249

N33087.02

DUP050293250