CG [illegible] CODE YM-811-P PKG. 3

LOT MAKE 37832-1

TAB: PUNCH TOTAL WGT AS EST WGT
EST WGT. (DO NOT PUNCH)
(REQ. # 3607)
TAB PUNCH FOLLOWING CONSUMPTIONS:

TIME 28 M
PLANNED DUE

5339
5304 LBS / 7 400

| PROCESSES | APPROVED BY |
|---|---|
| 1.) YM-811-P 81 | BBK 8-17-77 |
| 2.) ( ) | DCG 8-29-77 |
| ( ) ( ) | |
| TYPED BY | |
| NSA 8-29-77 | |

NOV 18 1980

| CG | CODE | LOT | PQ | DISP | LBS. | TAB: DO NOT PUNCH % | PULP WGT |
|---|---|---|---|---|---|---|---|
| 46 | YC-11-A | 37234 | 93 | | 1232 | | |
| 46 | YC-11-A | 37606 | 93 | | 1056 | | |
| 46 | YC-11-A | 37524 | 98 | | 33 | | |
| 46 | YM-811-PYC-11 | 37524 | 98 | | 118 | | |
| 46 | YM-811-P | Returned Chk | | | 337 | | |
| | YC-11-A | 35333A | 98 | | 60 | | |
| | YC-11-A | 37606 | 98 | | 36 | | |
| | | TOTAL WGT. | | | 2966 3234 | | |

Scale V-214 DONE

8192 × 100 = 99.6%
8226

**CLEAN UP**

**[illegible] ONLY**

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 ____ | | YM-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 | | | |

N35160

| EQUIPMENT | | PAGE 2 CO 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 | | | |

DUP050107956

| 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 2:15 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 66 0 | | | |
| | | 68 10 | | | |
| | | 70 20 | | | |
| | | 71 30 | | | |
| | | 74 40 | | | |
| | | 76 50 | | | |
| | | 84 60 | | | |
| | 17 | Pour in and stir 5 min | 2 oz. | 816-A | 0 |
| | 18 | Stop agitator RECORD: TEMP 85 °F | | | |
| | 19 | Record: pH 11.8 (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 Returned Color | 237 | YW-811- | 237 |
| | | NOTE: If ALM is full, add as vol permits during homog | ✓ ✓ | | ✓ |
| 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 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 | 0 | | 4:45 PM | 70 | 110 |
| 3:45 PM | 10 | 102 | 4:55 | 80 | 110 |
| 3:55 | 20 | 110 | 5:05 | 90 | 110 |
| 4:05 | 30 | 110 | 5:15 | 100 | 110 |
| 4:15 | 40 | 110 | 5:25 | 110 | 110 |
| 4:25 | 50 | 110 | 5:35 | 120 | 110 |
| 4:35 | 60 | 110 | 5:45 | 130 | |

| | | | | | |
|---|---|---|---|---|---|
| | 26 | While homogenizing, at 20 min intervals, jog agitator on ALM to maintain color suspension | | | |
| | 27 | Rinse ALM with 1611# water calculated in S 14 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 11.4 (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 S 46 | | | |

DUP050107957

| ULPMENT | | 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 |
|---|---|---|
| 05 | 204 | 8160 |
| | | 37 |
| | GRAND TOTAL NET PACK | 8197 |

NOTE: After discharging ± 25G, fill 2-16 ounce jars from packout line, mark "FINAL." Deliver to CTL when packout is completed. Record in S46

45 Stop agitator

46 Record:

| | Results | Time | Supv |
|---|---|---|---|
| S34 Screen tested | OK | 2 pm | |
| S33 Color sample to CTL | OK | | |
| S39 Resample to CTL | — | | |
| S44 Samples during packout | TAKEN | 4 Am | |
| S44 Delivered to CTL | | | |

| START | FINISH | OPERATOR |
|---|---|---|
| 7:Am | 3:Pm | 166 |
| 3:Pm | 7:Pm | 88 |
| 1:30Am | 9Am | 114 |

DUP050107958

MAKING INSTRUCTIONS: BATCH UNIT

S.V. C.V. D.V.

CO _____ CODE _____ PKG. _____

EST. WGT. _____ LBS.

STD. HRS. _____ TIME _____ M

| PROCESSES | | APPROVED BY |
|---|---|---|
| ( ) | ( ) | |
| ( ) | ( ) | |
| ( ) | ( ) | |
| ( ) | ( ) | |
| TYPED BY | | |
| | | |

NON-BLEEDING

| EQUIPMENT | | NAME: | USE LBS. | N CODE | ACCT. LBS. |
|---|---|---|---|---|---|
| | | | | | |

DUP050107959

WAREHOUSE REQUEST FORM

REQUEST NO. 3607
11/11/80

DELIVER TO Making Area BY 11/12/80 7 AM/~~PM~~

FOR: CG 46 CODE YW811P LOT 378321 SCHEDULED 11/10/80

| WHSE LOCATN | CG | CODE | PQ | LOT | DRY WEIGHT | DRY CONT | NO. PKG | PKG WGT | TOTAL WEIGHT | ACTUAL WEIGHT |
|---|---|---|---|---|---|---|---|---|---|---|
| P-4 | 46 | YC011A | 93 | 37234 | ~~1200~~ 1227 | 51.41 | 8 | 325 | ~~2534~~ 2600 | 2400 |
| P-7 | 46 | YC011A | 93 | 37606 | ~~1089~~ 1956 | 54.18 | 6 | 325 | ~~2010~~ 1950 | 1950 |
| 35P-3 | 46 | YC011A | 98 | 37524 | 53 | 36.40 | 1 | 172 | 146 | 146 |
| 35-P-2 | 46 | YC011A | 98 | 35353A | 60 | 29.80 | 1 | 202 | 201 | 201 |
| P-7 | 46 | YC011A | 98 | 37606 | 26 | 54.18 | 1 | 48 | 48 | 48 |
| | | YC-11-A | | 37524 | 118 | 36.40 | 4 | 325 | 325 | 325 |
| | | YW811 | 98 | — | 237 | Returned Color | | 237 | | 5220 |

2400
1950

PICK UP AND RETURN TO STORAGE:

| LOCATN | CG | CODE | PQ | LOT | DRY WEIGHT | DRY CONT | NO. PKG | PKG WGT | TOTAL WEIGHT |
|---|---|---|---|---|---|---|---|---|---|
| _____ | __ | _____ | __ | _____ | _____ | ____ | ____ | ____ | _____ |
| _____ | __ | _____ | __ | _____ | _____ | ____ | ____ | ____ | _____ |

4572

1889

EXPLANATION FOR SHORTAGE/OVERAGE:

_____

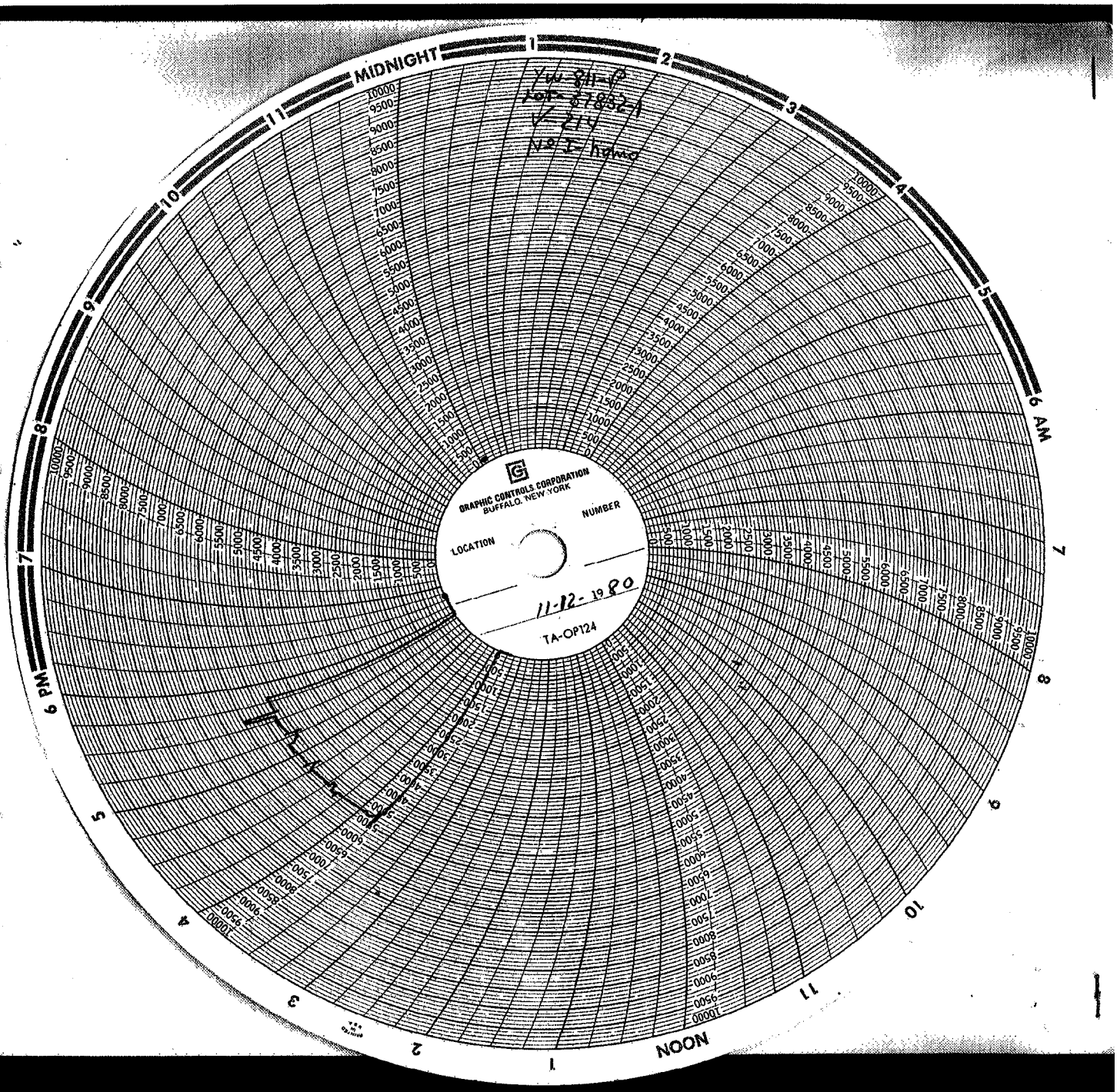
_____

_____

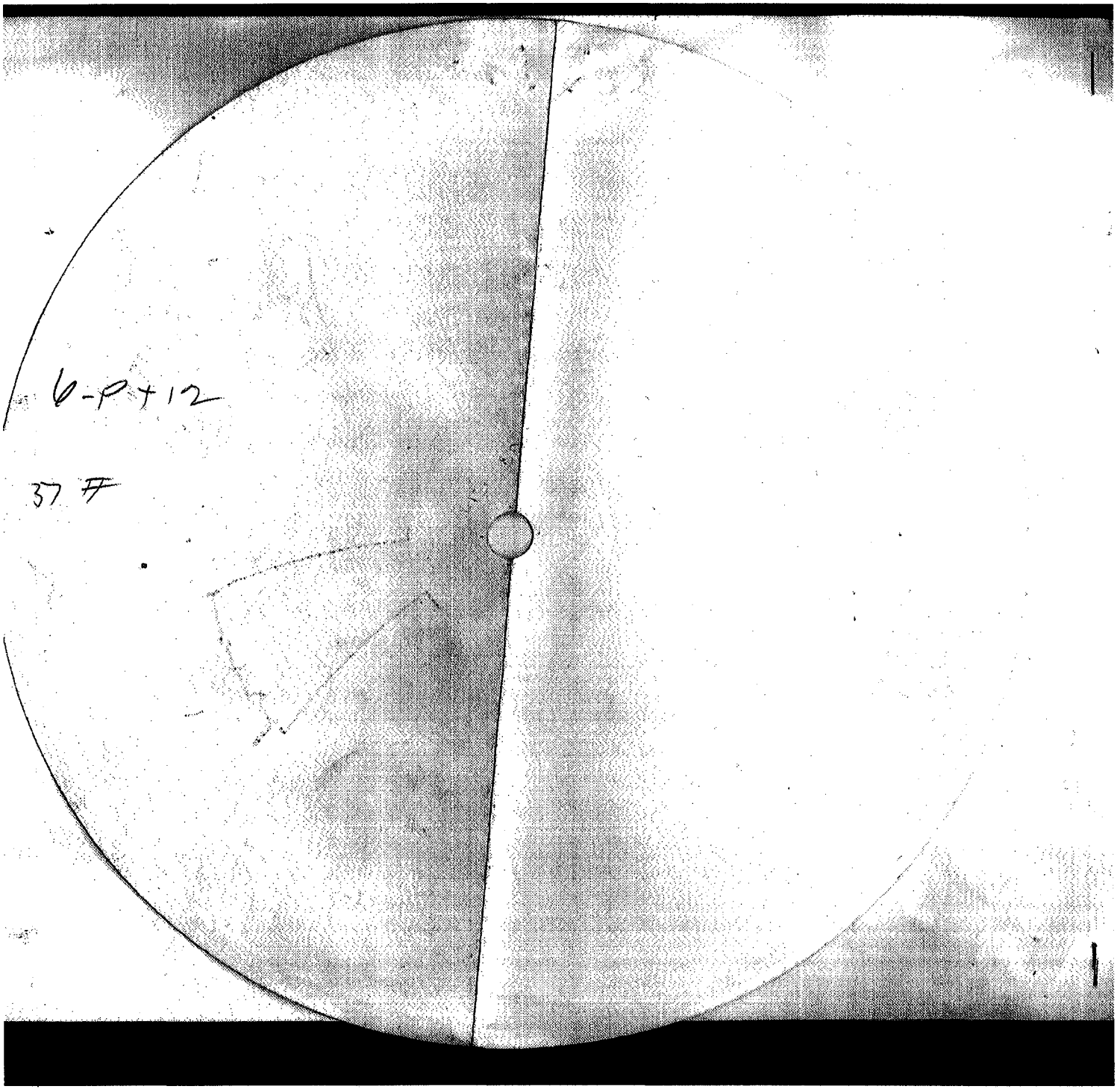
SIGNED _____ DATE __/__/__

COPY-1 PROD. CONTROL
COPY-2 MANUFACTURING
COPY-3 WAREHOUSE
COPY-4 RAW MATERIAL

DUP050107960




DUP050107961


6-P+12
37 F

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. 7964

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 | | | |
| | 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 | | | |
| | 2 Obtain as listed above | | | 2423 |
| | 3 Obtain & Mix to uniformity for S9 & S13 | 4981 | YC-11-A | 2480 |
| | 4 Calculate for S27 | | 896-B | |
| | 4981 # YC-11-A Pulp Wgt (S2) = 900 # water | | | |
| | 5 CLOSE ALM # 2 outlet & run in 2250# WATER | | | |
| ALM 2 | 6 DO NOT START AGITATOR | | | |
| | 7 POUR IN ASSUME 50% | 8 | 7-D | 4 |
| | 8 POUR 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 76 °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 BEATING, SIDES & MIXER BASKET WITH 150# WATER | | | |

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